



**International
Standard**

ISO 17633

**Welding consumables — Tubular
cored electrodes and rods for gas
shielded and non-gas shielded
metal arc welding of stainless
and heat-resisting steels —
Classification**

*Produits consommables pour le soudage — Fils et baguettes
fourrés pour le soudage à l'arc avec ou sans protection gazeuse
des aciers inoxydables et des aciers résistant aux températures
élevées — Classification*

**Fourth edition
2025-03**

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO document should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 3, *Welding consumables*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding and allied processes*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This fourth edition cancels and replaces the third edition (ISO 17633:2017) which has been technically revised. It also incorporates the Amendment ISO 17633:2017/Amd 1:2021

The main changes are as follows:

- document has been reformatted in single column showing System A and System B in tables and separate clauses and subclauses, some which are new;
- normative references have been updated;
- new footnotes have been added to [Tables 2](#) to [6](#) regarding specialized applications;
- 0,50 maximum cobalt has been added to all classifications in [Tables 2](#) to [6](#);
- compositions of 16 8 2 and 19 9 H and 25 4 have been updated in [Tables 4](#) and [5](#);
- examples in Clause 11 have been updated.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html. Official interpretations of ISO/TC 44 documents, where they exist, are available from this page: <https://committee.iso.org/sites/tc44/home/interpretation.html>.

Introduction

This document provides a classification system for tubular cored electrodes and rods for welding stainless and heat resisting steels.

It recognizes that there are two somewhat different approaches in the global market to classifying a given tubular stainless steel welding consumable, and allows for either or both to be used, to suit a particular market need. Application of either type of classification designation (or of both, where suitable) identifies a product as classified in accordance with this document. The classification in accordance with system A was mainly based on EN 12073:1999 which has been withdrawn and replaced by this standard. The classification in accordance with system B is mainly based upon standards used around the Pacific Rim.

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Welding consumables — Tubular cored electrodes and rods for gas shielded and non-gas shielded metal arc welding of stainless and heat-resisting steels — Classification

1 Scope

This document specifies requirements for classification of tubular flux and metal cored electrodes and rods, based on the all-weld metal chemical composition, the type of core, shielding gas, welding position and the all-weld metal mechanical properties, in the as-welded or heat-treated conditions, for gas shielded and non-gas shielded metal arc welding of stainless and heat-resisting steels.

This document is a combined standard providing for classification utilizing a system based upon nominal composition or utilizing a system based upon alloy type.

- a) Clauses, subclauses, and tables which carry the suffix “System A” are applicable only to products classified using the system based upon nominal composition.
- b) Clauses, subclauses, and tables which carry the suffix “System B” are applicable only to products classified using the system based upon alloy type.
- c) Clauses, subclauses, and tables which do not have either the suffix “System A” or “System B” are applicable to all products classified in accordance with this document.

This document does not use pulsed current for determining the product classification, neither does it address ferrite numbers (see [Annex D](#) and ISO/TR 22824).

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 544, *Welding consumables — Technical delivery conditions for filler materials and fluxes — Type of product, dimensions, tolerances and markings*

ISO 6847, *Welding consumables — Deposition of a weld metal pad for chemical analysis*

ISO 6947:2019, *Welding and allied processes — Welding positions*

ISO 13916, *Welding — Guidance on the measurement of preheating temperature, interpass temperature and preheat maintenance temperature*

ISO 14175, *Welding consumables — Gases and gas mixtures for fusion welding and allied processes*

ISO 14344, *Welding consumables — Procurement of filler materials and fluxes*

ISO 15792-1:2020, *Welding consumables — Test methods — Part 1: Preparation of all-weld metal test pieces and specimens in steel, nickel and nickel alloys*

ISO 80000-1:2022, *Quantities and units — Part 1: General*

3 Terms and definitions

No terms and definitions are listed in this document.

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <https://www.electropedia.org/>

4 Classification

4.1 General

Classification designations are based upon two approaches to indicate the chemical composition of the all-weld metal deposit obtained with a given electrode or rod.

The “nominal composition” approach uses designation components indicating directly the nominal levels of certain alloying elements, given in a particular order, and some symbols for low but significant levels of other elements, whose levels are not conveniently expressed as integers. The “alloy type” approach uses tradition-based three- or four-digit designations for alloy families, and an occasional additional character or characters for compositional modifications of each original alloy within the family.

This clause includes the symbols for the type of product, the chemical composition of all-weld metal, the type of core, the shielding gas and the welding position, in accordance with the symbols defined in [Clause 5](#).

In most cases, a given commercial product can be classified in both systems. Then either or both classification designations can be used for the product.

4.2 Classification systems

Each classification system, A and B, is split into five parts as given in [Table 1](#).

Table 1 — Parts of the classification systems, A and B

Part of classification designation	Classification system	
	System A Classification according to nominal composition	System B Classification according to alloy type
1	symbol indicating the product to be identified (see 5.2);	symbol indicating the tubular cored electrode and rod (see 5.2);
2	symbol indicating the chemical composition of the all-weld metal (see Table 2);	symbol indicating the chemical composition of the all-weld metal (see Table 3 to Table 6);
3	symbol indicating the type of core (see Table 9);	symbol indicating the type of core (see Table 10);
4	symbol indicating the shielding gas (see 5.5);	
5	symbol indicating the welding position (see Table 11).	

The full identification (see [Clause 10](#) and examples in [Clause 11](#)) shall be used on packages and in the manufacturer's literature and data sheets.

5 Symbols and requirements

5.1 General

A given tubular cored electrode may be classified with more than one shielding gas. In such cases, each shielding gas results in a separate classification.

5.2 Symbol for the product

5.2.1 Classification according to nominal composition – System A

The symbol for tubular cored product used in the metal arc welding process shall be the letter “T”.

5.2.2 Classification according to alloy type – System B

The symbol for tubular cored product used in the metal arc welding process shall be the letters “TS”. The initial letter, where:

- a) T indicates tubular cored electrode or rod as distinguished from covered electrodes and from solid electrodes and rods;
- b) S indicates that the alloy system is stainless or heat-resisting steel.

5.3 Symbol for the chemical composition of all-weld metal

5.3.1 Classification according to nominal composition – System A

The symbols in [Table 2](#) identify the chemical composition of all-weld metal determined in accordance with [Clause 7](#).

The all-weld metal obtained with the tubular cored product in [Table 2](#) under conditions given in [Clause 6](#) shall also fulfil the requirements given in [Table 7](#). (See [Annex A](#).)

5.3.2 Classification according to alloy type – System B

The symbols in [Table 3](#) identify the chemical composition of all-weld metal for gas shielded flux cored electrodes determined in accordance with [Clause 7](#).

The symbols in [Table 4](#) identify the chemical composition of all-weld metal for non-gas shielded flux cored electrodes determined in accordance with [Clause 7](#).

The symbols in [Table 5](#) identify the chemical composition of all-weld metal for gas shielded metal cored electrodes determined in accordance with [Clause 7](#).

The symbols in [Table 6](#) identify the chemical composition of all-weld metal for cored products for gas tungsten arc welding determined in accordance with [Clause 7](#).

The all-weld metal obtained with the tubular cored electrodes and rods in [Table 3](#), [Table 4](#), [Table 5](#) and [Table 6](#) under conditions given in [Clause 6](#) shall also fulfil the requirements given in [Table 8](#). (See [Annex A](#).)

Table 2 — Symbols and all-weld metal chemical composition requirements – Classification according to nominal composition – System A

Alloy designation according to nominal composition	Chemical composition, % (by mass) ^{a,b}												
	C	Mn	Si	P ^c	S ^c	Cr	Ni	Mo	Nb + Ta ^d	Cu	Co ^e	N	Others
Martensitic/ferritic types													
13	0,12	1,5	1,0	0,030	0,025	11,0 to 14,0	0,3	0,3	—	0,5	0,50	—	—
13 Ti	0,10	0,80	1,0	0,030	0,030	10,5 to 13,0	0,3	0,3	—	0,5	0,50	—	Ti: 10 × C to 1,5
13 4	0,06	1,5	1,0	0,030	0,025	11,0 to 14,5	3,0 to 5,0	0,4 to 1,0	—	0,5	0,50	—	—
17	0,12	1,5	1,0	0,030	0,025	16,0 to 18,0	0,3	0,3	—	0,5	0,50	—	—
Austenitic types													
19 9 L	0,04	2,0	1,2	0,030	0,025	18,0 to 21,0	9,0 to 11,0	0,3	—	0,5	0,50	—	—
19 9 Nb	0,08	2,0	1,2	0,030	0,025	18,0 to 21,0	9,0 to 11,0	0,3	8 × C to 1,1	0,5	0,50	—	—
19 12 3 L	0,04	2,0	1,2	0,030	0,025	17,0 to 20,0	10,0 to 13,0	2,5 to 3,0	—	0,5	0,50	—	—
19 12 3 Nb	0,08	2,0	1,2	0,030	0,025	17,0 to 20,0	10,0 to 13,0	2,5 to 3,0	8 × C to 1,1	0,5	0,50	—	—
Ferritic-austenitic types (Sometimes referred to as austenitic-ferritic types)													
22 9 3 N L	0,04	2,5	1,2	0,030	0,025	21,0 to 24,0	7,5 to 10,5	2,5 to 4,0	—	0,5	0,50	0,08 to 0,20	—
23 7 N L	0,04	0,4 to 1,5	1,0	0,030	0,020	22,5 to 25,5	6,5 to 10,0	0,8	—	0,5	0,50	0,10 to 0,20	—
25 9 4 N L	0,04	2,5	1,2	0,030	0,025	24,0 to 27,0	8,0 to 10,5	2,5 to 4,5	—	—	0,50	0,20 to 0,30	—
25 9 4 Cu N L	0,04	2,5	1,2	0,030	0,025	24,0 to 27,0	8,0 to 10,5	2,5 to 4,5	—	1,0 to 2,5	0,50	0,20 to 0,30	—
Fully austenitic types													
18 16 5 N L ^f	0,03	1,0 to 4,0	1,0	0,03	0,02	17,0 to 20,0	16,0 to 19,0	3,5 to 5,0	—	0,5	0,50	0,10 to 0,20	—
19 13 4 N L ^f	0,04	1,0 to 5,0	1,2	0,030	0,025	17,0 to 20,0	12,0 to 15,0	3,0 to 4,5	—	0,5	0,50	0,08 to 0,20	—
20 25 5 Cu N L ^f	0,03	1,0 to 4,0	1,0	0,03	0,02	19,0 to 22,0	24,0 to 27,0	4,0 to 6,0	—	1,0 to 2,0	0,50	0,10 to 0,20	—
Special types — Often used for dissimilar metal joining													
18 8 Mn	0,20	4,5 to 7,5	1,2	0,035	0,025	17,0 to 20,0	7,0 to 10,0	0,3	—	0,5	0,50	—	—
18 9 Mn Mo	0,04 to 0,14	3,0 to 5,0	1,2	0,035	0,025	18,0 to 21,5	9,0 to 11,0	0,5 to 1,5	—	—	0,50	—	—

^a Single values are maximum values.^b “No requirement for analysis” is indicated by a dash.^c The sum of P and S shall not exceed 0,050 % (by mass), except for 18 16 5 N L, 18 8 Mn, and 29 9.^d Up to 20 % (by mass) of the amount of Nb can be replaced by Ta.^e For certain specialized applications, including but not limited to medical and nuclear power applications, a significantly lower Co limit than 0,50 % may be necessary. A lower limit should be specified in the purchase order in accordance with ISO 14344.^f The all-weld metal is in most cases fully austenitic and therefore can be susceptible to microfissuring or hot cracking. The occurrence of fissuring or cracking is reduced by increasing the weld metal manganese level and in recognition of this the manganese range is extended for a number of grades.^g Consumables for which the chemical composition is not listed shall be symbolized similarly and prefixed by the letter Z. The chemical composition ranges are not specified, and it is possible that two products with the same Z classification are not interchangeable.

Table 2 (continued)

20 10 3	0,08	2,5	1,2	0,035	0,025	19,5 to 22,0	9,0 to 11,0	2,0 to 4,0	—	0,5	0,50	—	—
23 12 L	0,04	2,5	1,2	0,030	0,025	22,0 to 25,0	11,0 to 14,0	0,3	—	0,5	0,50	—	—
23 12 Nb	0,08	1,0 to 2,5	1,0	0,03	0,02	22,0 to 25,0	11,0 to 14,0	0,3	10 × C to 1,0	0,5	0,50	—	—
23 12 2 L	0,04	2,5	1,2	0,030	0,025	22,0 to 25,0	11,0 to 14,0	2,0 to 3,0	—	0,5	0,50	—	—
29 9	0,15	2,5	1,2	0,035	0,025	27,0 to 31,0	8,0 to 12,0	0,3	—	0,5	0,50	—	—
Heat-resisting types													
Alloy designation according to nominal composition	C	Mn	Si	P ^c	S ^c	Cr	Ni	Mo	Nb + Ta ^d	Cu	Co ^e	N	Others
16 8 2	0,10	1,0 to 2,5	1,0	0,03	0,02	14,5 to 17,5	7,5 to 9,5	1,0 to 2,5	—	0,5	0,50	—	Cr+Mo: 18,5
19 9 H	0,04 to 0,08	1,0 to 2,5	1,0	0,03	0,02	18,0 to 21,0	9,0 to 11,0	0,3	—	0,5	0,50	—	—
21 10 N	0,06 to 0,09	0,3 to 1,0	1,0 to 2,0	0,02	0,01	20,5 to 22,5	9,5 to 11,0	0,5	—	0,5	0,50	0,10 to 0,20	Ce: 0,05
22 12 H	0,15	2,5	1,2	0,030	0,025	20,0 to 23,0	10,0 to 13,0	0,3	—	0,5	0,50	—	—
25 4	0,15	1,0 to 2,5	2,0	0,03	0,02	24,0 to 27,0	4,0 to 6,0	0,3	—	0,5	0,50	—	—
25 20 ^f	0,06 to 0,20	1,0 to 5,0	1,2	0,030	0,025	23,0 to 27,0	18,0 to 22,0	0,3	—	0,5	0,50	—	—
Other compositions													
Z ^g	Any other agreed composition												
Single values are maximum values.													
"No requirement for analysis" is indicated by a dash.													
The sum of P and S shall not exceed 0,050 % (by mass), except for 18 16 5 N L, 18 8 Mn, and 29 9.													
Up to 20 % (by mass) of the amount of Nb can be replaced by Ta.													
For certain specialized applications, including but not limited to medical and nuclear power applications, a significantly lower Co limit than 0,50 % may be necessary. A lower limit should be specified in the purchase order in accordance with ISO 14344.													
The all-weld metal is in most cases fully austenitic and therefore can be susceptible to microfissuring or hot cracking. The occurrence of fissuring or cracking is reduced by increasing the weld metal manganese level and in recognition of this the manganese range is extended for a number of grades.													
Consumables for which the chemical composition is not listed shall be symbolized similarly and prefixed by the letter Z. The chemical composition ranges are not specified, and it is possible that two products with the same Z classification are not interchangeable.													

Table 3 — Symbols and all-weld metal chemical composition requirements of gas shielded flux cored electrodes – Classification according to alloy type – System B

Alloy designation according to alloy type	Typical shielding gas (see 5.5)	Chemical composition, % (by mass) ^{a,b}												Others ^d
		C	Mn	Si	P	S	Cr	Ni	Mo	Nb + Ta	Cu	Co ^c	N	
307	C1, M12, M21, Z	0,13	3,30 to 4,75	1,0	0,04	0,03	18,0 to 20,5	9,0 to 10,5	0,5 to 1,5	—	0,75	0,50	—	—
308	C1, M12, M21, Z	0,08	0,5 to 2,5	1,0	0,04	0,03	18,0 to 21,0	9,0 to 11,0	0,75	—	0,75	0,50	—	—
308L	C1, M12, M21, Z	0,04	0,5 to 2,5	1,0	0,04	0,03	18,0 to 21,0	9,0 to 12,0	0,75	—	0,75	0,50	—	—
308H	C1, M12, M21, Z	0,04 to 0,08	0,5 to 2,5	1,0	0,04	0,03	18,0 to 21,0	9,0 to 11,0	0,75	—	0,75	0,50	—	—
308Mo	C1, M12, M21, Z	0,08	0,5 to 2,5	1,0	0,04	0,03	18,0 to 21,0	9,0 to 11,0	2,0 to 3,0	—	0,75	0,50	—	—
308LMo	C1, M12, M21, Z	0,04	0,5 to 2,5	1,0	0,04	0,03	18,0 to 21,0	9,0 to 12,0	2,0 to 3,0	—	0,75	0,50	—	—
308N	C1, M12, M21, Z	0,10	1,0 to 4,0	1,0	0,04	0,03	20,0 to 25,0	7,0 to 11,0	0,5	—	0,5	0,50	0,12 to 0,30	—
309	C1, M12, M21, Z	0,10	0,5 to 2,5	1,0	0,04	0,03	22,0 to 25,0	12,0 to 14,0	0,75	—	0,75	0,50	—	—
309L	C1, M12, M21, Z	0,04	0,5 to 2,5	1,0	0,04	0,03	22,0 to 25,0	12,0 to 14,0	0,75	—	0,75	0,50	—	—
309H	C1, M12, M21, Z	0,04 to 0,10	0,5 to 2,5	1,0	0,04	0,03	22,0 to 25,0	12,0 to 14,0	0,75	—	0,75	0,50	—	—
309Mo	C1, M12, M21, Z	0,12	0,5 to 2,5	1,0	0,04	0,03	21,0 to 25,0	12,0 to 16,0	2,0 to 3,0	—	0,75	0,50	—	—
309LMo	C1, M12, M21, Z	0,04	0,5 to 2,5	1,0	0,04	0,03	21,0 to 25,0	12,0 to 16,0	2,0 to 3,0	—	0,75	0,50	—	—
309LNb	C1, M12, M21, Z	0,04	0,5 to 2,5	1,0	0,04	0,03	22,0 to 25,0	12,0 to 14,0	0,75	0,70 to 1,00	0,75	0,50	—	—
309LNiMo	C1, M12, M21, Z	0,04	0,5 to 2,5	1,0	0,04	0,03	20,5 to 23,5	15,0 to 17,0	2,5 to 3,5	—	0,75	0,50	—	—
310	C1, M12, M21, Z	0,20	1,0 to 2,5	1,0	0,03	0,03	25,0 to 28,0	20,0 to 22,5	0,75	—	0,75	0,50	—	—

^a Single values are maximum values.

^b "No requirement for analysis" is indicated by a dash.

^c For certain specialized applications, including but not limited to medical and nuclear power applications, a significantly lower Co limit than 0,50 % may be necessary. A lower limit should be specified in the purchase order in accordance with ISO 14344.

^d For alloys intended for high temperature, Bi should be restricted to 20 ppm maximum.

^e Consumables for which the chemical composition is not listed shall be symbolized by the letter G. The chemical composition ranges are not specified, and it is possible that two products with the same G classification are not interchangeable.

Table 3 (continued)

Alloy designation according to alloy type	Typical shielding gas (see 5.5)	Chemical composition, % (by mass) ^{a,b}											N	Others ^d
		C	Mn	Si	P	S	Cr	Ni	Mo	Nb + Ta	Cu	Co ^c		
312	C1, M12, M21, Z	0,15	0,5 to 2,5	1,0	0,04	0,03	28,0 to 32,0	8,0 to 10,5	0,75	—	0,75	0,50	—	—
316	C1, M12, M21, Z	0,08	0,5 to 2,5	1,0	0,04	0,03	17,0 to 20,0	11,0 to 14,0	2,0 to 3,0	—	0,75	0,50	—	—
316L	C1, M12, M21, Z	0,04	0,5 to 2,5	1,0	0,04	0,03	17,0 to 20,0	11,0 to 14,0	2,0 to 3,0	—	0,75	0,50	—	—
316H	C1, M12, M21, Z	0,04 to 0,08	0,5 to 2,5	1,0	0,04	0,03	17,0 to 20,0	11,0 to 14,0	2,0 to 3,0	—	0,75	0,50	—	—
316LCu	C1, M12, M21, Z	0,04	0,5 to 2,5	1,0	0,04	0,03	17,0 to 20,0	11,0 to 16,0	1,25 to 2,75	—	1,0 to 2,5	0,50	—	—
317	C1, M12, M21, Z	0,08	0,5 to 2,5	1,0	0,04	0,03	18,0 to 21,0	12,0 to 14,0	3,0 to 4,0	—	0,75	0,50	—	—
317L	C1, M12, M21, Z	0,04	0,5 to 2,5	1,0	0,04	0,03	18,0 to 21,0	12,0 to 14,0	3,0 to 4,0	—	0,75	0,50	—	—
318	C1, M12, M21, Z	0,08	0,5 to 2,5	1,0	0,04	0,03	17,0 to 20,0	11,0 to 14,0	2,0 to 3,0	8 × C to 1,0	0,75	0,50	—	—
347	C1, M12, M21, Z	0,08	0,5 to 2,5	1,0	0,04	0,03	18,0 to 21,0	9,0 to 11,0	0,75	8 × C to 1,0	0,75	0,50	—	—
347L	C1, M12, M21, Z	0,04	0,5 to 2,5	1,0	0,04	0,03	18,0 to 21,0	9,0 to 11,0	0,75	8 × C to 1,0	0,75	0,50	—	—
347H	C1, M12, M21, Z	0,04 to 0,08	0,5 to 2,5	1,0	0,04	0,03	18,0 to 21,0	9,0 to 11,0	0,75	8 × C to 1,0	0,75	0,50	—	—
409	C1, M12, M21, Z	0,10	0,80	1,0	0,04	0,03	10,5 to 13,5	0,60	0,75	—	0,75	0,50	—	Ti: 10 × C to 1,5
409Nb	C1, M12, M21, Z	0,10	1,2	1,0	0,04	0,03	10,5 to 13,5	0,6	0,5	8 × C to 1,5	0,5	0,50	—	—
410	C1, M12, M21, Z	0,12	1,2	1,0	0,04	0,03	11,0 to 13,5	0,60	0,75	—	0,75	0,50	—	—
410NiMo	C1, M12, M21, Z	0,06	1,0	1,0	0,04	0,03	11,0 to 12,5	4,0 to 5,0	0,40 to 0,70	—	0,75	0,50	—	—

^a Single values are maximum values.^b "No requirement for analysis" is indicated by a dash.^c For certain specialized applications, including but not limited to medical and nuclear power applications, a significantly lower Co limit than 0,50 % may be necessary. A lower limit should be specified in the purchase order in accordance with ISO 14344.^d For alloys intended for high temperature, Bi should be restricted to 20 ppm maximum.^e Consumables for which the chemical composition is not listed shall be symbolized by the letter G. The chemical composition ranges are not specified, and it is possible that two products with the same G classification are not interchangeable.

Table 3 (continued)

Alloy designation according to alloy type	Typical shielding gas (see 5.5)	Chemical composition, % (by mass) ^{a,b}												Others ^d	
		C	Mn	Si	P	S	Cr	Ni	Mo	Nb + Ta	Cu	Co ^c	N		
430	C1, M12, M21, Z	0,10	1,2	1,0	0,04	0,03	15,0 to 18,0	0,60	0,75	—	0,75	0,50	—	—	
430Nb	C1, M12, M21, Z	0,10	1,2	1,0	0,04	0,03	15,0 to 18,0	0,6	0,5	0,5 to 1,5	0,5	0,50	—	—	
16-8-2	C1, M12, M21, Z	0,10	0,5 to 2,5	0,75	0,04	0,03	14,5 to 17,5	7,5 to 9,5	1,0 to 2,0	—	0,75	0,50	—	Cr + Mo: 18,5	
2209	C1, M12, M21, Z	0,04	0,5 to 2,0	1,0	0,04	0,03	21,0 to 24,0	7,5 to 10,0	2,5 to 4,0	—	0,75	0,50	0,08 to 0,20	—	
2307	C1, M12, M21, Z	0,04	2,0	1,0	0,03	0,02	22,5 to 25,5	6,5 to 10,0	0,8	—	0,50	0,50	0,10 to 0,20	—	
2553	C1, M12, M21, Z	0,04	0,5 to 1,5	0,75	0,04	0,03	24,0 to 27,0	8,5 to 10,5	2,9 to 3,9	—	1,5 to 2,5	0,50	0,10 to 0,25	—	
2594	C1, M12, M21, Z	0,04	0,5 to 2,5	1,0	0,04	0,03	24,0 to 27,0	8,0 to 10,5	2,5 to 4,5	—	1,5	0,50	0,20 to 0,30	W: 1,0	
2594W	C1, M12, M21, Z	0,04	0,5 to 2,0	1,0	0,04	0,03	23,0 to 27,0	8,0 to 11,0	2,5 to 4,0	—	1,0	0,50	0,08 to 0,30	W: 1,0 to 2,5	
G ^e	C1, M12, M21, Z	Any other agreed composition													
^a Single values are maximum values.															
^b "No requirement for analysis" is indicated by a dash.															
^c For certain specialized applications, including but not limited to medical and nuclear power applications, a significantly lower Co limit than 0,50 % may be necessary. A lower limit should be specified in the purchase order in accordance with ISO 14344.															
^d For alloys intended for high temperature, Bi should be restricted to 20 ppm maximum.															
^e Consumables for which the chemical composition is not listed shall be symbolized by the letter G. The chemical composition ranges are not specified, and it is possible that two products with the same G classification are not interchangeable.															

Table 4 — Symbols and all-weld metal chemical composition requirements of non-gas shielded flux cored electrodes – Classification according to alloy type – System B

Alloy designation according to alloy type	Typical shielding gas (see 5.5)	Chemical composition, % (by mass) ^{a,b}												
		C	Mn	Si	P	S	Cr	Ni	Mo	Nb + Ta	Cu	Co ^c	N	Others ^d
307	NO	0,13	3,30 to 4,75	1,0	0,04	0,03	19,5 to 22,0	9,0 to 10,5	0,5 to 1,5	—	0,75	0,50	—	—
308	NO	0,08	0,5 to 2,5	1,0	0,04	0,03	19,5 to 22,0	9,0 to 11,0	0,75	—	0,75	0,50	—	—
308L	NO	0,04	0,5 to 2,5	1,0	0,04	0,03	19,5 to 22,0	9,0 to 12,0	0,75	—	0,75	0,50	—	—
308H	NO	0,04 to 0,08	0,5 to 2,5	1,0	0,04	0,03	19,5 to 22,0	9,0 to 11,0	0,75	—	0,75	0,50	—	—
308Mo	NO	0,08	0,5 to 2,5	1,0	0,04	0,03	18,0 to 21,0	9,0 to 11,0	2,0 to 3,0	—	0,75	0,50	—	—
308LMo	NO	0,04	0,5 to 2,5	1,0	0,04	0,03	18,0 to 21,0	9,0 to 12,0	2,0 to 3,0	—	0,75	0,50	—	—
308HMo	NO	0,07 to 0,12	1,25 to 2,25	0,25 to 0,80	0,04	0,03	19,0 to 21,5	9,0 to 10,7	1,8 to 2,4	—	0,75	0,50	—	—
309	NO	0,10	0,5 to 2,5	1,0	0,04	0,03	23,0 to 25,5	12,0 to 14,0	0,75	—	0,75	0,50	—	—
309L	NO	0,04	0,5 to 2,5	1,0	0,04	0,03	23,0 to 25,5	12,0 to 14,0	0,75	—	0,75	0,50	—	—
309Mo	NO	0,12	0,5 to 2,5	1,0	0,04	0,03	21,0 to 25,0	12,0 to 16,0	2,0 to 3,0	—	0,75	0,50	—	—
309LMo	NO	0,04	0,5 to 2,5	1,0	0,04	0,03	21,0 to 25,0	12,0 to 16,0	2,0 to 3,0	—	0,75	0,50	—	—
309LNb	NO	0,04	0,5 to 2,5	1,0	0,04	0,03	23,0 to 25,5	12,0 to 14,0	0,75	0,70 to 1,00	0,75	0,50	—	—
310	NO	0,20	1,0 to 2,5	1,0	0,03	0,03	25,0 to 28,0	20,0 to 22,5	0,75	—	0,75	0,50	—	—
312	NO	0,15	0,5 to 2,5	1,0	0,04	0,03	28,0 to 32,0	8,0 to 10,5	0,75	—	0,75	0,50	—	—
316	NO	0,08	0,5 to 2,5	1,0	0,04	0,03	18,0 to 20,5	11,0 to 14,0	2,0 to 3,0	—	0,75	0,50	—	—
316L	NO	0,04	0,5 to 2,5	1,0	0,04	0,03	18,0 to 20,5	11,0 to 14,0	2,0 to 3,0	—	0,75	0,50	—	—
316LK	NO	0,04	0,5 to 2,5	1,0	0,04	0,3	17,0 to 20,0	11,0 to 14,0	2,0 to 3,0	—	0,75	0,50	—	—
316H	NO	0,04 to 0,08	0,5 to 2,5	1,0	0,04	0,03	18,0 to 20,5	11,0 to 14,0	2,0 to 3,0	—	0,75	0,50	—	—
316LCu	NO	0,03	0,5 to 2,5	1,0	0,04	0,03	18,0 to 20,5	11,0 to 16,0	1,25 to 2,75	—	1,0 to 2,5	0,50	—	—
317	NO	0,08	0,5 to 2,5	1,0	0,04	0,03	18,5 to 21,0	13,0 to 15,0	3,0 to 4,0	—	0,75	0,50	—	—
317L	NO	0,04	0,5 to 2,5	1,0	0,04	0,03	18,5 to 21,0	13,0 to 15,0	3,0 to 4,0	—	0,75	0,50	—	—
318	NO	0,08	0,5 to 2,5	1,0	0,04	0,03	18,0 to 20,5	11,0 to 14,0	2,0 to 3,0	8 × C to 1,0	0,75	0,50	—	—

^a Single values are maximum values.

^b "No requirement for analysis" is indicated by a dash.

^c For certain specialized applications, including but not limited to medical and nuclear power applications, a significantly lower Co limit than 0,50 % may be necessary. A lower limit should be specified in the purchase order in accordance with ISO 14344.

^d For alloys intended for high temperature, Bi should be restricted to 20 ppm maximum.

^e Consumables for which the chemical composition is not listed shall be symbolized by the letter G. The chemical composition ranges are not specified, and it is possible that two products with the same G classification are not interchangeable.

Table 4 (continued)

Alloy designation according to alloy type	Typical shielding gas (see 5.5)	Chemical composition, % (by mass) ^{a,b}												Others ^d
		C	Mn	Si	P	S	Cr	Ni	Mo	Nb + Ta	Cu	Co ^c	N	
347	NO	0,08	0,5 to 2,5	1,0	0,04	0,03	19,0 to 21,5	9,0 to 11,0	0,75	8 × C to 1,0	0,75	0,50	—	—
347L	NO	0,04	0,5 to 2,5	1,0	0,04	0,03	19,0 to 21,5	9,0 to 11,0	0,75	8 × C to 1,0	0,75	0,50	—	—
409	NO	0,10	0,80	1,0	0,04	0,03	10,5 to 13,5	0,60	0,75	—	0,75	0,50	—	Ti: 10 × C to 1,5
409Nb	NO	0,12	1,0	1,0	0,04	0,03	10,5 to 14,0	0,6	0,75	8 × C to 1,5	0,75	0,50	—	—
410	NO	0,12	1,0	1,0	0,04	0,03	11,0 to 13,5	0,60	0,75	—	0,75	0,50	—	—
410NiMo	NO	0,06	1,0	1,0	0,04	0,03	11,0 to 12,5	4,0 to 5,0	0,40 to 0,70	—	0,75	0,50	—	—
430	NO	0,10	1,0	1,0	0,04	0,03	15,0 to 18,0	0,60	0,75	—	0,75	0,50	—	—
430Nb	NO	0,10	1,0	1,0	0,04	0,03	15,0 to 18,0	0,6	0,75	0,5 to 1,5	0,75	0,50	—	—
16-8-2	NO	0,10	0,5 to 2,5	0,75	0,04	0,03	14,5 to 17,5	7,5 to 9,5	1,0 to 2,0	—	0,75	0,50	—	Cr + Mo: 18,5
2209	NO	0,04	0,5 to 2,0	1,0	0,04	0,03	21,0 to 24,0	7,5 to 10,0	2,5 to 4,0	—	0,75	0,50	0,08 to 0,20	—
2307	NO	0,04	2,0	1,0	0,03	0,02	22,5 to 25,5	6,5 to 10,0	0,8	—	0,50	0,50	0,10 to 0,20	—
2553	NO	0,04	0,5 to 1,5	0,75	0,04	0,03	24,0 to 27,0	8,5 to 10,5	2,9 to 3,9	—	1,5 to 2,5	0,50	0,10 to 0,25	—
2594	NO	0,04	0,5 to 2,5	1,0	0,04	0,03	24,0 to 27,0	8,0 to 10,5	2,5 to 4,5	—	1,5	0,50	0,20 to 0,30	W: 1,0
G ^e	NO	Any other agreed composition												
^a Single values are maximum values.														
^b "No requirement for analysis" is indicated by a dash.														
^c For certain specialized applications, including but not limited to medical and nuclear power applications, a significantly lower Co limit than 0,50 % may be necessary. A lower limit should be specified in the purchase order in accordance with ISO 14344.														
^d For alloys intended for high temperature, Bi should be restricted to 20 ppm maximum.														
^e Consumables for which the chemical composition is not listed shall be symbolized by the letter G. The chemical composition ranges are not specified, and it is possible that two products with the same G classification are not interchangeable.														

^a Single values are maximum values.

^b "No requirement for analysis" is indicated by a dash.

^c For certain specialized applications, including but not limited to medical and nuclear power applications, a significantly lower Co limit than 0,50 % may be necessary. A lower limit should be specified in the purchase order in accordance with ISO 14344.

^d For alloys intended for high temperature, Bi should be restricted to 20 ppm maximum.

^e Consumables for which the chemical composition is not listed shall be symbolized by the letter G. The chemical composition ranges are not specified, and it is possible that two products with the same G classification are not interchangeable.

Table 5 — Symbols and all-weld metal chemical composition requirements of gas shielded metal cored electrodes – Classification according to alloy type – System B

Alloy designation according to alloy type	Typical shielding gas (see 5.5)	Chemical composition, % (by mass) ^{a,b}											Co ^c	N	Others ^d
		C	Mn	Si	P	S	Cr	Ni	Mo	Nb + Ta	Cu				
209	M12, M13, M21, II, Z	0,05	4,0 to 7,0	0,90	0,03	0,03	20,5 to 24,0	9,5 to 12,0	1,5 to 3,0	—	0,75	0,50	0,10 to 0,30	—	V: 0,10 to 0,30
218	M12, M13, M21, II, Z	0,10	7,0 to 9,0	3,5 to 4,5	0,03	0,03	16,0 to 18,0	8,0 to 9,0	0,75	—	0,75	0,50	0,08 to 0,18	—	—
219	M12, M13, M21, II, Z	0,05	8,0 to 10,0	1,00	0,03	0,03	19,0 to 21,5	5,5 to 7,0	0,75	—	0,75	0,50	0,10 to 0,30	—	—
240	M12, M13, M21, II, Z	0,05	10,5 to 13,5	1,00	0,03	0,03	17,0 to 19,0	4,0 to 6,0	0,75	—	0,75	0,50	0,10 to 0,30	—	—
307	M12, M13, M21, II, Z	0,04 to 0,14	3,30 to 4,75	0,30 to 0,65	0,03	0,03	19,5 to 22,0	8,0 to 10,7	0,5 to 1,5	—	0,75	0,50	—	—	—
308	M12, M13, M21, II, Z	0,08	1,0 to 2,5	0,30 to 0,65	0,03	0,03	19,5 to 22,0	9,0 to 11,0	0,75	—	0,75	0,50	—	—	—
308Si	M12, M13, M21, II, Z	0,08	1,0 to 2,5	0,65 to 1,00	0,03	0,03	19,5 to 22,0	9,0 to 11,0	0,75	—	0,75	0,50	—	—	—
308H	M12, M13, M21, II, Z	0,04 to 0,08	1,0 to 2,5	0,30 to 0,65	0,03	0,03	19,5 to 22,0	9,0 to 11,0	0,50	—	0,75	0,50	—	—	—
308L	M12, M13, M21, II, Z	0,03	1,0 to 2,5	0,30 to 0,65	0,03	0,03	19,5 to 22,0	9,0 to 11,0	0,75	—	0,75	0,50	—	—	—
308LSi	M12, M13, M21, II, Z	0,03	1,0 to 2,5	0,65 to 1,00	0,03	0,03	19,5 to 22,0	9,0 to 11,0	0,75	—	0,75	0,50	—	—	—
308LMo	M12, M13, M21, II, Z	0,04	1,0 to 2,5	0,30 to 0,65	0,03	0,03	18,0 to 21,0	9,0 to 12,0	2,0 to 3,0	—	0,75	0,50	—	—	—
308Mo	M12, M13, M21, II, Z	0,08	1,0 to 2,5	0,30 to 0,65	0,03	0,03	18,0 to 21,0	9,0 to 12,0	2,0 to 3,0	—	0,75	0,50	—	—	—
309	M12, M13, M21, II, Z	0,12	1,0 to 2,5	0,30 to 0,65	0,03	0,03	23,0 to 25,0	12,0 to 14,0	0,75	—	0,75	0,50	—	—	—
309L	M12, M13, M21, II, Z	0,03	1,0 to 2,5	0,30 to 0,65	0,03	0,03	23,0 to 25,0	12,0 to 14,0	0,75	—	0,75	0,50	—	—	—
309LSi	M12, M13, M21, II, Z	0,03	1,0 to 2,5	0,65 to 1,00	0,03	0,03	23,0 to 25,0	12,0 to 14,0	0,75	—	0,75	0,50	—	—	—

^a Single values are maximum values.

^b "No requirement for analysis" is indicated by a dash.

^c For certain specialized applications, including but not limited to medical and nuclear power applications, a significantly lower Co limit than 0,50 % may be necessary. A lower limit should be specified in the purchase order in accordance with ISO 14344.

^d For alloys intended for high temperature, Bi should be restricted to 20 ppm maximum.

^e Consumables for which the chemical composition is not listed shall be symbolized by the letter G. The chemical composition ranges are not specified, and it is possible that two products with the same G classification are not interchangeable.

Table 5 (continued)

Alloy designation according to alloy type	Typical shielding gas (see 5.5)	Chemical composition, % (by mass) ^{a,b}												Co ^c	N	Others ^d
		C	Mn	Si	P	S	Cr	Ni	Mo	Nb + Ta	Cu					
309Si	M12, M13, M21, II, Z	0,12	1,0 to 2,5	0,65 to 1,00	0,03	0,03	23,0 to 25,0	12,0 to 14,0	0,75	—	0,75	0,50	—	—		
309LMo	M12, M13, M21, II, Z	0,03	1,0 to 2,5	0,30 to 0,65	0,03	0,03	23,0 to 25,0	12,0 to 14,0	2,0 to 3,0	—	0,75	0,50	—	—		
309Mo	M12, M13, M21, II, Z	0,12	1,0 to 2,5	0,30 to 0,65	0,03	0,03	23,0 to 25,0	12,0 to 14,0	2,0 to 3,0	—	0,75	0,50	—	—		
310	M12, M13, M21, II, Z	0,08 to 0,15	1,0 to 2,5	0,30 to 0,65	0,03	0,03	25,0 to 28,0	20,0 to 22,5	0,75	—	0,75	0,50	—	—		
312	M12, M13, M21, II, Z	0,15	1,0 to 2,5	0,30 to 0,65	0,03	0,03	28,0 to 32,0	8,0 to 10,5	0,75	—	0,75	0,50	—	—		
316	M12, M13, M21, II, Z	0,08	1,0 to 2,5	0,30 to 0,65	0,03	0,03	18,0 to 20,0	11,0 to 14,0	2,0 to 3,0	—	0,75	0,50	—	—		
316H	M12, M13, M21, II, Z	0,04 to 0,08	1,0 to 2,5	0,30 to 0,65	0,03	0,03	18,0 to 20,0	11,0 to 14,0	2,0 to 3,0	—	0,75	0,50	—	—		
316L	M12, M13, M21, II, Z	0,03	1,0 to 2,5	0,30 to 0,65	0,03	0,03	18,0 to 20,0	11,0 to 14,0	2,0 to 3,0	—	0,75	0,50	—	—		
316LMn	M12, M13, M21, II, Z	0,03	5,0 to 9,0	0,30 to 0,65	0,03	0,03	19,0 to 22,0	15,0 to 18,0	2,5 to 3,5	—	0,75	0,50	0,10 to 0,20	—		
316LSi	M12, M13, M21, II, Z	0,03	1,0 to 2,5	0,65 to 1,00	0,03	0,03	18,0 to 20,0	11,0 to 14,0	2,0 to 3,0	—	0,75	0,50	—	—		
316Si	M12, M13, M21, II, Z	0,08	1,0 to 2,5	0,65 to 1,00	0,03	0,03	18,0 to 20,0	14,0 to 14,0	2,0 to 3,0	—	0,75	0,50	—	—		
317	M12, M13, M21, II, Z	0,08	1,0 to 2,5	0,30 to 0,65	0,03	0,03	18,5 to 20,5	13,0 to 15,0	3,0 to 4,0	—	0,75	0,50	—	—		
317L	M12, M13, M21, II, Z	0,03	1,0 to 2,5	0,30 to 0,65	0,03	0,03	18,5 to 20,5	13,0 to 15,0	3,0 to 4,0	—	0,75	0,50	—	—		
318	M12, M13, M21, II, Z	0,08	1,0 to 2,5	0,30 to 0,65	0,03	0,03	18,0 to 20,0	11,0 to 14,0	2,0 to 3,0	8 × C, to 1,0	0,75	0,50	—	—		
320	M12, M13, M21, II, Z	0,07	2,5	0,60	0,03	0,03	19,0 to 21,0	32,0 to 36,0	2,0 to 3,0	8 × C to 1,0	3,0 to 4,0	0,50	—	—		
^a Single values are maximum values.																
^b "No requirement for analysis" is indicated by a dash.																
^c For certain specialized applications, including but not limited to medical and nuclear power applications, a significantly lower Co limit than 0,50 % may be necessary. A lower limit should be specified in the purchase order in accordance with ISO 14344.																
^d For alloys intended for high temperature, Bi should be restricted to 20 ppm maximum.																
^e Consumables for which the chemical composition is not listed shall be symbolized by the letter G. The chemical composition ranges are not specified, and it is possible that two products with the same G classification are not interchangeable.																

Table 5 (continued)

Alloy designation according to alloy type	Typical shielding gas (see 5.5)	Chemical composition, % (by mass) ^{a,b}												
		C	Mn	Si	P	S	Cr	Ni	Mo	Nb + Ta	Cu	Co ^c	N	Others ^d
320LR	M12, M13, M21, II, Z	0,025	1,5 to 2,0	0,15	0,015	0,02	19,0 to 21,0	32,0 to 36,0	2,0 to 3,0	8 × C to 0,40	3,0 to 4,0	0,50	—	—
321	M12, M13, M21, II, Z	0,08	1,0 to 2,5	0,30 to 0,65	0,03	0,03	18,5 to 20,5	9,0 to 10,5	0,75	—	0,75	0,50	—	Ti: 9 × C to 1,0
330	M12, M13, M21, II, Z	0,18 to 0,25	1,0 to 2,5	0,30 to 0,65	0,03	0,03	15,0 to 17,0	34,0 to 37,0	0,75	—	0,75	0,50	—	—
347	M12, M13, M21, II, Z	0,08	1,0 to 2,5	0,30 to 0,65	0,03	0,03	19,0 to 21,5	9,0 to 11,0	0,75	10 × C to 1,0	0,75	0,50	—	—
347Si	M12, M13, M21, II, Z	0,08	1,0 to 2,5	0,65 to 1,00	0,03	0,03	19,0 to 21,5	9,0 to 11,0	0,75	10 × C to 1,0	0,75	0,50	—	—
383	M12, M13, M21, II, Z	0,025	1,0 to 2,5	0,50	0,02	0,03	26,5 to 28,5	30,0 to 33,0	3,2 to 4,2	—	0,70 to 1,50	0,50	—	—
385	M12, M13, M21, II, Z	0,025	1,0 to 2,5	0,50	0,02	0,03	19,5 to 21,5	24,0 to 26,0	4,2 to 5,2	—	1,2 to 2,0	0,50	—	—
409	M12, M13, M21, II, Z	0,08	0,8	0,8	0,03	0,03	10,5 to 13,5	0,6	0,50	—	0,75	0,50	—	Ti: 10 × C to 1,5
409Nb	M12, M13, M21, II, Z	0,08	0,8	1,0	0,04	0,03	10,5 to 13,5	0,6	0,50	10 × C to 0,75	0,75	0,50	—	—
410	M12, M13, M21, II, Z	0,12	0,6	0,5	0,03	0,03	11,5 to 13,5	0,6	0,75	—	0,75	0,50	—	—
410NiMo	M12, M13, M21, II, Z	0,06	0,6	0,5	0,03	0,03	11,0 to 12,5	4,0 to 5,0	0,4 to 0,7	—	0,75	0,50	—	—
420	M12, M13, M21, II, Z	0,25 to 0,40	0,6	0,5	0,03	0,03	12,0 to 14,0	0,6	0,75	—	0,75	0,50	—	—
430	M12, M13, M21, II, Z	0,10	0,6	0,5	0,03	0,03	15,5 to 17,0	0,6	0,75	—	0,75	0,50	—	—
430Nb	M12, M13, M21, II, Z	0,10	1,2	1,0	0,04	0,03	15,0 to 18,0	0,6	0,75	0,5 to 1,5	0,75	0,50	—	—
439	M12, M13, M21, II, Z	0,04	0,8	0,8	0,03	0,03	17,0 to 19,0	0,6	0,5	—	0,75	0,50	—	Ti: 10 × C to 1,1

^a Single values are maximum values.^b "No requirement for analysis" is indicated by a dash.^c For certain specialized applications, including but not limited to medical and nuclear power applications, a significantly lower Co limit than 0,50 % may be necessary. A lower limit should be specified in the purchase order in accordance with ISO 14344.^d For alloys intended for high temperature, Bi should be restricted to 20 ppm maximum.^e Consumables for which the chemical composition is not listed shall be symbolized by the letter G. The chemical composition ranges are not specified, and it is possible that two products with the same G classification are not interchangeable.

Table 5 (continued)

Alloy designation according to alloy type	Typical shielding gas (see 5.5)	Chemical composition, % (by mass) ^{a,b}												Others ^d	
		C	Mn	Si	P	S	Cr	Ni	Mo	Nb + Ta	Cu	Co ^c	N		
439Nb	M12, M13, M21, II, Z	0,04	0,8	0,8	0,03	0,03	17,0 to 20,0	0,6	0,5	8 × C to 0,75	0,75	0,50	—	Ti: 0,10 to 0,75	
446LMo	M12, M13, II, Z	0,015	0,4	0,4	0,02	0,02	25,0 to 27,5	0,5	0,75 to 1,50	—	0,5	0,50	0,015	Ni + Cu = 0,5	
630	M12, M13, M21, II, Z	0,05	0,25 to 0,75	0,75	0,03	0,03	16,00 to 16,75	4,5 to 5,0	0,75	0,15 to 0,30	3,25 to 4,00	0,50	—	—	
2209	M12, M13, M21, II, Z	0,03	0,50 to 2,00	0,90	0,03	0,03	21,5 to 23,5	7,5 to 9,5	2,5 to 3,5	—	0,75	0,50	0,08 to 0,20	—	
2553	M12, M13, M21, II, Z	0,04	1,5	1,0	0,04	0,03	24,0 to 27,0	4,5 to 6,5	2,9 to 3,9	—	1,5 to 2,5	0,50	0,10 to 0,25	—	
2594	M12, M13, M21, II, Z	0,03	2,5	1,0	0,03	0,02	24,0 to 27,0	8,0 to 10,5	2,5 to 4,5	—	1,5	0,50	0,20 to 0,30	W: 1,0	
16-8-2	M12, M13, M21, II, Z	0,10	1,0 to 2,0	0,30 to 0,65	0,03	0,03	14,5 to 16,5	7,5 to 9,5	1,0 to 2,0	—	0,75	0,50	—	—	
19-10H	M12, M13, M21, II, Z	0,04 to 0,08	1,0 to 2,0	0,30 to 0,65	0,03	0,03	18,5 to 20,0	9,0 to 11,0	0,25	0,05	0,75	0,50	—	Ti: 0,05	
33-31	M12, M13, M21, II, Z	0,015	2,00	0,50	0,02	0,01	31,0 to 35,0	30,0 to 33,0	0,5 to 2,0	—	0,3 to 1,2	0,50	0,35 to 0,60	—	
3556	M12, M13, M21, II, Z	0,05 to 0,15	0,50 to 2,00	0,20 to 0,80	0,04	0,015	21,0 to 23,0	19,0 to 22,5	2,5 to 4,0	—	—	16,0 to 21,0	0,10 to 0,30	W: 2,0 to 3,5 Nb: 0,30 Ta: 0,30 to 1,25 Al: 0,10 to 0,50 Zr: 0,001 to 0,100 La: 0,005 to 0,100 B: 0,02	
G ^e	M12, M13, M21, II, Z	Any other agreed composition													

^a Single values are maximum values.

^b "No requirement for analysis" is indicated by a dash.

^c For certain specialized applications, including but not limited to medical and nuclear power applications, a significantly lower Co limit than 0,50 % may be necessary. A lower limit should be specified in the purchase order in accordance with ISO 14344.

^d For alloys intended for high temperature, Bi should be restricted to 20 ppm maximum.

^e Consumables for which the chemical composition is not listed shall be symbolized by the letter G. The chemical composition ranges are not specified, and it is possible that two products with the same G classification are not interchangeable.

Table 6 — Symbols and all-weld metal chemical composition requirements of cored products for gas tungsten arc welding – Classification according to alloy type – System B

Alloy designation according to alloy type	Typical shielding gas (see 5.5)	Chemical composition, % (by mass) ^{a,b}											Others ^d	
		C	Mn	Si	P	S	Cr	Ni	Mo	Nb + Ta	Cu	Co ^c		N
308L	I1, Z	0,03	0,5 to 2,5	1,2	0,04	0,03	18,0 to 21,0	9,0 to 11,0	0,75	—	0,75	0,50	—	—
309L	I1, Z	0,03	0,5 to 2,5	1,2	0,04	0,03	22,0 to 25,0	12,0 to 14,0	0,75	—	0,75	0,50	—	—
316L	I1, Z	0,03	0,5 to 2,5	1,2	0,04	0,03	17,0 to 20,0	11,0 to 14,0	2,0 to 3,0	—	0,75	0,50	—	—
347	I1, Z	0,08	0,5 to 2,5	1,2	0,04	0,03	18,0 to 21,0	9,0 to 11,0	0,75	8 × C to 1,0	0,75	0,50	—	—
Ge ^e	I1, Z	Any other agreed composition												
^a Single values are maximum values.														
^b “No requirement for analysis” is indicated by a dash.														
^c For certain specialized applications, including but not limited to medical and nuclear power applications, a significantly lower Co limit than 0,50 % may be necessary. A lower limit should be specified in the purchase order in accordance with ISO 14344.														
^d For alloys intended for high temperature, Bi should be restricted to 20 ppm maximum.														
^e Consumables for which the chemical composition is not listed shall be symbolized by the letter G. The chemical composition ranges are not specified, and it is possible that two products with the same G classification are not interchangeable.														

Table 7 — Tensile properties of all-weld metal – Classification according to nominal composition – System A

Alloy designation according to nominal composition	Minimum proof strength $R_{p0,2}$ MPa	Minimum tensile strength R_m MPa	Minimum elongation ^a %	Post-weld heat treatment
13	250	450	15	b
13 Ti	250	450	15	b
13 4	500	750	15	c
16 8 2	320	510	25	None
17	300	450	15	d
19 9 L	320	510	30	None
19 9 Nb	350	550	25	
19 12 3 L	320	510	25	
19 12 3 Nb	350	550	25	
19 13 4 N L	350	550	25	
19 9 H	350	550	30	
22 9 3 N L	450	550	20	
18 16 5 N L	300	480	25	
18 8 Mn	350	500	25	
18 9 Mn Mo	350	500	25	
20 10 3	400	620	20	
20 25 5 Cu N L	320	510	25	
21 10 N	350	550	30	
23 7 N L	450	570	20	
23 12 L	320	510	25	
23 12 Nb	350	550	25	
23 12 2 L	350	550	25	
29 9	450	650	15	
22 12 H	350	550	25	
25 20	350	550	20	
25 4	450	650	15	
25 9 4 Cu N L	550	620	18	
25 9 4 N L	550	620	18	
Z	Not specified			
^a Gauge length is equal to five times the test specimen diameter.				
^b The weld test assembly (or the blank from it, from which the tensile test specimen is to be machined) shall be heated to a temperature between 840 °C and 870 °C, held for 2 h, then furnace cooled to 600 °C, then cooled in air.				
^c The weld test assembly (or the blank from it, from which the tensile test specimen is to be machined) shall be heated to a temperature between 580 °C and 620 °C, held for 2 h, then cooled in air.				
^d The weld test assembly (or the blank from it, from which the tensile test specimen is to be machined) shall be heated to a temperature between 760 °C and 790 °C, held for 2 h, then furnace cooled to 600 °C, then cooled in air.				

Table 8 — Tensile properties of all-weld metal – Classification according to alloy type – System B

Alloy designation according to alloy type	Minimum tensile strength MPa	Minimum elongation ^a %	Post-weld heat treatment
307	590	25	None
308	550	25	
308L	520	25	
308H	550	25	
308Mo	550	25	
308LMo	520	25	
308HMo	550	25	
308N	690	20	
309	550	25	
309L	520	25	
309H	550	25	
309Mo	550	15	
309LMo	520	15	
309LNiMo	520	15	
309LNb	520	25	
310	550	25	
312	660	15	
316	520	25	
316L	485	25	
316H	520	25	
316LCu	485	25	
317	550	20	
317L	520	18	
318	520	20	
347	520	25	
347L	520	25	
347H	520	25	
409	450	14	b
409Nb	450	14	
410	520	15	b
410NiMo	760	10	c
430	450	15	d
430Nb	450	12	d

^a Gauge length is equal to five times the test specimen diameter.

^b The weld test assembly (or the blank from it, from which the tensile test specimen is to be machined) shall be heated to a temperature between 730 °C and 760 °C, held for 1 h, then furnace cooled to 315 °C, then cooled in air.

^c The weld test assembly (or the blank from it, from which the tensile test specimen is to be machined) shall be heated to a temperature between 590 °C and 620 °C, held for 1 h, then cooled in air.

^d The weld test assembly (or the blank from it, from which the tensile test specimen is to be machined) shall be heated to a temperature between 760 °C and 790 °C, held for 2 h, then furnace cooled to 600 °C, then cooled in air.

Table 8 (continued)

Alloy designation according to alloy type	Minimum tensile strength MPa	Minimum elongation ^a %	Post-weld heat treatment
16-8-2	520	25	None
2209	690	15	
2307	690	18	
2553	760	13	
2594	760	13	
2594W	690	15	
G	Not specified		
^a Gauge length is equal to five times the test specimen diameter.			
^b The weld test assembly (or the blank from it, from which the tensile test specimen is to be machined) shall be heated to a temperature between 730 °C and 760 °C, held for 1 h, then furnace cooled to 315 °C, then cooled in air.			
^c The weld test assembly (or the blank from it, from which the tensile test specimen is to be machined) shall be heated to a temperature between 590 °C and 620 °C, held for 1 h, then cooled in air.			
^d The weld test assembly (or the blank from it, from which the tensile test specimen is to be machined) shall be heated to a temperature between 760 °C and 790 °C, held for 2 h, then furnace cooled to 600 °C, then cooled in air.			

5.4 Symbol for type of core

The symbols in [Table 9](#) and [Table 10](#) indicate different types of tubular cored electrodes and rods relative to their core composition and slag characteristics.

Table 9 — Symbol for type of core – Classification according to nominal composition - System A

Symbol	Characteristics
B	Basic slag
R	Rutile, slow freezing slag
P	Rutile, fast freezing slag
M	Metal powder
U	Self-shielding
Z	Other types
Annex B provides a description of core types.	

Table 10 — Symbol for type of tubular cored electrode and rod – Classification according to alloy type – System B

Symbol	Characteristics
F	Flux cored electrodes
M	Metal cored electrodes
R	Cored rods for gas tungsten arc welding
Annex C provides a description of types of tubular cored electrodes and rods.	

5.5 Symbol for shielding gas

The symbols for shielding gases shall be the classification of the gas in accordance with ISO 14175, except that the symbol NO shall be used for non-gas shielded tubular cored electrodes.

5.6 Symbol for welding position

The symbols in [Table 11](#) indicate the welding positions, in accordance with the requirements of ISO 6947:2019, for which the product is suitable.

Table 11 — Symbol for welding position

Symbol	Classification system	
	System A Classification according to nominal composition	System B Classification according to alloy type
0	–	PA and PB
1	PA, PB, PC, PD, PE, PF and PG	PA, PB, PC, PD, PE, PF or PG, or PF and PG
2	PA, PB, PC, PD, PE and PF	–
3	PA and PB	–
4	PA	–
5	PA, PB and PG	–
Welding positions in accordance with ISO 6947:2019: PA = Flat position PB = Horizontal-vertical position PC = Horizontal position PD = Horizontal overhead position PE = Overhead position PF = Vertical up position PG = Vertical down position NOTE 1 A dash indicates not applicable.		

6 Mechanical test

6.1 General

The mechanical tests for tubular cored electrodes and tubular cored rods for each classification system, A and B, are given in [Table 12](#).

Table 12 — Mechanical tests

Test type	System A Classification according to nominal composition	System B Classification according to alloy type
Tensile tests (and any other required tests)	Tubular cored electrodes	
	Tensile tests and any required retests shall be carried out:	Tensile tests shall be carried out:
	a) on weld metal in the condition specified in Table 7 (as-welded or post-weld heat treated)	a) on weld metal in the condition specified in Table 8 (as-welded or post-weld heat treated)
	b) using an all-weld metal test piece in accordance with ISO 15792-1:2020 of a type specified in Table 14	
	c) using 1,2 mm, or, if this diameter is not manufactured, the next larger diameter manufactured as specified in 6.1 and 6.2 .	
	Tubular cored rods	
	Tensile tests for tubular cored rods shall be carried out:	
	a) on weld metal in the condition specified in Table 7	a) on weld metal in the condition specified in Table 8
	b) using an all-weld metal test piece in accordance with ISO 15792-1:2020 of a type specified in Table 14	
	c) using 2,0 mm, or, if this diameter is not manufactured, the next larger diameter manufactured as specified in 6.1 and 6.2	c) using 2,2 mm, or, if this diameter is not manufactured, the next larger diameter manufactured as specified in 6.1 and 6.2

6.2 Preheating and interpass temperatures

Preheating and interpass temperatures shall be selected for the appropriate weld metal type for each classification system, A and B, as given in [Table 13](#).

The preheating and interpass temperatures shall be measured using temperature indicator crayons, surface thermometers or thermocouples in accordance with ISO 13916.

The interpass temperature shall not exceed the maximum temperature indicated in [Table 13](#). If, after any pass, the interpass temperature is exceeded, the test assembly shall be cooled in air to a temperature within the limits of the interpass temperature.

Table 13 — Preheating and interpass temperatures

Preheating and interpass temperatures °C	System A Classification according to nominal composition	System B Classification according to alloy type
200 to 300	13 13Ti 17	410
100 to 180	13 4	-
150 to 260	-	409 409Nb 430 430Nb
100 to 260	-	410NiMo
≤150	All others	
NOTE 1 A dash indicates not applicable.		

6.3 Pass sequence

The total number of runs, the number of runs per layer and the total number of layers shall be as given in [Table 14](#).

Table 14 — Pass sequence

Process	Diameter mm	ISO 15792-1:2020 test piece type	Passes per layer		Total number of layers
			First layer	Other layers	
Gas shielded and non- gas shielded metal arc welding	<1,2	1.0	1 or 2	2 or 3 ^a	6 to 9
	1,2	1.3	1 or 2	2 or 3 ^a	5 to 9
	1,4 1,6 2,0	1.3	1 or 2	2 or 3 ^a	5 to 8
	2,4 3,2	1.3	1 or 2	1 or 2 ^b	4 to 7
Gas tungsten arc weld- ing	2,0 2,2 2,4	1.0	1 or 2	2 or 3 ^a	5 to 8

^a Final layer may have four passes.
^b Final layer may have three passes.

7 Chemical analysis

Chemical analysis shall be performed on any specimen appropriate for the analytical method to be used. In case of dispute, specimens in accordance with ISO 6847 shall be used. Any analytical technique can be used, but in cases of dispute, reference shall be made to established published methods.

8 Rounding procedure

Actual test values obtained shall be subject to ISO 80000-1:2022, B.3, Rule A. If the measured values are obtained by equipment calibrated in units other than those of this document, the measured values shall be converted to the units of this document before rounding. If an average value is to be compared with the requirements of this document, rounding shall be done only after calculating the average. The rounded results shall fulfil the requirements of the appropriate table for the classification under test.

9 Retests

If any test fails to meet the requirement(s), that test shall be repeated twice. The results of both retests shall meet the requirement. Specimens for the retest may be taken from the original test assembly or sample or from one or two new test assemblies. For chemical analysis, retests need only be for those specific elements that failed to meet the requirement. If the results of one or both retests fail to meet the requirement, the material under test shall be considered as not meeting the requirements of this document for that classification.

In the event that during preparation, or after completion of any test, it is clearly determined that prescribed or proper procedures were not followed in preparing the weld test assembly or sample(s) or test specimen(s), or in conducting the tests, the test shall be considered invalid. This determination is made without regard to whether the test was actually completed, or whether the test results met, or failed to meet, the requirements. That test shall be repeated, following proper prescribed procedures. In this case, the requirement for doubling the number of test specimens does not apply.

10 Technical delivery conditions

Technical delivery conditions shall be in accordance with ISO 544 and ISO 14344.

11 Examples of designation

11.1 General

The designation of tubular cored product shall follow the principles given in 11.2 to 11.4.

11.2 Example 1 – Classification according to nominal composition – System A

A tubular cored electrode (T) for gas shielded arc welding deposits a weld metal of chemical composition within the limits for the nominal composition 19 12 3 L of [Table 2](#).

This electrode, with a rutile type core with a slow freezing slag (R), tested under mixed gas (M21), that can be used in flat and horizontal-vertical positions (3), is designated as follows:

ISO 17633-A - T 19 12 3 L R M21 3

where

ISO 17633-A	is the number of this document with classification according to nominal composition;
T	indicates a tubular cored electrode for metal arc welding (see 5.2.1);
19 12 3 L	represents the chemical composition of the all-weld metal (see Table 2);
R	is the type of electrode core (see Table 9);
M21	is the shielding gas (see 5.5);
3	is the welding position (see Table 11).

11.3 Example 2 - Classification according to alloy type – System B

A tubular cored electrode (TS) for gas shielded arc welding deposits a weld metal of chemical composition within the limits for the alloy type 316L of [Table 3](#).

This flux cored electrode, type (F), tested under mixed gas (M21), that can be used in flat and horizontal-vertical positions (0), is designated as follows:

ISO 17633-B - TS 316L-F M21 0

where

ISO 17633-B	is the number of this document with classification according to alloy type;
TS	indicates a tubular cored stainless steel electrode for metal arc welding (see 5.2.2);
316L	represents the chemical composition of the all-weld metal (see Table 3);
F	is the type of tubular cored electrode (see Table 10);
M21	is the shielding gas (see 5.5);
0	is the welding position (see Table 11).

11.4 Example 3 – Z Classification according to nominal composition – System A

A tubular cored electrode (T) for gas shielded arc welding deposits a weld metal of chemical composition within the limits for the nominal composition T Z 22 12 N H C1 3 of [Table 2](#).

This electrode, with a rutile type core with a slow freezing slag (R), tested using carbon dioxide gas (C1), that can be used in flat and horizontal-vertical positions (3), is designated as follows:

where

ISO 17633-A	is the number of this document with classification according to nominal composition;
T	indicates a tubular cored electrode for metal arc welding (see 5.2.1);
Z	indicates that no chemical composition limits are specified (see Table 2);
22 10 N H	represents the typical chemical composition of the all-weld metal with 22 % Cr, 10 % Ni, 0,1 % N and 0,05 % C;
R	is the type of electrode core (see Table 9);
C1	is the shielding gas (see 5.5);
3	is the welding position (see Table 11).

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Annex A

(informative)

Comparison charts of alloy designation according to nominal composition and alloy type

See [Table A.1](#).

Table A.1 — Comparison charts of alloy designation according to nominal composition and alloy type

Correspondence of alloy, designated according to nominal composition, with alloy, designated according to alloy type, of similar, but not identical, requirements		Correspondence of alloy, designated according to alloy type, with alloy, designated according to nominal composition, of similar, but not identical, requirements	
Nominal composition	Alloy type ^a	Alloy type	Nominal composition ^a
13	410	307	—
13 Ti	409	308	—
13 4	410NiMo	308L	19 9 L
16 8 2	16-8-2	308H	19 9H
17	430	308Mo	20 10 3
19 9 L	308L	308LMo	—
19 9 Nb	347	308HMo	—
19 12 3 L	316L	309	—
19 12 3 Nb	318	309L	23 12 L
19 13 4 N L	—	309H	22 12 H
19 9 H	308H	309Mo	—
22 9 3 N L	2209	309LMo	23 12 2 L
18 16 5 N L	—	309LNb	—
18 8 Mn	—	310	25 20
18 9 Mn Mo	—	312	29 9
20 10 3	308Mo	316	—
20 25 5 Cu N L	—	316L	19 12 3 L
21 10 N	—	316H	—
23 7 N L	2307	316LCu	—
23 12 L	309L	317	—
23 12 Nb	309Nb	317L	—
23 12 2 L	309LMo	318	19 12 3 Nb
29 9	312	347	19 9 Nb
22 12 H	309H	347L	—
25 20	310	347H	19 9 Nb
25 4	—	409	13 Ti
25 9 4 N L and 25 9 4 Cu L	2594	409Nb	—

^a No correspondence of alloy designation in the classification according to alloy type or nominal composition is indicated by a dash