

STN	Zváracie materiály Pevné drôtové elektródy, plnené drôtové elektródy a kombinácia elektróda-tavivo na zváranie vysokopevných ocelí pod tavivom Klasifikácia (ISO 26304: 2025)	STN EN ISO 26304 05 5501
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Welding consumables - Solid wire electrodes, tubular cored electrodes and electrode-flux combinations for submerged arc welding of high strength steels - Classification (ISO 26304:2025)

Táto norma obsahuje anglickú verziu európskej normy.
This standard includes the English version of the European Standard.

Táto norma bola oznámená vo Vestníku ÚNMS SR č. 05/25

Obsahuje: EN ISO 26304:2025, ISO 26304:2025

Oznámením tejto normy sa ruší
STN EN ISO 26304 (05 5501) z augusta 2018

140460

Úrad pre normalizáciu, metrológiu a skúšobníctvo Slovenskej republiky, 2025
Slovenská technická norma a technická normalizačná informácia je chránená zákonom č. 60/2018 Z. z. o technickej normalizácii
v znení neskorších predpisov.

EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN ISO 26304

March 2025

ICS 25.160.20

Supersedes EN ISO 26304:2018

English Version

**Welding consumables - Solid wire electrodes, tubular
cored electrodes and electrode-flux combinations for
submerged arc welding of high strength steels -
Classification (ISO 26304:2025)**

Produits consommables pour le soudage - Fils-
électrodes pleins, fils-électrodes fourrés et couples
électrodes-flux pour le soudage à l'arc sous flux des
aciers à haute résistance - Classification (ISO
26304:2025)

Schweißzusätze - Massivdrahtelektroden,
Fülldrahtelektroden und Draht-Pulver-Kombinationen
zum Unterpulverschweißen von hochfesten Stählen -
Einteilung (ISO 26304:2025)

This European Standard was approved by CEN on 20 August 2024.

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EUROPÄISCHES KOMITEE FÜR NORMUNG

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EN ISO 26304:2025 (E)

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European foreword

This document (EN ISO 26304:2025) has been prepared by Technical Committee ISO/TC 44 "Welding and allied processes" in collaboration with Technical Committee CEN/TC 121 "Welding and allied processes" the secretariat of which is held by AFNOR.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by September 2025, and conflicting national standards shall be withdrawn at the latest by September 2025.

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Endorsement notice

The text of ISO 26304:2025 has been approved by CEN as EN ISO 26304:2025 without any modification.



International Standard

ISO 26304

Welding consumables — Solid wire electrodes, tubular cored electrodes and electrode-flux combinations for submerged arc welding of high strength steels — Classification

Produits consommables pour le soudage — Fils-électrodes pleins, fils-électrodes fourrés et couples électrodes-flux pour le soudage à l'arc sous flux des aciers à haute résistance — Classification

Fourth edition 2025-03

ISO 26304:2025(en)



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Published in Switzerland

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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 26304:2017), which has been technically revised.

The main changes are as follows:

- this document has been reformatted in single column showing System A and System B in tables and separate clauses and subclauses, some which are new;
- a new paragraph has been added to the end of [Clause 1](#), Scope;
- normative references updated;
- [Table 1](#) was updated;
- [Table 3](#) values for System B were revised to reflect those in ISO 18275 and ISO 18276
- [Table 7](#) and [Table 8](#) were revised and new footnotes added; header of the last column was revised;
- [Table 11](#), H8 was added;
- [Table 12](#), System B was revised;
- [Subclause 5.3](#) was revised;
- [Subclause 6.2](#) was revised;
- [Clause 11](#), examples updated and expanded.

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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>.

ISO 26304:2025(en)**Introduction**

This document recognizes that there are two somewhat different approaches in the global market to classifying a given solid wire electrode, tubular cored electrode, and electrode-flux combination, 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 originally based on EN 14295 which has been withdrawn and replaced by this document. The classification in accordance with system B is mainly based on standards used around the Pacific Rim. Future revisions aim to merge the two approaches into a single classification system.

This document provides a classification for the designation of solid wire electrodes in terms of their chemical composition, tubular cored electrodes in terms of the deposit composition obtained with a particular submerged arc flux, and, where required, electrode-flux combinations in terms of the yield strength, tensile strength, elongation, and impact properties of the all-weld metal deposit. The ratio of yield to tensile strength of weld metal is generally higher than that of parent material. Users should note that matching weld metal yield strength to parent metal yield strength does not necessarily ensure that the weld metal tensile strength matches that of the parent material. Thus, where the application requires matching tensile strength, selection of the consumable should be made by reference to columns 3 or 6 of [Table 3](#), as appropriate.

Although combinations of electrodes and fluxes supplied by individual companies can have the same system A classification, it is possible that the combination of an electrode with a flux from one manufacturer and the same electrode with a flux from another manufacturer, both fluxes having the same classification, may not be interchangeable unless verified in accordance with this document. Two tubular cored wires of the same classification can likewise produce different results with the same flux.

The mechanical properties of the all-weld metal test specimens used to classify the electrode-flux combinations vary from those obtained in production joints because of differences in welding procedures such as electrode size, width of weave, welding position, and material composition.

Welding consumables — Solid wire electrodes, tubular cored electrodes and electrode-flux combinations for submerged arc welding of high strength steels — Classification

1 Scope

This document specifies requirements for classification of solid wire electrodes, tubular cored electrodes, and electrode-flux combinations (the all-weld metal deposits) in the as-welded condition and in the post-weld heat-treated condition for submerged arc welding of high strength steels with a minimum yield strength greater than 500 MPa or a minimum tensile strength greater than 570 MPa. One flux can be tested and classified with different electrodes. One electrode can be tested and classified with different fluxes. The solid wire electrode is also classified separately based on its chemical composition.

This document is a combined specification providing for classification utilizing a system based on the yield strength and average impact energy of 47 J for the all-weld metal, or utilizing a system based on the tensile strength and average impact energy of 27 J for the all-weld metal.

- a) Clauses, subclauses and tables which carry the suffix “system A” are applicable only to solid wire electrodes, tubular cored electrodes and the all-weld metal deposits classified to the system based on the yield strength and the average impact energy of 47 J for the all-weld metal obtained with electrode-flux combinations in accordance with this document.
- b) Clauses, subclauses and tables which carry the suffix “system B” are applicable only to solid wire electrodes, tubular cored electrodes and the all-weld metal deposits classified to the system based on the tensile strength and the average impact energy of 27 J for the all-weld metal obtained with electrode-flux combinations in accordance with this document.
- c) Clauses, subclauses and tables which do not have either the suffix “system A” or “system B” are applicable to all solid wire electrodes, tubular cored electrodes and electrode-flux combinations classified in accordance with this document.

For comparison purposes, some tables include requirements for electrodes classified in accordance with both systems, placing individual electrodes from the two systems, which are similar in composition and properties, on adjacent lines in the particular table. In a particular line of the table that is mandatory in one system, the symbol for the similar electrode from the other system is indicated in parentheses. By appropriate restriction of the formulation of a particular electrode, it is often, but not always, possible to produce an electrode that can be classified in both systems, in which case the electrode, or its packaging, can be marked with the classification in either or both systems.

For system B only, electrode flux combinations for the single-run and two-run techniques are classified on the basis of the two-run technique.

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 3690, *Welding and allied processes — Determination of hydrogen content in arc weld metal*

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

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

ISO 14174, *Welding consumables — Fluxes for submerged arc welding and electroslag welding — Classification*

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 15792-2:2020, *Welding consumables — Test methods — Part 2: Preparation of single-run and two-run technique test pieces and specimens in steel*

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

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