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Welding consumables — Deposition of a weld metal pad for chemical analysis

*Produits consommables pour le soudage — Exécution d'un dépôt de
métal fondu pour l'analyse chimique*



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Foreword

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This document was prepared by IIW, *International Institute of Welding*, Commission II, *Arc Welding and Filler Metals*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding and allied processes*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This fourth edition cancels and replaces the third edition (ISO 6847:2013), which has been technically revised.

The main change compared to the previous edition is the addition of provisions for strip-flux combinations for use with cladding with the submerged arc welding and electroslag welding processes.

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Introduction

The first edition of this document, ISO 6847:1985, addressed only the deposition of a weld metal pad for chemical analysis using covered electrodes for manual arc welding. This pad preparation was expensive to execute. IIW Commission II conducted testing of several methods of weld pad preparation that were less costly to execute than that of ISO 6847:1985 and yet produced equivalent results. Further, these methods were applicable to solid wires for gas shielded welding, to tubular cored wires for arc welding with or without gas shielding, and to wires and fluxes for submerged arc welding, as well as being applicable to covered electrodes. Accordingly, subsequent revisions (ISO 6847:2000 and ISO 6847:2013) simplified weld pad preparation and broadened the range of welding processes and filler metals. This document adds the use of strip with the submerged arc welding and electroslag welding processes.