

JAPANESE
INDUSTRIAL
STANDARD

Translated and Published by
Japanese Standards Association

JIS Z 3326 : 1999

**Arc welding flux cored wires
for hardfacing**

ICS 25.160.20

Descriptors : steels, iron, arc-welding equipment, filler wire, fluxes (materials), metal-arc welding

Reference number : JIS Z 3326 : 1999 (E)

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 3326 : 1991** is replaced with **JIS Z 3326 : 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 a normative reference.

Date of Establishment: 1991-03-01

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 3326 : 1999, First English edition published in 2002-05

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,
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Printed in Japan

Arc welding flux cored wires for hardfacing

1 Scope This Japanese Industrial Standard specifies flux cored wires (hereafter referred to as "wires") for gas-shielded arc welding and self-shielded arc welding used for the purpose of hardfacing iron and steel products.

2 Normative references The standards given 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.

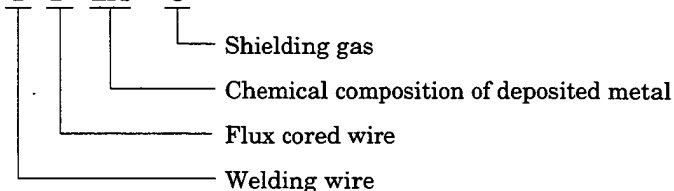
3 Classification Wires shall be classified as shown in Table 1 according to the kind of shielding gas and the chemical composition of deposited metal.

Table 1 Classification of wires

Wire	Shielding gas	Wire	Shielding gas
YF2A-C	Carbonic acid gas or mixed gas consisting of argon containing 20 % or more carbonic acid gas (CO ₂ or Ar-CO ₂)	YF2A-G	Not specified.
YF3B-C		YF3B-G	
YF4A-C		YF4A-G	
YF4B-C		YF4B-G	
YFMA-C		YFMA-G	
YFME-C		YFME-G	
YFCrA-C		YFCrA-G	
		YF2A-S	Not used. (self-shielding)
		YF3B-S	
		YFCrA-S	

Remarks : The symbols for classification shall be as shown in the following example.

Example : Y F 2A - C



4 Quality

4.1 Wires The appearance and condition of wires shall be in accordance with clause 3 of JIS Z 3200.

4.2 Chemical composition The chemical composition of the deposited metal shall be tested according to 7.2 and shall meet the requirements of Table 2 according to the respective classes of wires.