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AMENDMENT 1
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**Welding consumables — Tubular
cored electrodes and rods for gas
shielded and non-gas shielded metal
arc welding of stainless and heat-
resisting steels — Classification**

AMENDMENT 1

iTeh STANDARD PREVIEW

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*Produits consommables pour le soudage — Fils et baguettes fourrés
pour le soudage à l'arc avec ou sans protection gazeuse des aciers
inoxydables et des aciers résistant aux températures élevées —
Classification*

<https://standards.iteh.ai/catalog/standards/sist/f3245ea7-2570-4f3b-8d05-d10ae751d750/iso-17633-2017-amd-1-2021>
AMENDEMENT 1



Reference number
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[ISO 17633:2017/Amd 1:2021](https://standards.iteh.ai/catalog/standards/sist/f3245ea7-2570-4f3b-8d05-d10ae751f956/iso-17633-2017-amd-1-2021)
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This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 3, *Welding consumables*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding and allied processes*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

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Table 1A

Replace the rows for 16 8 2, 19 9 H and 25 4 to update Mn and Si contents as follows:

Alloy designation according to nominal composition	Chemical composition, % (by mass)											
	C	Mn	Si	P	S	Cr	Ni	Mo	Nb+Ta	Cu	N	Others
16 8 2	0,10	1,0 to 2,5	1,0	0,03	0,02	14,5 to 17,5	7,5 to 9,5	1,0 to 2,5	—	0,5	—	Cr+Mo: 18,5
19 9 H	0,04 to 0,08	1,0 to 2,5	1,0	0,03	0,02	18,0 to 21,0	9,0 to 11,0	0,3	—	0,5	—	—
25 4	0,15	1,0 to 2,5	2,0	0,03	0,02	24,0 to 27,0	4,0 to 6,0	0,3	—	0,5	—	—

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