

Welding consumables - Procurement of filler materials
and fluxes (ISO 14344:2024)

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EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

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ICS 25.160.20

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EUROPEAN STANDARD

EN ISO 14344

NORME EUROPÉENNE

EUROPÄISCHE NORM

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English Version

Welding consumables - Procurement of filler materials and fluxes (ISO 14344:2024)

Produits consommables pour le soudage -
Approvisionnement en matériaux d'apport et flux (ISO
14344:2024)

Schweißzusätze - Beschaffung von Schweißzusätzen
(ISO 14344:2024)

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

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

European foreword

This document (EN ISO 14344:2024) 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 AFNOR.

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of an identical text or by endorsement, at the latest by March 2025, and conflicting national standards shall be withdrawn at the latest by March 2025.

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 14344:2010.

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Endorsement notice

The text of ISO 14344:2024 has been approved by CEN as EN ISO 14344:2024 without any modification.

Contents

	Page
Foreword	iv
Introduction	v
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 Lot classification	3
4.1 General.....	3
4.2 Solid welding consumables.....	4
4.2.1 Lot class S1.....	4
4.2.2 Lot class S2.....	4
4.2.3 Lot class S3.....	4
4.2.4 Lot class S4.....	4
4.2.5 Lot Class S5.....	4
4.3 Tubular cored electrodes and rods.....	4
4.3.1 Lot Class T1.....	4
4.3.2 Lot Class T2.....	5
4.3.3 Lot Class T3.....	5
4.3.4 Lot Class T4.....	5
4.4 Covered electrodes.....	5
4.4.1 Lot Class C1.....	5
4.4.2 Lot Class C2.....	5
4.4.3 Lot Class C3.....	6
4.4.4 Lot Class C4.....	6
4.4.5 Lot Class C5.....	6
4.5 Fluxes for electroslag and submerged arc welding.....	6
4.5.1 Lot Class F1.....	6
4.5.2 Lot Class F2.....	6
5 Testing schedule	6
5.1 General.....	6
5.2 Schedule 1 or F.....	7
5.3 Schedule 2 or G.....	7
5.4 Schedule 3 or H.....	7
5.5 Schedule 4 or I.....	7
5.6 Schedule 5 or J.....	8
5.7 Schedule 6 or K.....	8
6 Certification	8
6.1 General.....	8
6.2 Certificates.....	9
6.2.1 Certificate of compliance.....	9
6.2.2 Certificate of conformance.....	9
6.2.3 Certified material test report (CMTR).....	9
6.3 Inspection documents.....	9
Annex A (informative) Examples of how to apply the 24 h limitation	10
Bibliography	12

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 document 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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This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 3, *Welding consumables*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding and allied processes*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This third edition cancels and replaces the second edition (ISO 14344:2010), which has been technically revised.

The main changes are as follows:

- content from scope has been moved to the introduction;
- in [Clause 2](#), reference is made to ISO 544, ISO 10474 and EN 10204;
- in [Clause 3](#), terms and definitions have been revised and the list expanded;
- [Clause 5](#) has been significantly revised.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html. Official interpretations, where they exist, are available from this page: <https://committee.iso.org/sites/tc44/home/interpretation.html>. Official interpretations, where they exist, are available from this page: <https://committee.iso.org/sites/tc44/home/interpretation.html>.

Introduction

In production, the components of welding consumables are divided into discrete, predetermined quantities so that satisfactory tests with a sample from that quantity will establish that the entire quantity meets specification requirements. These quantities, known by such terms as heats, lots, blends, batches and mixes, vary in size according to the manufacturer. For identification purposes, each manufacturer assigns a unique designation to each quantity. This designation usually consists of a series of numbers or letters, or combinations thereof, which will enable the manufacturer to determine the date and time (or shift) of manufacture, the raw materials used, and the details of the procedures used in producing the welding consumable. This designation stays with the welding consumable and can be used to identify the material later, in those cases in which identification is necessary.

Welding consumables — Procurement of filler materials and fluxes

1 Scope

This document specifies tools for communication between a purchaser and a supplier of welding consumables within quality systems, such as those based upon ISO 9001.

This document, together with an applicable welding consumable standard (ISO or other), provides a method for preparing the specific details needed for welding consumable procurement which consists of:

- a) the welding consumable classification (selected from the applicable welding consumable standard);
- b) the lot classification (selected from [Clause 4](#));
- c) the testing schedule (selected from [Clause 5](#)).

Selection of the specific welding consumable classification, lot classification, and testing schedule depends upon the requirements of the application for which the welding consumable is being procured.

This document does not apply to non-consumable electrodes or shielding gases.

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 10474, *Steel and steel products — Inspection documents*

EN 10204, *Metallic products – Types of inspection documents*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 544 and the following apply.

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <https://www.electropedia.org/>

3.1

controlled chemical composition

<covered or tubular electrodes> covering or core ingredients consisting of one or more wet mixes, dry batches, or dry blends that are subjected to sufficient tests to ensure that all within the *lot* ([3.8](#)) are equivalent

Note 1 to entry: These tests shall include chemical analysis, the results of which shall fall within the manufacturer's acceptance limits. The identification of the test procedure and the results of the tests shall be recorded.