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(JWES/JSA)

**Covered electrodes, solid wires,
rods and flux cored wires for cast
iron**

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In the event of any doubts arising as to the contents,
the original JIS is to be the final authority.

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Foreword

This translation has been made based on the original Japanese Industrial Standard revised by the Minister of Economy, Trade and Industry through deliberations at the Japanese Industrial Standards Committee as the result of proposal for revision of Japanese Industrial Standard submitted by The Japan Welding Engineering Society (JWES)/Japanese Standards Association (JSA) with the draft being attached, based on the provision of Article 12 Clause 1 of the Industrial Standardization Law applicable to the case of revision by the provision of Article 14.

Consequently, **JIS Z 3252**:2008 is replaced with this Standard.

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Covered electrodes, solid wires, rods and flux cored wires for cast iron

Introduction

This Japanese Industrial Standard has been prepared based on the second edition of **ISO 1071** published in 2003 with some modifications of the technical contents.

In **JIS Z 3252:2001**, scope was limited to covered electrodes. However, in **ISO 1071** which is the basis of the revision at this time, welding consumables other than covered electrodes are also specified. This time, to conform to the corresponding International Standard, scope is made the same as that of **ISO 1071**.

The portions with continuous sidelines or dotted underlines are the matters in which the contents of the corresponding International Standard have been modified. A list of modifications with explanations is given in Annex JA.

1 Scope

This Standard specifies the following welding consumables to be used in welding of cast iron.

- a) Covered electrodes
- b) Solid wires for gas shielded arc welding (hereafter referred to as “solid wires”)
- c) Rods for TIG welding and rods for gas welding (hereafter referred to as “rods”)
- d) Flux cored wires for gas shielded arc welding and self-shielded arc welding (hereafter referred to as “flux cored wires”)

NOTE : The International Standard corresponding to this Standard and the symbol of degree of correspondence are as follows:

ISO 1071:2003 *Welding consumables—Covered electrodes, wires, rods and tubular cored electrodes for fusion welding of cast iron—Classification (MOD)*

The symbols which denote the degree of correspondence in the contents between the relevant International Standard and **JIS** are IDT (identical), MOD (modified), and NEQ (not equivalent) according to **ISO/IEC Guide 21-1**.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this Standard. The most recent editions of the standards (including amendments) indicated below shall be applied.

JIS G 0320 *Standard test method for heat analysis of steel products*

JIS G 0321 *Product analysis and its tolerance for wrought steel*

JIS G 0404 *Steel and steel products—General technical delivery requirements*

JIS G 1326 *Methods for chemical analysis of ferronickel*