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(JWES/JSA)

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high tensile strength steel and
low temperature service steel**

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In the event of any doubts arising as to the contents,
the original JIS is to be the final authority.

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Foreword

This translation has been made based on the original Japanese Industrial Standard revised by the Minister of Economy, Trade and Industry through deliberations at the Japanese Industrial Standards Committee as the result of proposal for revision of Japanese Industrial Standard submitted by The Japan Welding Engineering Society (JWES)/Japanese Standards Association (JSA) with the draft being attached, based on the provision of Article 12 Clause 1 of the Industrial Standardization Law applicable to the case of revision by the provision of Article 14.

Consequently **JIS Z 3211**:2000 is replaced with this Standard. Also, **JIS Z 3212**:2000 and **JIS Z 3241**:1999 are withdrawn and replaced with this Standard.

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Covered electrodes for mild steel, high tensile strength steel and low temperature service steel

Introduction

This Japanese Industrial Standard has been prepared based on the second edition of **ISO 2560** published in 2002 and the first edition of **ISO 18275** published in 2005 with some modifications of the technical contents. **ISO 2560** is a combined standard of **EN 499** and the standard used around the Pacific Rim, and **ISO 18275** is a combined standard of **EN 757** and the standard used around the Pacific Rim. Either of them may be used in different global markets. According to this, this Standard gives requirements corresponding to the standards used in Pacific Rim (system B of **ISO 2560** and system B of **ISO 18275**) in the text, and those of **EN 499** and **EN 757** (system A of **ISO 2560** and system A of **ISO 18275**) in Annex A and Annex B for reference.

The portions given sidelines or dotted underlines are the matters in which the contents of the corresponding International Standards have been modified. A list of modifications with the explanations is given in Annex JA.

1 Scope

This Standard specifies the covered electrodes (hereafter referred to as “electrodes”) to be used for welding of mild steel, high tensile strength steel whose tensile strength is between 490 MPa grade and 830 MPa grade and low temperature service steel.

NOTE : The International Standards corresponding to this Standard are as follows.

ISO 2560:2002 *Welding consumables—Covered electrodes for manual metal arc welding of non-alloy and fine grain steels—Classification*

ISO 18275:2005 *Welding consumables—Covered electrodes for manual metal arc welding of high-strength steels—Classification*

(Overall evaluation: MOD)

In addition, symbols which denote the degree of correspondence in the contents between the relevant International Standards and **JIS** are IDT (identical), MOD (modified), and NEQ (not equivalent) according to **ISO/IEC Guide 21**.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this Standard. The most recent editions of the standards (including amendments) indicated below shall be applied.

JIS G 0321 *Product analysis and its tolerance for wrought steel*

JIS G 3101 *Rolled steels for general structure*

JIS G 3106 *Rolled steels for welded structure*

JIS G 3126 *Carbon steel plates for pressure vessels for low temperature service*