



INTERNATIONAL STANDARD ISO 18275:2005 TECHNICAL CORRIGENDUM 1

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INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Welding consumables — Covered electrodes for manual metal arc welding of high-strength steels — Classification

TECHNICAL CORRIGENDUM 1

Produits consommables pour le soudage — Électrodes enrobées pour le soudage manuel à l'arc des aciers à haute résistance — Classification

RECTIFICATIF TECHNIQUE 1

Technical Corrigendum 1 to ISO 18275:2005 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 3, *Welding consumables*.

Requests for official interpretations of any aspect of Technical Corrigendum 1 to ISO 18275:2005 should be directed to the Secretariat of ISO/TC 44/SC 3 via your national standards body. A complete listing of these bodies can be found at www.iso.org.

Pages 9, 10, Table 8B

Replace Table 8B with the version appearing in this Technical Corrigendum. In addition to changed headings for columns 2 to 5, certain table entries, indicated in bold type, have been updated.

Table 8B — Mechanical test requirements
(Classification by tensile strength and 27 J impact energy)

Classification, compulsory section	Tensile strength MPa	Yield strength ^a MPa	Minimum elongation ^b %	Temperature for 27 J Charpy V-notch test °C
E5916-3 M2 A and/or P	590	490	16	– 20
E5916-N1M1 A and/or P	590	490	16	– 20
E5916-N5M1 A and/or P	590	490	16	– 60
E5918-N1M1 A and/or P	590	490	16	– 20
E6210-G A and/or P	620	530	15	N.S.
E6211-G A and/or P	620	530	15	N.S.
E6213-G A and/or P	620	530	12	N.S.
E6215-G A and/or P	620	530	15	N.S.
E6216-G A and/or P	620	530	15	N.S.
E6218-G A and/or P	620	530	15	N.S.
E6215-N13L P	620	530	15	– 115
E6215-3 M2 P	620	530	15	– 50
E6216-3 M2 A and/or P	620	530	15	– 20
E6216-N1M1 A and/or P	620	530	15	– 20
E6216-N2M1 A and/or P	620	530	15	– 20
E6216-N4M1 A and/or P	620	530	15	– 40
E6216-N5M1 A and/or P	620	530	15	– 60
E6218-3 M2 P	620	530	15	– 50
E6218-3 M3 P	620	530	15	– 50
E6218-N1M1 A and/or P	620	530	15	– 20
E6218-N2M1 A and/or P	620	530	15	– 20
E6218-N3M1 A	620	540 to 620 ^c	21	– 50
E6910-G A and/or P	690	600	14	N.S.
E6911-G A and/or P	690	600	14	N.S.
E6913-G A and/or P	690	600	11	N.S.
E6915-G A and/or P	690	600	14	N.S.
E6916-G A and/or P	690	600	14	N.S.
E6918-G A and/or P	690	600	14	N.S.
E6915-4 M2 P	690	600	14	– 50
E6916-4 M2 P	690	600	14	– 50
E6916-N3CM1 A	690	600	14	– 20
E6916-N4M3 A and/or P	690	600	14	– 20
E6916-N7CM3 A	690	600	14	– 60
E6918-4 M2 P	690	600	14	– 50