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# NATIONAL STANDARD OF THE PEOPLE'S REPUBLIC OF CHINA

**GB/T 12470-2003**

**Replace** GB/T 12470-1990

# Low-alloy steel electrodes and fluxes for submerged arc welding

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# Contents

## Forward

This Standard replaces GB/T 12470-1990 *Fluxes for the submerged arc welding of low alloy steel*.

This Standard, compared with GB/T 12470-1990, has the main changes as follows:

- Increased requirements on electrodes;

- Model classification is not divided according to slag types any longer, but American standard model classification method is adopted;

- F48XX-HXXX model yield strength is required to be improved to not less than 400MPa from not less than 380MPa.

This Standard's Annex A and Annex B are informative annexes.

This Standard was proposed by China Machinery Industry Federation.

This Standard is under the jurisdiction of National Technical Committee on Welding of Standardization Administration of China.

Drafting unit of this Standard: National Welding Consumables Quality Supervision and Inspection Center, Hunan Yongzhou Haling Welding Equipment Co., Ltd., Guangxi Yizhou Guixing Welding Consumables Co., Ltd., Luoyang Mudan Welding Materials Co., Ltd., Jinzhou Tech Welding Consumables Co., Ltd., Tianjin Bridge Welding Materials Co., Ltd.

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# Low-alloy steel electrodes and fluxes for submerged arc welding

## 1 Scope

This Standard specifies model category, technical requirements, test methods and inspection rules, etc. of low-alloy steel electrodes and fluxes for submerged arc welding.

## 2 Normative references

The terms in the following documents become the terms of the Standard through quotation in the Standard. Dated reference documents, its subsequent modification list (excluding corrigendum) or revised edition are not applicable to this Standard; however, parties who have reached agreement based on this Standard are encouraged to investigate the possibility of applying the latest editions of these documents. The latest editions of the undated references shall be applicable to this Standard.

GB/T 700 Carbon Structural Steel

GB/T 1591 Low-alloy and High Strength Structural Steel (neq ISO 4950)

GB/T 2650 Impact test method of welded joint

GB/T 2652 Test method of welding line and elongation of deposited metal

GB/T 3323 Radiographs and Quality Classification for Steel Melting Welded Butt Joints

GB/T 3429 Wire rod for electrode

GB/T 3965 Method for determination of diffusion hydrogen in deposited metal

GB/T 14957 Steel Wire for Fusion Welding

JB/T 7948.8 Methods for chemical analysis of melted welding fluxes The "molybdenum blue" photometric method for determination of phosphorus content

JB/T 7948.11 Methods for chemical analysis of melted welding fluxes-combustion-photometric method for determination of phosphorus content

## 3 Model category

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