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(JWES/JSA)

**Covered electrodes for molybdenum steel
and chromium molybdenum 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 3223 : 2006 is replaced with this Standard.

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Introduction

This Japanese Industrial Standard has been prepared based on the second edition of ISO 3580 published in 2004 with some modifications of the technical contents. ISO 3580 is a combined standard of EN 1599 and the standard used around the Pacific Rim, and either of them may be used in different global markets. According to this, this Standard gives requirements corresponding to the Pacific Rim (System B of ISO 3580) in the text, and those of EN 1599 (System A of ISO 3580) in Annex A.

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

1 Scope

This Standard specifies the covered electrodes used after the execution of the post weld heat treatment for the ferritic and martensitic creep-resisting molybdenum steel and chromium molybdenum steel of low alloy steel (hereafter referred to as "electrodes").

NOTE: The International Standard corresponding to this Standard and the symbol of degree of correspondence are as follows.

ISO 3580:2004 *Welding consumables—Covered electrodes for manual metal arc welding of creep-resisting steels—Classification (MOD)*

In addition, symbols which denote the degree of correspondence in the contents between the relevant International Standard and JIS are IDT (identical), MOD (modified), and NEQ (not equivalent) according to ISO/IEC Guide 21-1.

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 Z 3001-1 *Welding and allied processes—Vocabulary—Part 1: General*

JIS Z 3001-2 *Welding and allied processes—Vocabulary—Part 2: Welding processes*