

JAPANESE
INDUSTRIAL
STANDARD

Translated and Published by
Japanese Standards Association

JIS Z 3225 : 1999

Covered electrodes for
9% nickel steel

ICS 25.160.20

Descriptors : arc welding, covered electrodes, nickel steels, filler metal, welding rods

Reference number : JIS Z 3225 : 1999 (E)



Documents

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Foreword

This translation has been made based on the original Japanese Industrial Standard revised by the Minister of International Trade and Industry through deliberations at the Japanese Industrial Standards Committee in accordance with the Industrial Standardization Law. Consequently **JIS Z 3225 : 1990** is replaced with **JIS Z 3225 : 1999**.

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.

This revision employs **JIS Z 3200 : 1999** *Welding consumables—Technical delivery conditions for welding filler metals—Type of product, dimensions, tolerances and marking* as the normative reference.

Date of Establishment: 1985-03-01

Date of Revision: 1999-09-20

Date of Public Notice in Official Gazette: 1999-09-20

Investigated by: Japanese Industrial Standards Committee
Divisional Council on Welding

JIS Z 3225:1999, First English edition published in 2002-02

Translated and published by: Japanese Standards Association
4-1-24, Akasaka, Minato-ku, Tokyo, 107-8440 JAPAN

In the event of any doubts arising as to the contents,
the original JIS is to be the final authority.

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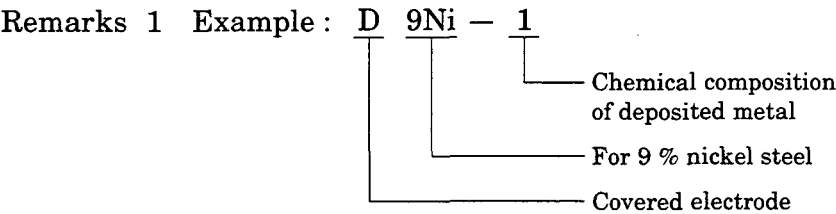
Printed in Japan

Covered electrodes for 9% nickel steel

- 1 Scope** This Japanese Industrial Standard specifies the high nickel type covered electrodes (hereafter referred to as “electrodes”) used for welding 9 % nickel steel.
- 2 Normative references** The standards listed in Attached Table 1 contain provisions which, through reference in this Standard, constitute provisions of this Standard. The most recent editions of the standards shall be applied.
- 3 Classification** The electrodes shall be classified as given in Table 1 according to the chemical composition of deposited metal.

Table 1 Classification of electrodes

Classification	Welding position	Type of current
D9Ni-1	F, V, O, H	AC or DC (+)
D9Ni-2		



- 2 The symbols used for welding positions mean the following:
- F: flat, V: vertical, O: overhead, H: horizontal or horizontal fillet.
- However, V and O of the welding positions as given in Table 1 are, as a rule, not applicable to the electrode rod diameter of 5.0 mm (hereafter referred to as “diameter”).
- 3 The symbols used for the type of current mean the following:
- AC: alternating current, DC (+): direct current (electrode positive)

4 Quality

4.1 Covering The covering shall be in accordance with 3 of JIS Z 3200.

4.2 Chemical composition The deposited metal shall be tested in accordance with the method specified in 6.2 and the determined chemical composition shall comply with the specifications of Table 2.

In addition, elements other than those given in Table 2 may be added, if necessary, in the range that the said elements are not more than 0.50 % in total, provided that the added elements are analyzed.