

# SVENSK STANDARD

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**Svetsning och besläktade förfaranden – Pulver- och gasskyddade bågsvetsmetoder – Riktlinjer för anskaffning av tillsatsmaterial (ISO 14344:2010)**

**Welding consumables – Procurement of filler materials and fluxes (ISO 14344:2010)**

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Europastandarden EN ISO 14344:2010 gäller som svensk standard. Detta dokument innehåller den officiella engelska versionen av EN ISO 14344:2010.

Denna standard ersätter SS-EN ISO 14344:2006, utgåva 1.

The European Standard EN ISO 14344:2010 has the status of a Swedish Standard. This document contains the official English version of EN ISO 14344:2010.

This standard supersedes the Swedish Standard SS-EN ISO 14344:2006, edition 1.

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN ISO 14344**

February 2010

ICS 25.160.10

Supersedes EN ISO 14344:2005

English Version

## Welding consumables - Procurement of filler materials and fluxes (ISO 14344:2010)

Produits consommables pour le soudage -  
Approvisionnement en matériaux d'apport et flux (ISO  
14344:2010)

Schweißzusätze - Beschaffung von Schweißzusätzen (ISO  
14344:2010)

This European Standard was approved by CEN on 27 January 2010.

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 CEN Management Centre 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 CEN Management Centre has the same status as the official versions.

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COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

**Management Centre: Avenue Marnix 17, B-1000 Brussels**

## Foreword

This document (EN ISO 14344:2010) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with 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 August 2010, and conflicting national standards shall be withdrawn at the latest by August 2010.

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.

This document supersedes EN ISO 14344:2005.

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, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and the United Kingdom.

### Endorsement notice

The text of ISO 14344:2010 has been approved by CEN as an EN ISO 14344:2010 without any modification.

# Welding consumables — Procurement of filler materials and fluxes

## 1 Scope

This International Standard specifies tools for communication between a purchaser and a supplier of welding consumables within quality systems, such as those based upon ISO 9001<sup>[1]</sup>.

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 type and source of 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.

This International Standard, together with an applicable International Standard or other standard for welding consumables, provides a method for preparing those specific details needed for welding consumable procurement which consist of:

- a) the welding consumable classification (selected from the applicable International Standard or other standard for welding consumables);
- 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 International Standard does not apply to non-consumable electrodes or shielding gases.

## 2 Terms and definitions

For the purposes of this International Standard, the following terms and definitions apply.

### 2.1

#### **dry batch**

quantity of dry ingredients mixed at one time in one mixing vessel

**NOTE** Liquid binder, when added to a dry batch, produces a wet mix. A dry batch can be divided into smaller quantities, in which case addition of the liquid binder produces as many wet mixes as there are smaller quantities.

## 2.2

### dry blend

⟨welding consumables⟩ two or more dry batches from which quantities of each are combined proportionately, then mixed in a mixing vessel to produce a larger quantity in which the ingredients are as uniformly dispersed as they would have been had the entire quantity been mixed together at one time in one large mixer

NOTE A dry blend, as in the case of a dry batch, can be used singly or divided into smaller quantities which, when the liquid binder is added, produce one or more wet mixes.

## 2.3

### wet mix

combination of liquid binder and a dry batch or dry blend, or a portion thereof, mixed at one time in one mixing vessel

## 2.4 Heat

### 2.4.1

#### heat

⟨open hearth, electric arc, basic oxygen, argon-oxygen processes⟩ for consumable inserts, solid wires, rods and strip, core wire for covered electrodes, and the sheath (strip or tubing of tubular cored electrode wire and rod), material obtained from one furnace melt, where slag-metal or gas-metal reactions occur in producing the metal

### 2.4.2

#### heat

⟨induction melting in a controlled atmosphere or in a vacuum⟩ for consumable inserts, solid wires, rods and strip, core wire for covered electrodes, and the sheath (strip or tubing of tubular cored electrode wire and rod), an uninterrupted series of melts from one controlled batch of metals and alloying ingredients in one melting furnace under the same melting conditions, each melt conforming to the chemical composition range approved by the purchaser of the material (i.e. the producer of the welding consumable) where significant chemical reactions do not occur in producing the metal

### 2.4.3

#### heat

⟨consumable electrode remelt⟩ for consumable inserts, solid wires, rods and strip, core wire for covered electrodes, and the sheath (strip or tubing of tubular cored electrode wire and rod), an uninterrupted series of remelts in one furnace under the same remelting conditions using one or more consumable electrodes produced from a heat, as defined, each remelt conforming to the chemical composition range approved by the purchaser of the material (i.e. the producer of the welding consumable) in processes involving continuous melting and casting

## 3 Identification

### 3.1 General

Identification of consumable inserts, solid wires, rods and strip, core wire for covered electrodes, and the sheath (strip or tubing) for tubular cored electrodes and rods shall be applied as listed in 3.2 to 3.3.1.

Identification of covering mix of covered electrodes, core ingredients of tubular cored electrode wire or rod, and fluxes for submerged arc welding shall be applied as listed in 3.3.2 to 3.6.

### 3.2 Heat number

Consumable inserts, solid wires, rods and strip, core wire for covered electrodes, and the sheath (strip or tubing) for tubular cored electrodes and rods, identified by heat number, shall consist of material from a single heat of metal.