



NSAI
Standards

Irish Standard
I.S. EN ISO 26304:2018

Welding consumables - Solid wire electrodes, tubular cored electrodes and electrode-flux combinations for submerged arc welding of high strength steels - Classification (ISO 26304:2017)

I.S. EN ISO 26304:2018

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National Foreword

I.S. EN ISO 26304:2018 is the adopted Irish version of the European Document EN ISO 26304:2018, Welding consumables - Solid wire electrodes, tubular cored electrodes and electrode-flux combinations for submerged arc welding of high strength steels - Classification (ISO 26304:2017)

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EUROPEAN STANDARD

EN ISO 26304

NORME EUROPÉENNE

EUROPÄISCHE NORM

February 2018

ICS 25.160.20

Supersedes EN ISO 26304:2011

English Version

**Welding consumables - Solid wire electrodes, tubular
cored electrodes and electrode-flux combinations for
submerged arc welding of high strength steels -
Classification (ISO 26304:2017)**

Produits consommables pour le soudage - Fils-
électrodes pleins, fils-électrodes fourrés et couples
électrodes-flux pour le soudage à l'arc sous flux des
aciers à haute résistance - Classification (ISO
26304:2017)

Schweißzusätze - Massivdrahtelektroden,
Fülldrahtelektroden und Draht-Pulver-Kombinationen
zum Unterpulverschweißen von hochfesten Stählen -
Einteilung (ISO 26304:2017)

This European Standard was approved by CEN on 9 January 2018.

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COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

EN ISO 26304:2018 (E)

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European foreword

This document (EN ISO 26304:2018) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with Technical Committee CEN/TC 121 "Welding and allied processes", the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by August 2018, and conflicting national standards shall be withdrawn at the latest by August 2018.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 26304:2011.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

Endorsement notice

The text of ISO 26304:2017 has been approved by CEN as EN ISO 26304:2018 without any modification.

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INTERNATIONAL STANDARD

ISO
26304

Third edition
2017-11

Welding consumables — Solid wire electrodes, tubular cored electrodes and electrode-flux combinations for submerged arc welding of high strength steels — Classification

Produits consommables pour le soudage — Fils-électrodes pleins, fils-électrodes fourrés et couples électrodes-flux pour le soudage à l'arc sous flux des aciers à haute résistance — Classification



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ISO 26304:2017(E)

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation on the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 3, *Welding consumables*.

This third edition cancels and replaces the second edition (ISO 26304:2011), which has been technically revised. The main changes compared to the previous edition are as follows:

- the chemical compositions of a number of solid wire electrodes and all-weld metal from tubular cored electrode-flux combinations have been changed;
- H2 and H4 are now options for hydrogen content;
- an example of a Z designation has been added to [Clause 11](#).

Requests for official interpretations of any aspect of this document should be directed to the Secretariat of ISO/TC 44/SC 3 via your national standards body. A complete listing of these bodies can be found at www.iso.org.

Introduction

This document recognizes that there are two somewhat different approaches in the global market to classifying a given solid wire electrode, tubular cored electrode, and electrode-flux combination, and allows for either or both to be used, to suit a particular market need. Application of either type of classification designation (or of both where suitable) identifies a product as classified in accordance with this document. The classification in accordance with system A was originally based on EN 14295. The classification in accordance with system B is mainly based on standards used around the Pacific Rim. Future revisions aim to merge the two approaches into a single classification system.

This document provides a classification for the designation of solid wire electrodes in terms of their chemical composition, tubular cored electrodes in terms of the deposit composition obtained with a particular submerged arc flux, and, where required, electrode-flux combinations in terms of the yield strength, tensile strength, elongation, and impact properties of the all-weld metal deposit. The ratio of yield to tensile strength of weld metal is generally higher than that of parent material. Users should note that matching weld metal yield strength to parent metal yield strength does not necessarily ensure that the weld metal tensile strength matches that of the parent material. Thus, where the application requires matching tensile strength, selection of the consumable should be made by reference to column 3 of Table 1A or Table 1B, as appropriate.

Although combinations of electrodes and fluxes supplied by individual companies can have the same classification, it is possible that the combination of an electrode with a flux from one manufacturer and the same electrode with the flux from another manufacturer — both fluxes having the same classification — might not be interchangeable unless verified in accordance with this document. Two tubular cored wires of the same classification can likewise produce different results with the same flux.

The mechanical properties of the all-weld metal test specimens used to classify the electrode-flux combinations vary from those obtained in production joints because of differences in welding procedures such as electrode size, width of weave, welding position, and material composition.

Welding consumables — Solid wire electrodes, tubular cored electrodes and electrode-flux combinations for submerged arc welding of high strength steels — Classification

1 Scope

This document specifies requirements for classification of solid wire electrodes, tubular cored electrodes, and electrode-flux combinations (the all-weld metal deposits) in the as-welded condition and in the post-weld heat-treated condition for submerged arc welding of high strength steels with a minimum yield strength greater than 500 MPa or a minimum tensile strength greater than 570 MPa. One flux can be tested and classified with different electrodes. One electrode can be tested and classified with different fluxes. The solid wire electrode is also classified separately based on its chemical composition.

This document is a combined specification providing for classification utilizing a system based on the yield strength and average impact energy of 47 J for the all-weld metal, or utilizing a system based on the tensile strength and average impact energy of 27 J for the all-weld metal.

- a) Clauses, subclauses and tables which carry the suffix letter “A” are applicable only to solid wire electrodes, tubular cored electrodes and the all-weld metal deposits classified to the system based on the yield strength and the average impact energy of 47 J for the all-weld metal obtained with electrode-flux combinations in accordance with this document.
- b) Clauses, subclauses and tables which carry the suffix letter “B” are applicable only to solid wire electrodes, tubular cored electrodes and the all-weld metal deposits classified to the system based on the tensile strength and the average impact energy of 27 J for the all-weld metal obtained with electrode-flux combinations in accordance with this document.
- c) Clauses, subclauses and tables which do not have either the suffix letter “A” or the suffix letter “B” are applicable to all solid wire electrodes, tubular cored electrodes and electrode-flux combinations classified in accordance with this document.

For comparison purposes, some tables include requirements for electrodes classified in accordance with both systems, placing individual electrodes from the two systems, which are similar in composition and properties, on adjacent lines in the particular table. In a particular line of the table that is mandatory in one system, the symbol for the similar electrode from the other system is indicated in parentheses. By appropriate restriction of the formulation of a particular electrode, it is often, but not always, possible to produce an electrode that can be classified in both systems, in which case the electrode, or its packaging, can be marked with the classification in either or both systems.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 544, *Welding consumables — Technical delivery conditions for filler materials and fluxes — Type of product, dimensions, tolerances and markings*

ISO 3690, *Welding and allied processes — Determination of hydrogen content in arc weld metal*

ISO 6847, *Welding consumables — Deposition of a weld metal pad for chemical analysis*

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