

JIS

JAPANESE
INDUSTRIAL
STANDARD

Translated and Published by
Japanese Standards Association

JIS Z 3221 : 2021

(JWES/JSA)

Stainless steel covered electrodes

ICS 25.160.20

Reference number : JIS Z 3221 : 2021 (E)

Z 3221 : 2021

Date of Establishment: 1957-01-30

Date of Revision: 2021-07-20

Date of Public Notice in Official Gazette: 2021-07-20

Investigated by: Japanese Industrial Standards Committee

Standards Board for ISO area

Technical Committee on Metal and Inorganic Materials

JIS Z 3221 : 2021, First English edition published in 2022-08

Translated and published by: Japanese Standards Association
Mita MT Building, 3-13-12, Mita, Minato-ku, Tokyo, 108-0073 JAPAN

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Printed in Japan

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Contents

	Page
Introduction	1
1 Scope	1
2 Normative references	1
3 Terms and definitions	2
4 Classification	2
5 Quality	3
5.1 Dimensions, dimensional tolerances and product conditions	3
5.2 Chemical composition of deposited metal	3
5.3 Mechanical properties of deposited metal	8
5.4 Welding position adaptability	9
6 Test methods	10
6.1 Determination of lot	10
6.2 General requirements for tests	10
6.3 Chemical analysis for deposited metal	11
6.4 Tensile test for deposited metal	11
6.5 Fillet weld test	12
7 Inspection	13
8 Designation of product	13
9 Marking	14
9.1 Marking on product	14
9.2 Marking on packages	15
10 Packaging	15
11 Certificate of inspection	15
Annex JA (informative) ISO 3581 System A	16
Annex JB (informative) Comparison table between JIS and corresponding International Standard	27

Foreword

This Japanese Industrial Standard has been revised by the Minister of Economy, Trade and Industry through deliberations at the Japanese Industrial Standards Committee as the result of proposal for revision of Japanese Industrial Standard submitted by The Japan Welding Engineering Society (JWES)/Japanese Standards Association (JSA) with a draft being attached, based on the provision of Article 12, paragraph (1) of the Industrial Standardization Act applied mutatis mutandis pursuant to the provision of Article 16 of the said Act. This edition replaces the previous edition (**JIS Z 3221** : 2013), which has been technically revised.

However, **JIS Z 3221** : 2013 may be applied in the **JIS** mark certification based on the relevant provisions of Article 30, paragraph (1), etc. of the Industrial Standardization Act until 19 July 2022.

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Stainless steel covered electrodes

Introduction

This Japanese Industrial Standard has been prepared based on **ISO 3581 : 2016**, Edition 3, with some modifications of the technical contents. **ISO 3581** is a combined standard of the standard used in Europe and the standard used around the Pacific Rim, either or both of which may be used in different global markets. Therefore, this Standard gives the parts corresponding to the standard used around the Pacific Rim (System B of **ISO 3581**) in the main body, and the parts corresponding to the standard used in Europe (System A of **ISO 3581**) in Annex JA for reference.

The vertical lines on both sides and dotted underlines indicate changes from the corresponding International Standard. A list of modifications with the explanations is given in Annex JB.

1 Scope

This Standard specifies requirements for stainless steel covered electrodes (hereafter referred to as electrodes) which generate the deposited metal of chromium not less than 11.0 % (mass fraction) and nickel not more than 37.0 % (mass fraction).

NOTE 1 Requirements for electrodes having low-temperature toughness at $-196\text{ }^{\circ}\text{C}$ are specified in **JIS Z 3227**.

NOTE 2 The International Standard corresponding to this Standard and the symbol of degree of correspondence are as follows.

ISO 3581 : 2016 *Welding consumables — Covered electrodes for manual metal arc welding of stainless and heat-resisting steels — Classification* (MOD)

In addition, symbols which denote the degree of correspondence in the contents between the relevant International Standard and **JIS** are IDT (identical), MOD (modified), and NEQ (not equivalent) according to **ISO/IEC Guide 21-1**.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this Standard. The most recent editions of the standards (including amendments) indicated below shall be applied.

JIS G 0321 *Product analysis and its tolerance for wrought steel*

JIS G 1201 *Iron and steel — General rules for analytical methods*

JIS G 3101 *Rolled steels for general structure*

JIS G 3106 *Rolled steels for welded structure*

JIS G 4304 *Hot-rolled stainless steel plate, sheet and strip*