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Welding — All-weld metal test assembly for the classification of corrosion-resisting chromium and chromium-nickel steel covered arc welding electrodes

*Soudage — Moule pour la classification des électrodes enrobées pour
soudage à l'arc, déposant un acier au chrome ou au chrome-nickel
résistant à la corrosion*



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Foreword

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Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 10446 was prepared in collaboration with the International Institute of Welding, which has been approved as an international standardizing body in the field of welding by the ISO Council.

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Welding — All-weld metal test assembly for the classification of corrosion-resisting chromium and chromium-nickel steel covered arc welding electrodes

1 Scope

This International Standard describes the preparation and welding of all-weld metal test assembly for the classification of the mechanical properties of corrosion-resisting chromium and chromium-nickel steel covered arc welding electrodes.

The procedure includes details for the preparation of deposited weld metal to allow comparison of test results obtained from the same weld metal grades of different origin.

Recommended electrode diameters for testing are 3,2 mm to 5,0 mm.

2 Normative reference

The following standard contains provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the edition indicated was valid. All standards are subject to revision, and parties to agreements

based on this International Standard are encouraged to investigate the possibility of applying the most recent edition of the standard indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 630:1980, *Structural steels*.

3 Preparation of the test assemblies

The deposited metal test assembly shall be prepared as shown in figure 1. The backing strip shall be tack welded to the test assembly.

The steel to be used for the assembly shall be a matching type, or the edges of the grooves and the backing strip may be built up with the corresponding electrode type being tested.

In instances where carbon steel is used, the plates and backing bar (Grade Fe 430 in accordance with ISO 630 or its equivalent) shall be built up with two layers of weld metal (see figure 1).