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**Electroslag welding wires and fluxes
for mild steel and high strength steel**

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Mita MT Building, 3-13-12, Mita, Minato-ku, Tokyo, 108-0073 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) 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 3353** : 2007 is replaced with this Standard.

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Electroslag welding wires and fluxes for mild steel and high strength steel

Introduction

This Japanese Industrial Standard was established in 1999 as the specification of welding consumables used in electroslag welding with non-consumable nozzle and consumable nozzle (hereafter referred to as “welding consumables”), and has gone through two revisions up to the present. The last revision was made in 2007, and the revision at this time is to respond to the addition of materials of property class conforming to newly developed high strength steel, reflection of revised contents of normative references, and addition of metal-cored wires as the form of wires.

1 Scope

This Standard specifies solid wires and metal-cored wires (both are hereafter referred to as “wires”), fluxes and consumable nozzles which are used in electroslag welding of mild steel and high strength steel of 490 MPa to 590 MPa in tensile strength class.

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 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 3115 *Steel plates for pressure vessels for intermediate temperature service*
- JIS G 3129 *High tensile strength steel for tower structural purposes*
- JIS G 3136 *Rolled steels for building 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*
- JIS Z 3111 *Methods of tension and impact tests for deposited metal*
- JIS Z 3200 *Welding consumables — Technical delivery conditions for welding filler materials — Type of product, dimensions, tolerances and markings*