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Tubular cored electrodes for electrogas welding

气电焊用药芯焊丝

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Foreword

This document is in accordance with the provisions of GB/T 1.1-2020 "Guidelines for standardization work Part 1: Structure and drafting rules for standardization documents" Drafting.

Please note that some of the contents of this document may involve patents. The issuing organization of this document does not assume the responsibility for identifying patents.

This document is proposed and coordinated by the National Technical Committee for Welding Standardization (SAC/TC55).

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Flux-cored wire for gas-electric welding

1 Scope

This document specifies the types, technical requirements, test methods, rounding rules, inspection rules and supply technical conditions of flux-cored wire for gas-electric welding And other content.

This document is applicable to flux cores for gas shielded and self-shielded gas electric welding with a minimum tensile strength requirement of not less than 430 MPa for weld metal.

Welding wire (hereinafter referred to as "welding wire").

2 Normative references

GB/T 2650-2022

ISO 9016

GB/T 2652

ISO 5178

GB/T 3323.1

GB/T 3323.1

ISO 17636

GB/T 3375

GB/T 8170-2008

GB/T 16672

GB/T 16672-1996

ISO 6947

GB/T 25775

GB/T 25775-2010

ISO 544

GB/T 25778

GB/T 25778-2010

ISO 14344

GB/T 37910.1-2019

ISO 10675

GB/T 39255

GB/T 39255-2020

ISO 14175

3 Terms and Definitions

The terms and definitions defined in GB/T 3375 and the following apply to this document.

3.1 electrogas welding

The arc between the welding wire and the workpiece is continuously fed, and no external pressure is applied during the welding process. The weld is constrained by forming and cooling equipment. Forming welding method.

Note. Solid or flux-cored wire can be used, and gas shielding or self-shielding can be selected. Usually, according to the welding position, it is divided into gas-electric vertical welding and gas-electric horizontal welding.

4.1 Model Classification

Welding wire models are divided according to mechanical properties, welding method, welding position, shielding gas type and chemical composition of weld metal.