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(JWES/JSA)

**Stainless steel flux cored wires and  
rods for arc welding**

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In the event of any doubts arising as to the contents,  
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## Foreword

This Japanese Industrial Standard has been 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 a draft being attached, based on the provision of Article 12, paragraph (1) of the Industrial Standardization Act applied mutatis mutandis pursuant to the provision of Article 16 of the said Act. This edition replaces the previous edition (**JIS Z 3323** : 2007), which has been technically revised.

However, **JIS Z 3323** : 2007 may be applied in the **JIS** mark certification based on the relevant provisions of Article 30, paragraph (1), etc. of the Industrial Standardization Act until 19 July 2022.

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# Stainless steel flux cored wires and rods for arc welding

## Introduction

This Japanese Industrial Standard has been prepared based on **ISO 17633** : 2017, Edition 3, with some modifications of the technical contents. **ISO 17633** is a combined standard of the standard used in Europe and the standard used around the Pacific Rim, either or both of which may be used in different global markets. Therefore, this Standard gives the parts corresponding to the standard used around the Pacific Rim (System B of **ISO 17633**) in the main body, and the parts corresponding to the standard used in Europe (System A of **ISO 17633**) in Annex JA for reference.

The vertical lines on both sides and dotted underlines indicate changes from the corresponding International Standard. A list of modifications with the explanations is given in Annex JB.

## 1 Scope

This Standard specifies requirements for the following stainless steel flux cored electrodes (hereafter referred to as electrodes) and cored rods for gas tungsten arc welding (hereafter referred to as rods) which generate the deposited metal of chromium not less than 10.5 % (mass fraction) and nickel not more than 37.0 % (mass fraction).

- Flux cored electrodes for gas-shielded arc welding
- Metal cored electrodes for gas-shielded arc welding
- Flux cored electrodes for self-shielded arc welding
- Cored rods for gas tungsten arc welding

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

ISO 17633 : 2017 *Welding consumables — Tubular cored electrodes and rods for gas shielded and non-gas shielded metal arc welding of stainless and heat-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*