

AWS A5.25/A5.25M:2023
An American National Standard

Specification for Carbon and Low-Alloy Steel Electrodes and Fluxes for Electroslag Welding



**AWS A5.25/A5.25M:2023
An American National Standard**

**Approved by the
American National Standards Institute
March 2, 2023**

Specification for Carbon and Low-Alloy Steel Electrodes and Fluxes for Electroslag Welding

4th Edition

Revises ANSI/AWS A5.25/A5.25M-97 (R2009)

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 prescribes the requirements for classification of fluxes and solid and composite metal cored electrodes for electroslag welding. The requirements for electrodes include chemical composition of the electrode for solid electrodes and of weld metal for metal cored electrodes. Requirements for fluxes include the mechanical properties and soundness of weld metal taken from a groove weld made with a particular electrode using a prescribed welding procedure. Standard electrode sizes, marking, and packaging requirements are included.

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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This standard is subject to revision at any time by the AWS A5 Committee on Filler Metals and Allied Materials. It must be reviewed every five years, and if not revised, it must be either reaffirmed or withdrawn. Comments (recommendations, additions, or deletions) and any pertinent data that may be of use in improving this standard are requested and should be addressed to AWS Headquarters. Such comments will receive careful consideration by the AWS A5 Committee on Filler Metals and Allied Materials and the author of the comments will be informed of the Committee's response to the comments. Guests are invited to attend all meetings of the AWS A5 Committee on Filler Metals and Allied Materials to express their comments verbally. Procedures for appeal of an adverse decision concerning all such comments are provided in the Rules of Operation of the Technical Activities Committee. A copy of these Rules can be obtained from the American Welding Society, 8669 NW 36 St, # 130, Miami, FL 33166.

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Foreword

This foreword is not part of this standard but is included for informational purposes only.

This document makes use of both U.S. Customary Units and the International System of Units (SI). The measurements are not exact equivalents; therefore, each system must be used independently of the other, without combining in any way. In selecting rational metric units, AWS A1.1, *Metric Practice Guide for the Welding Industry* is used where suitable. Tables and figures make use of both U.S. Customary and SI Units which, with the application of the specified tolerances provide for interchangeability of products in both U.S. Customary and SI Units.

The current document is the third revision of this specification. Substantive changes include:

- Changing the metric equivalent to 70 000 psi from 480 MPa to 490 MPa, to better align with international specifications.
- ASTM E2033, *Standard Practice for Radiographic Examination Using Computed Radiography (Photostimulable Luminescence Method)* and ASTM E2698, *Standard Practice for Radiographic Examination Using Digital Detector Arrays* were added to the Normative References.
- The layout and wording of the document were updated to comply with AWS A5 general requirements and standard formats.

These substantive changes are shown in *italic* font.

The document evolution took place as follows:

AWS A5.25-78, *Specification for Consumables Used for Electroslag Welding of Carbon and High Strength Low Alloy Steels*

ANSI/AWS A5.25-91, *Specification for Carbon and Low-Alloy Steel Electrodes and Fluxes for Electroslag Welding*

ANSI/AWS A5.25-97, *Specification for Carbon and Low-Alloy Steel Electrodes and Fluxes for Electroslag Welding*

ANSI/AWS A5.25-97R, *Specification for Carbon and Low-Alloy Steel Electrodes and Fluxes for Electroslag Welding*

ANSI/AWS A5.25/A5.25M-97 (R2009), *Specification for Carbon and Low-Alloy Steel Electrodes and Fluxes for Electroslag Welding*

The user's attention is called to the possibility that compliance with this standard may require use of an invention covered by patent rights. By publication of this standard, no position is taken with respect to the validity of any such claim(s) or of any patent rights in connection therewith. If a patent holder has filed a statement of willingness to grant a license under these rights on reasonable and nondiscriminatory terms and conditions to applicants desiring to obtain such a license, then details may be obtained from the standards developer.

Comments and suggestions for the improvement of this standard are welcome. They should be sent to the Secretary, AWS A5 Committee on Filler Metals and Allied Materials, American Welding Society, 8669 NW 36 St, # 130, Miami, FL 33166.

All errata to a standard shall be published in the *Welding Journal* and posted on the AWS website.

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Table of Contents

	Page No.
<i>Personnel</i>	v
<i>Foreword</i>	vii
<i>List of Tables</i>	x
<i>List of Figures</i>	x
1. Scope	1
2. Normative References	1
3. Classification	2
4. Acceptance	6
5. Certification	6
6. Rounding Procedure	6
7. Summary of Tests	6
8. Retest	6
9. Test Assemblies	7
10. Chemical Analysis	7
11. Radiographic Test	8
12. Tension Test	10
13. Impact Test	12
14. Method of Manufacture	12
15. Electrode Requirements	12
16. Flux Requirements	13
Annex A (Informative)—Guide to AWS Specification for Carbon and Low-Alloy Steel Electrodes and Fluxes for Electroslag Welding.....	15
Annex B (Informative)—Requesting an Official Interpretation on an AWS Standard.....	21
AWS Filler Metal Specifications by Material and Welding Process.....	23
AWS Filler Metal Specifications and Related Documents.....	25

List of Tables

Table		Page No.
1	Chemical Composition Requirements for Solid Electrodes	3
2	Chemical Composition Requirements for Weld Metal from Composite Metal Cored Electrodes	4
3	A5.25 Tension Test Requirements (As Welded)	4
3M	A5.25M Tension Test Requirements (As Welded).....	4
4	A5.25 Impact Test Requirements (As Welded).....	5
4M	A5.25M Impact Test Requirements (As Welded)	5
5	Required Tests	7
6	Base Metals for Weld Test Assemblies	10
A.1	Comparison of A5.25/A5.25M:2023 Classifications and Classifications in Other AWS Specifications	16

List of Figures

Figure		Page No.
1	Weld Ingot Preparation	8
2	Groove Weld Test Assembly for Mechanical Properties and Soundness	9
3	Radiographic Standards for 6 in [150 mm] Length	11
A.1	Classification System	16

Specification for Carbon and Low-Alloy Steel Electrodes and Fluxes for Electroslag Welding

1. Scope

1.1 This specification prescribes requirements for the classification of electrodes (both solid and composite metal cored) and fluxes for electroslag welding of carbon and low-alloy steels.

1.2 This specification makes use of both U.S. Customary Units and the International System of Units (SI). The measurements are not exact equivalents; therefore, each system must be used independently of the other without combining in any way when referring to material properties. The specification A5.25 uses U.S. Customary Units; and the specification A5.25M uses SI Units. The latter are shown within brackets [] or in appropriate columns in tables and figures. Standard dimensions based on either system may be used for sizing of filler metal or packaging or both under A5.25 or A5.25M specifications.

1.3 Safety and health issues and concerns are beyond the scope of this standard; some safety and health information is provided, but such issues are not fully addressed herein. Some safety and health information can be found in Annex Clauses A5 and A8.

Safety and Health information is available from the following sources:

American Welding Society:

- (1) ANSI Z49.1, *Safety in Welding, Cutting, and Allied Processes*
- (2) AWS Safety and Health Fact Sheets
- (3) Other safety and health information on the AWS website

Material or Equipment Manufacturers:

- (1) Safety Data Sheets supplied by materials manufacturers
- (2) Operating Manuals supplied by equipment manufacturers

Applicable Regulatory Agencies

Work performed in accordance with this standard may involve the use of materials that have been deemed hazardous, and may involve operations or equipment that may cause injury or death. This standard does not purport to address all safety and health risks that may be encountered. The user of this standard should establish an appropriate safety program to address such risks as well as to meet applicable regulatory requirements. ANSI Z49.1 should be considered when developing the safety program.

2. Normative References

The documents listed below are referenced within this publication and are mandatory to the extent specified herein. Unless otherwise defined in this document, welding terms are as defined in AWS A3.0M/A3.0. For undated references, the latest edition of the referenced standard shall apply. For dated references, subsequent amendments to or revisions of any of these publications do not apply.

American Welding Society (AWS) documents:

AWS A3.0M/A3.0, *Standard Welding Terms and Definitions, Including Terms for Adhesive Bonding, Brazing, Soldering, Thermal Cutting, and Thermal Spraying*