

**Welding consumables - Deposition of a weld metal pad  
for chemical analysis (ISO 6847:2013)**

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## EESTI STANDARDI EESSÕNA

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English Version

## Welding consumables - Deposition of a weld metal pad for chemical analysis (ISO 6847:2013)

Produits consommables pour le soudage - Exécution d'un  
dépôt de métal fondu pour l'analyse chimique (ISO  
6847:2013)

Schweißzusätze - Auftragung von Schweißgut zur  
Bestimmung der chemischen Zusammensetzung (ISO  
6847:2013)

This European Standard was approved by CEN on 21 April 2013.

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COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

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## Foreword

This document (EN ISO 6847:2013) has been prepared by Technical Committee IIW “International Institute of Welding” 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of an identical text or by endorsement, at the latest by December 2013, and conflicting national standards shall be withdrawn at the latest by December 2013.

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 6847:2001.

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### Endorsement notice

The text of ISO 6847:2013 has been approved by CEN as EN ISO 6847:2013 without any modification.

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## Introduction

ISO 6847:1985 addressed only the deposition of a weld metal pad for chemical analysis using covered electrodes for manual arc welding. This pad preparation was expensive to execute. IIW Commission II conducted testing of several methods of weld pad preparation that were less costly to execute than that of ISO 6847:1985 and yet produced equivalent results. Further, these methods were applicable to solid wires for gas shielded welding, to tubular cored wires for arc welding with or without gas shielding, and to wires and fluxes for submerged arc welding, as well as being applicable to covered electrodes. Accordingly, this revision simplifies weld pad preparation and broadens the range of welding processes and filler metals.

# Welding consumables — Deposition of a weld metal pad for chemical analysis

## 1 Scope

This International Standard specifies the procedure to be used for deposition of a weld metal pad for chemical analysis. This International Standard applies to deposition of a weld metal pad by use of covered electrodes, wire electrodes for gas shielded metal arc welding, tubular cored electrodes for gas shielded metal arc welding and for non-gas shielded metal arc welding, tubular cored rods for gas tungsten arc welding, and wire-flux combinations for submerged arc welding. This International Standard is applicable to welding consumables for non-alloy and fine grain steels, high strength steels, creep-resisting steels, stainless and heat-resisting steels, nickel and nickel alloys, and copper and copper alloys.

## 2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 6947, *Welds — Working positions — Definitions of angles of slope and rotation*

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

## 3 Base metal

### 3.1 Type

The base metal shall have a composition similar to that of the deposited metal or be a weldable carbon manganese structural steel with a carbon content of less than 0,2 %.

### 3.2 Dimensions

The minimum dimensions of the base metal are given in Table 1.

### 3.3 Surface condition

The surface of the base metal on to which the weld metal is to be deposited shall be cleaned by grinding or other means in order to remove any rust, scale, grease, or paint.