

Australian Standard™

Electrodes and fluxes for submerged-arc welding

Part 1: Carbon steels and carbon-manganese steels

This Australian Standard was prepared by Committee WD-002, Welding Consumables. It was approved on behalf of the Council of Standards Australia on 31 January 2003 and published on 3 March 2003.

The following are represented on Committee WD-002:

Australian Chamber of Commerce and Industry
Australian Industry Group
Australian Institute of Steel Construction
Bureau of Steel Manufacturers of Australia
Business New Zealand
CSIRO Manufacturing Science and Technology
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This Standard was issued in draft form for comment as DR 02426.

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Part 1: Carbon steels and carbon-manganese steels

Originated as AS 1858—1976.
Previous edition as 1858.1—1986.
Second edition 2003.

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Published by Standards Australia International Ltd
GPO Box 5420, Sydney, NSW 2001, Australia

ISBN 0 7337 5048 6

PREFACE

This Standard was prepared by the Joint Standards Australia/Standards New Zealand Committee WD-002, Welding Consumables, to supersede AS 1858.1—1986.

The objective of this Standard is to provide classification and designation systems, as well as requirements, for solid and composite welding electrodes and fluxes for submerged-arc welding of carbon steels and carbon manganese steels.

This Standard is based on ANSI/AWS A5.17, *Specification for Carbon Steel Electrodes and Fluxes for Submerged-arc Welding*.

The principle behind the classification and designation systems adopted was that each of the three factors involved, electrodes, flux and weld metal, should be capable of individual selection and identification. In particular, the concept of the classification of weld metal as a separate entity is regarded as being of great significance. For ease of selection, the weld metal is classified according to its tensile strength and divided into grades related to its Charpy V-notch impact energy value. The Standard, therefore, separately deals with electrodes, fluxes, weld metal and testing.

Because of the large number of electrode/flux combinations available, guidance is frequently needed on the suitability of the process for a specific weldment. The intent here is that the designer should only need to specify on the drawing the weld metal designation, thereby nominating the mechanical properties required for the satisfactory functioning of the welded joint. The fabricator, taking into account recommendations by the manufacturer of the consumables, can select the electrode/flux combination that are appropriate to the materials of construction and the conditions pertaining at the time.

If procedure qualification is called up in the relevant application code, it may be necessary for the chosen electrode/flux combination to be qualified by procedure testing.

The terms ‘normative’ and ‘informative’ have been used in this Standard to define the application of the appendix to which they apply. A ‘normative’ appendix is an integral part of a Standard, whereas an ‘informative’ appendix is only for information and guidance.

Statements expressed in mandatory terms in notes to tables are deemed to be requirements of this Standard.

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STANDARDS AUSTRALIA

Australian Standard**Electrodes and fluxes for submerged-arc welding****Part 1: Carbon steels and carbon-manganese steels**

SECTION 1 SCOPE AND GENERAL

1.1 SCOPE

This Standard specifies requirements for solid and composite electrodes and fluxes for the submerged-arc welding of carbon steels and carbon manganese steels. It defines classification and designation systems for electrodes, fluxes and weld metal, and specifies their chemical and physical properties. It also specifies, where appropriate, requirements for testing, packaging, marking and storage.

NOTES:

- 1 The electrodes and fluxes specified herein may also be used, under appropriate conditions, for the welding of certain alloy steels.
- 2 Guidance on the classification system and the selection of electrodes and fluxes is given in Appendix A.

1.2 REFERENCED DOCUMENTS

The following documents are referred to in this Standard:

AS

1544	Methods for impact tests on metals
1544.2	Part 2: Charpy V-notch
1674	Safety in welding and allied processes
1674.1	Part 1: Fire precautions
1674.2	Part 2: Electrical
2177	Non-destructive testing—Radiography of welded butt joints in metals
2177.1	Part 1: Methods of test
2205	Methods of destructive testing of welds in metal
2205.2.2	Method 2.2: All-weld-metal tensile test
2205.7.1	Method 7.1: Charpy V-notch impact fracture toughness test
2812	Welding, brazing and cutting of metals—Glossary of terms

AS/NZS

1050	Methods for the analysis of iron and steel (all methods)
3678	Structural steel—Hot-rolled plates, floorplates and slabs
3752	Welding—Methods for determination of the diffusible hydrogen content of ferritic weld metal produced by arc welding

ANSI/AWS

A5.01	Filler metal procurement guidelines
WTIA (Welding Technology Institute of Australia)	
Technical Note 3—Care and conditioning of arc-welding consumables	
Technical Note 7—Health and safety in welding	
Technical Note 22—Welding—Electrical safety	