Specification for Low-Alloy Steel Electrodes and Fluxes for Submerged Arc Welding

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Specification for Low-Alloy Steel Electrodes and Fluxes for Submerged Arc Welding

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Prepared by the American Welding Society (AWS) A5 Committee on Filler Metals and Allied Materials

Under the Direction of the AWS Technical Activities Committee

Approved by the AWS Board of Directors

Abstract

This specification provides requirements for the classification of solid and composite carbon steel and low-alloy steel electrodes and fluxes for submerged arc welding. Electrode classification is based on chemical composition of the electrode for solid electrodes, and chemical composition of the weld metal for composite electrodes. Fluxes may be classified using a multiple pass classification system or a two-run classification system, or both, under this specification. Multiple pass classification is based on the mechanical properties and the deposit composition of weld metal produced with the flux and an electrode classified herein. Two-run classification is based upon mechanical properties only. Additional requirements are included for sizes, marking, manufacturing and packaging. The form and usability of the flux are also included. A guide is appended to the specification as a source of information concerning the classification system employed and the intended use of submerged arc fluxes and electrodes.

This specification makes use of both U.S. Customary Units and the International System of Units (SI). Since these are not equivalent, each system must be used independently of the other.
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Personnel

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R. D. Fuchs, 2nd Vice Chair Böhler Welding Group USA, Incorporated
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T. Anderson ESAB Welding & Cutting Product
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D. A. DelSignore Consultant
J. DeVito ESAB Welding & Cutting Products
H. W. Ebert Consulting Welding Engineer
D. M. Fedor The Lincoln Electric Company
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R. M. Henson J.W. Harris Company, Incorporated
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A. Y. Lau Canadian Welding Bureau
J. S. Lee Chevron
T. Melfi The Lincoln Electric Company
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K. Roossinck Ingalls Shipbuilding
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K. Sampath Consultant
W. S. Severance ESAB Welding and Cutting Products
M. J. Sullivan NASSCO—Natl Steel and Shipbuilding
R. C. Sutherlin ATI Wah Chang
R. A. Swain Euroweld, Limited
M. D. Tumuluru US Steel Corporation

Advisors to the A5 Committee on Filler Metal and Allied Material

R. L. Bateman Soldaduras West Arco Limitada
J. E. Beckham Chrysler LLC
M. L. Caruso Special Metals
R. A. Daemen Consultant
AWS A5B Subcommittee on Carbon and Low Alloy Steel Electrodes and Fluxes for Submerged Arc Welding

T. Melfi, Chair  The Lincoln Electric Company
R. K. Gupta, Secretary American Welding Society
H. Beck Harbert’s Products, Incorporated
H. W. Ebert Consultant
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T. C. Myers American Bureau of Shipping
P. J. Nicklas Sunset Metal Works
R. D. Strugar Bechtel Plant Machinery, Incorporated
R. A. Swain Euroweld, Limited

Advisors to the A5B Subcommittee on Carbon and Low Alloy Steel Electrodes and Fluxes for Submerged Arc Welding

D. D. Crockett Consultant
S. Imaoka Kobe Steel Limited
D. R. Miller ABS Americas Materials Department
D.M. Parker Consultant
F. A. Rhoades Hobart Brothers Company
A. C. Souza Lincoln Electric do Brasil
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