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STANDARD

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JIS Z 3333 : 1999

**Submerged arc welding solid wires
and fluxes for 9 % nickel steel**

ICS 25.160.20

Descriptors : submerged arc welding, filler wire, welding rods, welding electrodes,
fluxes (materials), nickel steels

Reference number : JIS Z 3333 : 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 3333 : 1991** is replaced with **JIS Z 3333 : 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: 1985-04-01

Date of Revision: 1999-09-20

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Divisional Council on Welding

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In the event of any doubts arising as to the contents,
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Submerged arc welding solid wires and fluxes for 9 % nickel steel

1 Scope This Japanese Industrial Standard specifies welding solid wires of high nickel content and fluxes to be used in submerged arc welding of 9 % nickel steel (hereafter referred to as “wires and fluxes”).

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.

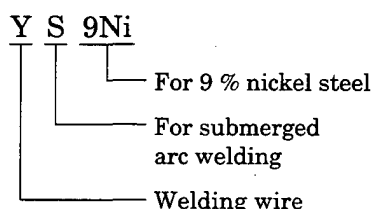
3 Classification Wires and fluxes shall be classified as given in Table 1 according to the welding position.

Table 1 Classification

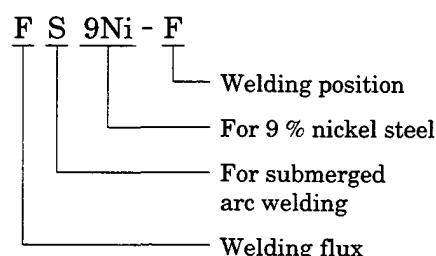
Classification		Welding position
Wire	Flux	
YS9Ni	FS9Ni-F	F
	FS9Ni-H	F, H

Remarks 1 The symbols used for classification mean the following:

Example 1 (Wire)



Example 2 (Flux)



2 The symbols used for the welding position mean the following:

F : Flat

H : Horizontal or horizontal fillet

4 Quality

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

4.2 Fluxes Fluxes shall be uniform in quality, supplied smoothly during welding, and develop good bead appearance and shape.

4.3 Chemical composition Chemical composition of deposited metal obtained by a combination of wires and fluxes (hereafter referred to as “deposited metal”) shall be tested in accordance with 7.2 and shall conform to Table 2.