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**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 17493-2018

Replacing GB/T 17493-2008

Tubular cored electrodes for creep-resisting steels

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Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009.

This standard replaces GB/T 17493-2008 "low alloy steel flux cored wire". And GB/T 17493-2008 "low alloy steel flux cored welding

Compared with Silk, the main changes are as follows.

--- The standard name was changed to "heat-strength steel flux cored wire";

--- This standard revision only retains the heat-strength steel cored wire in the original standard. Other welding wires are adjusted according to their tensile strength range.

To GB/T 10045 "Non-alloy steel and fine-grain steel flux cored wire" and "High-strength steel flux-cored wire" standard;

--- Re-programmed the heat-strength steel flux-cored wire retained in the original standard according to ISO 17634.2015, and adjusted the technology

Claim;

---In accordance with ISO 17634.2015, the classification of 9C1MV1 chemical composition has been added;

--- For the type division, T-joint fillet weld, mechanical properties and chemical composition requirements according to ISO 17634.2015, the corresponding

Adjustment.

This standard uses the redrafting method to modify the use of ISO 17634.2015 "welding material gas shielded arc welding heat-strength steel flux cored wire

Classification" (English version).

Compared with ISO 17634.2015, this standard has more structural adjustments. Appendix A lists this standard and ISO 17634.2015.

Checklist of changes in the number of chapters;

There are technical differences between this standard and ISO 17634.2015. Appendix B gives the corresponding technical differences and their causes.

Watch list.

This standard also made the following editorial changes.

--- Change the standard name to "heat-strength steel flux cored wire";

--- Added Appendix C flux core wire type control (informative appendix);

--- Added Appendix D protective gas type code (informative appendix);

This standard is proposed and managed by the National Welding Standardization Technical Committee (SAC/TC55).

This standard was drafted. Harbin Welding Research Institute Co., Ltd., Tianjin Bridge Welding Materials Group Co., Ltd., Kunshan Jingqun Welding Materials Technology

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Su Jinhua, Qi Wanli, Song Bei.

The previous versions of the standards replaced by this standard.

---GB/T 17493-1998, GB/T 17493-2008.

Heat-strength steel flux cored wire

1 Scope

This standard specifies the type, technical requirements, test methods, re-inspection and technical conditions of supply of heat-strength steel flux cored wire.

This standard applies to heat-strength steel flux-cored wire for gas-shielded arc welding (hereinafter referred to as "welding wire").

2 Normative references

The following documents are indispensable for the application of this document. For dated references, only dated versions apply to this article.

Pieces. For undated references, the latest edition (including all amendments) applies to this document.

GB/T 2652 Weld and deposited metal tensile test method (GB/T 2652-2008, ISO 5178.2001, IDT)

GB/T 3323 metal fusion welding joints radiography

GB/T 3965 Method for determination of diffusible hydrogen in deposited metal (GB/T 3965-2012, ISO 3690.2000, MOD)

GB/T 16672 Definition of dip angle and corner of weld working position (GB/T 16672-1996, idt ISO 6947.1990)

GB/T 18591 Welding preheating temperature, inter-channel temperature and preheating maintenance temperature measurement guide (GB/T 18591-2001, idt ISO 13916.1996)

GB/T 25774.1 Inspection of welding materials - Part 1 . Preparation and inspection of mechanical properties of steel, nickel and nickel alloys

Inspection (GB/T 25774.1-2010, ISO 15792-1.2000, MOD)