

## **Welding consumables - Welding consumables for hard-facing**

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## EESTI STANDARDI EESSÕNA

## NATIONAL FOREWORD

<p>Käesolev Eesti standard EVS-EN 14700:2005 sisaldab Euroopa standardi EN 14700:2005 ingliskeelset teksti.</p> <p>Käesolev dokument on jõustatud 22.06.2005 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes.</p> <p>Standard on kättesaadav Eesti standardiorganisatsioonist.</p>	<p>This Estonian standard EVS-EN 14700:2005 consists of the English text of the European standard EN 14700:2005.</p> <p>This document is endorsed on 22.06.2005 with the notification being published in the official publication of the Estonian national standardisation organisation.</p> <p>The standard is available from Estonian standardisation organisation.</p>
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<p><b>Käsitlusala:</b></p> <p>This European Standard applies to welding consumables for hard facing. The range of application includes surfaces of new structural components, semi-finished products as well as repair of surfaces of structural components which have to resist to mechanical, hemical, thermal or combined stress.</p>	<p><b>Scope:</b></p> <p>This European Standard applies to welding consumables for hard facing. The range of application includes surfaces of new structural components, semi-finished products as well as repair of surfaces of structural components which have to resist to mechanical, hemical, thermal or combined stress.</p>
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**ICS** 25.160.20

**Võtmesõnad:** acceptance specification, chemical composition, Delivery conditions, designations, marking

ICS 25.160.20

English version

## Welding consumables - Welding consumables for hard-facing

Produits consommables de soudage - Produits  
consommables pour le rechargement dur

Schweißzusätze - Schweißzusätze zum Hartauftragen

This European Standard was approved by CEN on 8 April 2005.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.



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## Foreword

This European Standard (EN 14700:2005) has been prepared 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 November 2005, and conflicting national standards shall be withdrawn at the latest by November 2005.

This European Standard includes a Bibliography.

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

## 1 Scope

This European Standard applies to welding consumables for hard facing. The range of application includes surfaces of new structural components, semi-finished products as well as repair of surfaces of structural components which have to resist to mechanical, chemical, thermal or combined stress.

This European Standard specifies requirements for classification of the consumables based on their chemical composition of the all weld metal of covered electrodes, cored wires, cored rods, cored strips, sintered strips, sintered rods and metal powders and on the chemical composition of solid wires, solid rods, solid strips and cast rods.

## 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.

EN ISO 544, *Welding consumables — Technical delivery conditions for welding filler materials — Type of product, dimensions, tolerances and markings* (ISO 544:2003)

EN ISO 6847, *Welding consumables — Deposition of a weld metal pad for chemical analysis* (ISO 6847:2000)

EN ISO 14344, *Welding and allied processes - Flux and gas shielded electrical welding processes — Procurement guidelines for consumables* (ISO 14344:2002)

ISO 31-0:1992, *Quantities and units — Part 0: General principles*

## 3 Classification

The classification is divided in two parts:

- a) the first part gives a symbol indicating the product form, see 4.1;
- b) the second part gives a alloy symbol indicating the chemical composition, see Table 2.

## 4 Symbols and requirements

### 4.1 Symbol for the product form

The following symbols for the product forms shall be used (see Table 1).