



JAPANESE
INDUSTRIAL
STANDARD

Translated and Published by
Japanese Standards Association

JIS Z 3317 : 2011

(JWES/JSA)

**Solid wire electrodes, wires and
rods for gas-shielded arc welding
of molybdenum steel and chromium
molybdenum steel**

ICS 25.160.20

Reference number : **JIS Z 3317 : 2011 (E)**

Date of Establishment: 1985-04-01

Date of Revision: 2011-03-22

Date of Public Notice in Official Gazette: 2011-03-22

Investigated by: Japanese Industrial Standards Committee
Standards Board
Technical Committee on Welding

JIS Z 3317:2011, First English edition published in 2012-10

Translated and published by: Japanese Standards Association
4-1-24, Akasaka, Minato-ku, Tokyo, 107-8440 JAPAN

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

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Printed in Japan

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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 3317:2007** is replaced with this Standard.

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Solid wire electrodes, wires and rods for gas-shielded arc welding of molybdenum steel and chromium molybdenum steel

Introduction

This Japanese Industrial Standard has been prepared based on the first edition of **ISO 21952** published in 2007 with some modifications of the technical contents. **ISO 21952** is a combined standard of **EN 12070** and the standard used around the Pacific Rim. Either or both of the standards may be applied to the specific global markets. According to this, this Standard gives requirements corresponding to the standards used in Pacific Rim (**ISO 21952** System B) in the text, and those corresponding to **EN 12070** (**ISO 21952** System A) in Annex A for information.

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 solid rods and solid wires (hereafter generically referred to as “filler metals”) used for TIG welding, and solid wires used for MAG welding and MIG welding of molybdenum steel and chromium molybdenum steel.

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

ISO 21952:2007 *Welding consumables—Wire electrodes, wires, rods and deposits for gas-shielded arc welding of creep-resisting steels—Classification* (MOD)

The 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 0203 *Glossary of terms used in iron and steel (Products and quality)*

JIS G 0320 *Standard test method for heat analysis of steel products*

JIS G 3103 *Carbon steel and molybdenum alloy steel plates for boilers and pressure vessels*

JIS G 4109 *Chromium-molybdenum alloy steel plates for boilers and pressure vessels*