

KOBELCO

WELDING HANDBOOK

WELDING CONSUMABLES AND PROCESSES



KOBE STEEL, LTD.
Welding Company

Foreword

Note the following preliminary information on use of the welding handbook.

1. Standards for welding consumables are abbreviated as follows.

- JIS: Japanese Industrial Standard
- AWS: American Welding Society's Standard
- EN: European Norm
- ASME: American Society of Mechanical Engineers' Standard

2. Classifications for welding consumables are used in accordance with the following rules.

Welding consumables are classified in accordance with, basically, the mechanical and/or chemical requirements of the standards, excluding such requirements as size, length, marking and identification means. If in details, please contact the nearest Kobelco office or sales representative.

3. The test conditions of mechanical properties and hardness are as follows.

- (1) Unless otherwise specified, impact values are obtained with Charpy 2mm V notch specimens.
- (2) Unless otherwise specified, tension test and hardness test are carried out at room temperature.
- (3) Unless otherwise specified, tension test and hardness test are carried out in the as-welded condition.
- (4) The gauge length of tensile specimens is 4 x D (where D is the diameter) for testing at room temperature.
- (5) Unless otherwise specified, prebend heat treatment is followed by furnace cooling.
- (6) Unless otherwise specified, the testing method is as per AWS standard.
- (7) All mechanical and chemical data are given separately as "Example" (one of the manufacturer's laboratory test data) and "Quantity" (the quantity value as per AWS standard). Tensile strength and 0.2% yield strength are rounded as 50 unit.

4. The weight per piece of covered electrode shows an approximate weight.

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For your further information of welding consumable specifications, classifications, approvals and packages, please contact the nearest Kobelco office or sales representative.

Abbreviations and marks with definitions

The welding handbook uses the following abbreviations and marks if necessary.

Abbrev. and mark	Definition	Abbrev. and mark	Definition
AC	Alternating current for Arc welding	BL	Number of layers
AS	As per	BR	As required
AP	As position	CS	Outer diameter
AW	As welded	CS	Oil quenching
Bul	Balance	CS	Oil strength
CR	Cooling rate	CS	One side welding
DBE	Distance between electrodes	CS	Plasma
DC	Direct current	CS	Preheat
DC-EN	DC, electrode negative	CS	Plate thickness
DC-EP	DC, electrode positive	CS	Prebend heat treatment
Da	Diameter	CS	Reduction of area
EW	Electrodes are welding	CS	Reheating conditions
EV	Evaporation	CS	Root gap
Fl	Submerged fluxes	CS	Room temperature
F	Flat position	CS	Submerged arc welding
FC	Furnace cooling	CS	Shielding gas
FCW	Full-cover wire	CS	Shielded metal arc welding
F-CW	Full-cover Arc Welding	CS	Stress relief
GO	Grout design	CS	Solid wire
GMW	Gas Metal Arc Welding	CS	Trailing electrode
GS	Grout size	CS	Tungsten inert gas
G-TAG	Gas Tungsten Arc Welding	CS	Tensile strength
H	Horizontal position	CS	Test temperature
HAZ	Heat-affected zone	CS	Vertical position
HP	Horizontal fillet	CS	Vertical down position
IP	Heat input	CS	Vertical up position
IT	High tensile	CS	Welding position
Ma	Hardness (JIS-H)	CS	Water quenching
MP	Storage temperature	CS	Yield point
IV	Impact value	CS	Maximum
L	Length	CS	Minimum
LI	Leading electrode		
LI	Side view		
NS	Number of electrode		

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