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Flux cored wires for MAG welding of 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 3318** : 2007 is replaced with this Standard.

Attention is drawn to the possibility that some parts of this Standard may conflict with a patent right, application for a patent after opening to the public, utility model right or application for registration of utility model after opening to the public which have technical properties. The relevant Minister and the Japanese Industrial Standards Committee are not responsible for identifying the patent right, application for a patent after opening to the public, utility model right or application for registration of utility model after opening to the public which have the said technical properties.

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Introduction

This Japanese Industrial Standard has been prepared based on the first edition of **ISO 17634** published in 2004 with some modifications of the technical contents. **ISO 17634** is a combined standard of **EN 12071** and the standards 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 17634**) in the text, and those of **EN 12071** (System A of **ISO 17634**) in Annex A.

The portions given 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 flux cored wires for MAG welding used in the post-weld heat-treated condition for the creep-resisting molybdenum steel and chromium molybdenum steel of low alloy steel (hereafter referred to as "wires").

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

ISO 17634:2004 *Welding consumables–Tubular cored electrodes for gas shielded 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 3103 *Carbon steel and molybdenum alloy steel plates for boilers and pressure vessels*

JIS G 3106 *Rolled steels for welded structure*

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