

**KEEVITUSMATERJALID. KEEVITUSTRAADID JA  
KEEVISMETALLID LEGEERIMATA JA  
PEENTERATERASTE KAARKEEVITUSEKS  
KAITSEGAASIS. LIIGITUS**

**Welding consumables - Wire electrodes and weld  
deposits for gas shielded metal arc welding of non alloy  
and fine grain steels - Classification (ISO 14341:2010)**

**EESTI STANDARDI EESSÕNA****NATIONAL FOREWORD**

See Eesti standard EVS-EN ISO 14341:2011 sisaldab Euroopa standardi EN ISO 14341:2011 ingliskeelset teksti.	This Estonian standard EVS-EN ISO 14341:2011 consists of the English text of the European standard EN ISO 14341:2011.
Standard on jõustunud sellekohase teate avaldamisega EVS Teatajas.	This standard has been endorsed with a notification published in the official bulletin of the Estonian Centre for Standardisation.
Euroopa standardimisorganisatsioonid on teinud Euroopa standardi rahvuslikele liikmetele kättesaadavaks 26.01.2011.	Date of Availability of the European standard is 26.01.2011.
Standard on kättesaadav Eesti Standardikeskusest.	The standard is available from the Estonian Centre for Standardisation.

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ICS 25.160.20

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English Version

**Welding consumables - Wire electrodes and weld deposits for  
gas shielded metal arc welding of non alloy and fine grain steels  
- Classification (ISO 14341:2010)**

Produits consommables pour le soudage - Fils-électrodes  
et métaux d'apport déposés en soudage à l'arc sous  
protection gazeuse des aciers non alliés et à grains fins -  
Classification (ISO 14341:2010)

Schweißzusätze - Drahtelektroden und Schweißgut zum  
Metall-Schutzgasschweißen von unlegierten Stählen und  
Feinkornstählen - Einteilung (ISO 14341:2010)

This European Standard was approved by CEN on 25 December 2010.

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EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

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## Foreword

The text of ISO 14341:2010 has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" of the International Organization for Standardization (ISO) and has been taken over as EN ISO 14341:2011 by Technical Committee CEN/TC 121 "Welding" 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 July 2011, and conflicting national standards shall be withdrawn at the latest by July 2011.

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

This document supersedes EN ISO 14341:2008.

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, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and the United Kingdom.

### Endorsement notice

The text of ISO 14341:2010 has been approved by CEN as a EN ISO 14341:2011 without any modification.

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## Introduction

This International Standard recognizes that there are two somewhat different approaches in the global market to classifying a given wire electrode, and allows for either or both to be used, to suit a particular market need. Application of either type of classification designation (or both where suitable) identifies a product as classified in accordance with this International Standard.

This International Standard provides a classification in order to designate wire electrodes in terms of their chemical composition and, where required, in terms of the yield strength, tensile strength and elongation of the all-weld metal. The ratio of yield strength to tensile strength of weld metal is generally higher than that of parent metal. 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. Therefore, where the application requires matching tensile strength, selection of the consumable should be made by reference to column 3 of Table 1A or 1B.

It should be noted that the mechanical properties of all-weld metal test specimens used to classify the electrodes 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 — Wire electrodes and weld deposits for gas shielded metal arc welding of non alloy and fine grain steels — Classification

## 1 Scope

This International Standard specifies requirements for classification of wire electrodes and weld deposits in the as-welded condition and in the post-weld heat-treated condition for gas shielded metal arc welding of non alloy and fine grain steels with a minimum yield strength of up to 500 MPa or a minimum tensile strength of up to 570 MPa. One wire electrode can be tested and classified with different shielding gases.

This International Standard constitutes a combined specification providing classification utilizing a system based upon the yield strength and the average impact energy of 47 J of all-weld metal, or utilizing a system based upon the tensile strength and the average impact energy of 27 J of all-weld metal.

- a) Clauses and tables which carry the suffix letter "A" are applicable only to wire electrodes classified to the system based upon the yield strength and the average impact energy of 47 J of all-weld metal in accordance with this International Standard.
- b) Clauses and tables which carry the suffix letter "B" are applicable only to wire electrodes classified to the system based upon the tensile strength and the average impact energy of 27 J of all-weld metal in accordance with this International Standard.
- c) Clauses and tables which have neither the suffix letter "A" nor the suffix letter "B" are applicable to all wire electrodes classified in accordance with this International Standard.

## 2 Normative references

The following referenced documents are indispensable for the application 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 13916, *Welding — Guidance on the measurement of preheating temperature, interpass temperature and preheat maintenance temperature*

ISO 14175:2008, *Welding consumables — Gases and gas mixtures for fusion welding and allied processes*

ISO 14344, *Welding consumables — Procurement of filler materials and fluxes*

ISO 15792-1:2000, *Welding consumables — Test methods — Part 1: Test methods for all-weld metal test specimens in steel, nickel and nickel alloys*

ISO 80000-1:2009, *Quantities and units — Part 1: General*