Specification for
Nickel-Alloy Electrodes for
Flux Cored Arc Welding

Abstract

The composition, soundness, and properties of weld metal from nine grades of flux cored electrodes are specified. Standard electrode sizes together with their package forms and package sizes are detailed.

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.
# Table of Contents

Personnel ........................................................................................................................................................................ v
Foreword ........................................................................................................................................................................... vii
List of Tables .................................................................................................................................................................... x
List of Figures .................................................................................................................................................................. x

1. Scope ........................................................................................................................................................................ 1
2. Normative References ............................................................................................................................................. 1
3. Classification .......................................................................................................................................................... 2
4. Acceptance .............................................................................................................................................................. 2
5. Certification ............................................................................................................................................................. 2
6. Rounding-Off Procedure ........................................................................................................................................ 4
7. Summary of Tests .................................................................................................................................................... 4
8. Retest ........................................................................................................................................................................ 4
9. Weld Test Assemblies ............................................................................................................................................. 4
10. Chemical Analysis ................................................................................................................................................. 11
11. Radiographic Test .................................................................................................................................................. 11
12. Tension Test .......................................................................................................................................................... 11
13. Bend Test .............................................................................................................................................................. 11
14. Fillet Weld Test ........................................................................................................................................................ 13
15. Method of Manufacture ........................................................................................................................................ 13
16. Standard Sizes ...................................................................................................................................................... 13
17. Finish and Uniformity ............................................................................................................................................ 14
18. Standard Package Forms ...................................................................................................................................... 14
19. Winding Requirements ......................................................................................................................................... 16
20. Filler Metal Identification .................................................................................................................................... 17
21. Packaging ............................................................................................................................................................. 17
22. Marking of Packages ............................................................................................................................................. 18

Annex B (Informative)—Guidelines for the Preparation of Technical Inquiries ......................................................... 25
AWS Filler Metal Specifications by Material and Welding Process ........................................................................ 27
AWS Filler Metal Specifications and Related Documents ......................................................................................... 29
List of Tables

<table>
<thead>
<tr>
<th>Table</th>
<th>Description</th>
<th>Page No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Chemical Composition Requirements for Undiluted Weld Metal</td>
<td>3</td>
</tr>
<tr>
<td>2</td>
<td>Required Shielding Gas, Welding Current, and Welding Position</td>
<td>4</td>
</tr>
<tr>
<td>3</td>
<td>Required Tests</td>
<td>5</td>
</tr>
<tr>
<td>4</td>
<td>Required Base Metals</td>
<td>5</td>
</tr>
<tr>
<td>5</td>
<td>Base Metal Specifications</td>
<td>6</td>
</tr>
<tr>
<td>6</td>
<td>Tension Test Requirements</td>
<td>13</td>
</tr>
<tr>
<td>7</td>
<td>Standard Electrode Sizes and Tolerances</td>
<td>15</td>
</tr>
<tr>
<td>8</td>
<td>Standard Package Dimensions and Weights</td>
<td>15</td>
</tr>
<tr>
<td>A.1</td>
<td>Comparison of Classifications</td>
<td>21</td>
</tr>
</tbody>
</table>

List of Figures

<table>
<thead>
<tr>
<th>Figure</th>
<th>Description</th>
<th>Page No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Pad for Chemical Analysis of Undiluted Weld Metal</td>
<td>7</td>
</tr>
<tr>
<td>2</td>
<td>Groove Weld Test Assembly for Tension and Radiographic Tests</td>
<td>8</td>
</tr>
<tr>
<td>3</td>
<td>Groove Weld for Longitudinal Face-Bend Test</td>
<td>9</td>
</tr>
<tr>
<td>4</td>
<td>Fillet Weld Test Assembly</td>
<td>10</td>
</tr>
<tr>
<td>5</td>
<td>Radiographic Standards for 3/4 in [19 mm] Test Assembly in Figure 2</td>
<td>12</td>
</tr>
<tr>
<td>6</td>
<td>Fillet Weld Test Specimen and Dimensional Requirements</td>
<td>14</td>
</tr>
<tr>
<td>7</td>
<td>Dimensions of 4 in, 8 in, 12 in, and 14 in [100 mm, 200 mm, 300 mm, and 350 mm] Standard Spools</td>
<td>16</td>
</tr>
<tr>
<td>8</td>
<td>Dimensions of 22 in, 24 in, and 30 in [560 mm, 610 mm, and 760 mm] Standard Spools (Reels)</td>
<td>17</td>
</tr>
<tr>
<td>A.1</td>
<td>A5.34/A5.34M Classification System Utilizing the ISO Format</td>
<td>20</td>
</tr>
<tr>
<td>A.2</td>
<td>A5.34/A5.34M Classification System Utilizing the Traditional Format</td>
<td>20</td>
</tr>
</tbody>
</table>
Specification for Nickel-Alloy Electrodes for Flux Cored Arc Welding

1. Scope

1.1 This specification prescribes requirements for the classification of nickel-alloy electrodes for flux cored arc welding. It includes those compositions in which the nickel content exceeds that of any other element, but excludes nickel-base alloy compositions intended for the joining of cast irons.

1.2 Safety and health issues and concerns are beyond the scope of this standard and, therefore, are not fully addressed herein. Some safety and health information can be found in Annex A, Clauses A5 and A10. Safety and health information is available from other sources, including, but not limited to, ANSI Z49.1, Safety in Welding, Cutting, and Allied Processes, and applicable federal and state regulations.

1.3 This specification makes use of both U.S. Customary Units and the International System of Units (SI), according to the guidelines in AWS A1.1. 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 with the designation A5.34 uses U.S. Customary Units. The specification A5.34M 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 the A5.34 or A5.34M specification.

2. Normative References

2.1 The following standards contain provisions which, through reference in this text, constitute provisions of this AWS standard. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreement based on this AWS standard are encouraged to investigate the possibility of applying the most recent editions of the documents shown below. For undated references, the latest edition of the standard referred to applies.

2.2 The following AWS standards\(^1\) are referenced in the mandatory clauses of this document:

- AWS A1.1, Metric Practice Guide for the Welding Industry
- AWS A5.01, Filler Metal Procurement Guidelines
- AWS A5.32/A5.32M, Specification for Welding Shielding Gases
- AWS B4.0 or AWS B4.0M, Standard Methods for Mechanical Testing of Welds

2.3 The following ANSI standard\(^2\) is referenced in the mandatory clauses of this document:

- ANSI Z49.1 Safety in Welding, Cutting, and Allied Processes

2.4 The following ASTM standards\(^3\) are referenced in the mandatory clauses of this document:

- ASTM A 131/A 131M, Standard Specification for Structural Steel for Ships
- ASTM A 240/A 240M, Standard Specification for Chromium and Chromium-Nickel Stainless Steel Plate, Sheet, and Strip for Pressure Vessels and for General Applications

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\(^1\) AWS standards are published by the American Welding Society, 550 N.W. LeJeune Road, Miami, FL 33126.

\(^2\) This ANSI standard is published by the American Welding Society, 550 N.W. LeJeune Road, Miami, FL 33126.

\(^3\) ASTM standards are published by the American Society for Testing and Materials, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.