Welding consumables - Rods, wires and deposits for tungsten inert gas welding of non-alloy and fine-grain steels - Classification (ISO 636:2015)

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NATIONAL FOREWORD

See Eesti standard EVS-EN ISO 636:2015 sisaldab Euroopa standardi EN ISO 636:2015 ingliskeelset teksti.	This Estonian standard EVS-EN ISO 636:2015 consists of the English text of the European standard EN ISO 636:2015.
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 16.12.2015.	Date of Availability of the European standard is 16.12.2015.
Standard on kättesaadav Eesti Standardikeskusest.	The standard is available from the Estonian Centre for Standardisation.

Tagasisidet standardi sisu kohta on võimalik edastada, kasutades EVS-i veebilehel asuvat tagasiside vormi või saates e-kirja meiliaadressile standardiosakond@evs.ee.

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Welding consumables - Rods, wires and deposits for tungsten inert gas welding of non-alloy and fine-grain steels - Classification (ISO 636:2015)

Produits consommables pour le soudage - Baguettes et fils pour dépôts par soudage TIG des aciers non alliés et des aciers à grains fins - Classification (ISO 636:2015)

Schweißzusätze - Stäbe, Drähte und Schweißgut zum Wolfram-Inertgasschweißen von unlegierten Stählen und Feinkornstählen - Einteilung (ISO 636:2015)

EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
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European foreword

This document (EN ISO 636:2015) 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of an identical text or by endorsement, at the latest by June 2016, and conflicting national standards shall be withdrawn at the latest by June 2016.

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.

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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, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

Endorsement notice

The text of ISO 636:2015 has been approved by CEN as EN ISO 636:2015 without any modification.

Contents

Page

Foreword ..... **iv**
Introduction ..... **v**
1 Scope **1**
2 Normative references **1**
3 Classification **1**
4 Symbols and requirements **2**
4.1 Symbol for the product/process 2
4.2 Symbol for strength and elongation of all-weld metal 3
4.3 Symbol for impact properties of all-weld metal 4
4.4 Symbol for the chemical composition of rods or wires 4
5 Mechanical tests **9**
5.1 Preheating and interpass temperatures 9
5.2 Welding conditions and pass sequence 10
5.3 PWHT condition 10
6 Chemical analysis **10**
7 Rounding procedure **11**
8 Retests **11**
9 Technical delivery conditions **11**
10 Designation **11**

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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Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: Foreword - Supplementary information

The committee responsible for this document is ISO/TC 44, *Welding and allied processes*, Subcommittee SC 3, *Welding consumables*.

This fourth edition cancels and replaces the third edition (ISO 636:2004), which has been technically revised.

Requests for official interpretations of any aspect of this International Standard should be directed to the Secretariat of ISO/TC 44/SC 3, through your national standards body, a complete listing of which can be found at www.iso.org.

Introduction

This International Standard provides a classification for the designation of rods and wires 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 to tensile strength of weld metal is generally higher than that of parent metal. Matching weld metal yield strength to parent metal yield strength will not necessarily ensure that the weld metal tensile strength matches that of the parent material. Where the application requires matching tensile strengths, selection of consumables is made by reference to column 3 of Table 1A or Table 1B.

Of note is that the mechanical properties of all-weld metal test specimens used to classify the rods and wires vary from those obtained in production joints because of differences in welding procedure such as diameter, width of weave, welding position, and material composition.

The classification according to system A is mainly based on EN 1668:1997. The classification according to system B is mainly based upon standards used around the Pacific Rim.

Welding consumables — Rods, wires and deposits for tungsten inert gas welding of non-alloy and fine-grain steels — Classification

1 Scope

This International Standard specifies requirements for classification of rods and wires in the as-welded condition and in the post-weld heat-treated condition for tungsten inert gas 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.

This International Standard is 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) Paragraphs and tables which carry the suffix letter "A" are applicable only to rods and wires 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) Paragraphs and tables which carry the suffix letter "B" are applicable only to rods and wires 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) Paragraphs and tables which have neither the suffix letter "A" nor the suffix letter "B" are applicable to all rods and wires classified in accordance with this International Standard.

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 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, *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*. Amended by ISO 15792-1:2000/Amd 1:2011

ISO 80000-1:2009, *Quantities and units — Part 1: General.* Corrected by ISO 80000-1:2009/Cor 1:2011

3 Classification

Classification designations are based upon two approaches to indicate the tensile properties and the impact properties of the all-weld metal obtained with rods or wires. The two designation approaches include additional designators for some other classification requirements, but not all as will be clear from the following sections. In most cases, a given commercial product can be classified to the