



BSI Standards Publication

Welding consumables — Welding consumables for hard-facing

National foreword

This British Standard is the UK implementation of EN 14700:2022. It supersedes BS EN 14700:2014, which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee WEE/39, Welding consumables.

A list of organizations represented on this committee can be obtained on request to its committee manager.

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EUROPEAN STANDARD

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NORME EUROPÉENNE

EUROPÄISCHE NORM

November 2022

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Supersedes EN 14700:2014

English Version

Welding consumables - Welding consumables for hard-facing

Produits consommables de soudage - Produits
consommables pour le rechargement dur

Schweißzusätze - Schweißzusätze zum Hartauftragen

This European Standard was approved by CEN on 30 October 2022.

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European foreword

This document (EN 14700:2022) has been prepared by Technical Committee CEN/TC 121 “Welding and allied processes”, the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by May 2023, and conflicting national standards shall be withdrawn at the latest by May 2023.

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1 Scope

This document is applicable to welding consumables for hardfacing. The range of application includes surfaces of new structural components, semi-finished products as well as repair of surfaces of structural components which have to resist to mechanical, chemical, thermal or combined stress.

This document specifies requirements for classification of the consumables based on their chemical composition of the all-weld metal of covered electrodes, cored wires, cored rods, cored strips, sintered strips, sintered rods and metal powders and on the chemical composition of solid wires, solid rods, solid strips and cast rods.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN ISO 544, *Welding consumables - Technical delivery conditions for filler materials and fluxes - Type of product, dimensions, tolerances and markings (ISO 544)*

EN ISO 6506-1, *Metallic materials - Brinell hardness test - Part 1: Test method (ISO 6506-1)*

EN ISO 6506-2, *Metallic materials - Brinell hardness test - Part 2: Verification and calibration of testing machines (ISO 6506-2)*

EN ISO 6506-3, *Metallic materials - Brinell hardness test - Part 3: Calibration of reference blocks (ISO 6506-3)*

EN ISO 6506-4, *Metallic materials - Brinell hardness test - Part 4: Table of hardness values (ISO 6506-4)*

EN ISO 6508-1, *Metallic materials - Rockwell hardness test - Part 1: Test method (ISO 6508-1)*

EN ISO 6508-2, *Metallic materials - Rockwell hardness test - Part 2: Verification and calibration of testing machines and indenters (ISO 6508-2)*

EN ISO 6508-3, *Metallic materials - Rockwell hardness test - Part 3: Calibration of reference blocks (ISO 6508-3)*

EN ISO 6847, *Welding consumables - Deposition of a weld metal pad for chemical analysis (ISO 6847)*

EN ISO 14174:2019, *Welding consumables - Fluxes for submerged arc welding and electroslag welding - Classification (ISO 14174:2019)*

EN ISO 14175:2008, *Welding consumables - Gases and gas mixtures for fusion welding and allied processes (ISO 14175:2008)*

EN ISO 14344, *Welding consumables - Procurement of filler materials and fluxes (ISO 14344)*

EN ISO 80000-1:2013, *Quantities and units - Part 1: General (ISO 80000-1:2009 + Cor 1:2011)*