

A NUMBERS CLASSIFICATION OF WELD METAL ANALYSIS FOR PROCEDURE QUALIFICATION

QW	A No.	TYPES OF WELD DEPOSIT	ANALYSIS*					
			C%	Cr%	Mo%	Ni%	Mn%	Si%
442	1	Mild Steel	0.15				1.60	1.00
	2	Carbon-Moly	0.15	0.50	0.40-0.65		1.60	1.00
	3	Chrome (0.4 to 2%)- Moly	0.15	0.40-2.00	0.40-0.65		1.60	1.00
	4	Chrome (2to6%)- Moly	0.15	2.00-6.00	0.40-1.50		1.60	2.00
	5	Chrome (6 to 10.5%)- Moly	0.15	6.00-10.50	0.40-1.50		1.20	2.00
	6	Chrome-Martensitic	0.15	11.00-15.00	0.70		2.00	1.00
	7	Chrome-Ferritic	0.15	11.00-30.00	1.00		1.00	3.00
	8	Chromium-Nickel	0.15	14.50-30.00	4.00	7.50-15.00	2.50	1.00
	9	Chromium-Nickel	0.30	25.00-30.00	4.00	15.00-37.00	2.50	1.00
	10	Nickel to 4%	0.15		0.55	0.80-4.00	1.70	1.00
	11	Manganese-Moly	0.17		0.25-0.75	0.85	1.25-2.25	1.00
	12	Nickel-Chrome-Moly	0.15	1.50	0.25-0.80	1.25-2.80	0.75-2.25	1.00

F NUMBERS GROUPING OF ELECTRODES AND WELDING RODS FOR QUALIFICATION

QW	F No.	ASME SPECIFICATION No.	AWS CLASSIFICATION No.
432.1	1	SFA 5.1 & 5.5	EXX20, EXX24, EXX27, EXX28
	2	SFA 5.1 & 5.5	EXX12, EXX13, EXX14
	3	SFA 5.1 & 5.5	EXX10, EXX11
	4	SFA 5.1 & 5.5	EXX15, EXX16, EXX18
	4	SFA 5.4 NOM TOTAL ALLOY 6% OR LESS	EXX15, EXX16
	4	SFA 5.4 NOM TOTAL ALLOY MORE THAN 6%	EXX15, EXX16
	5	SFA 5.4 Cr-Ni ELECTRODE	EXX15, EXX16
	6	SFA 5.2	RGXX
	6	SFA 5.17	FXX-XXXX
	6	SFA 5.9	ERXX
	6	SFA 5.18	EXXS-X, EXXU-X
	6	SFA 5.20	EXXT-X
	6	SFA 5.22	EXXT-X
	6	SFA 5.23	FXX-EXXX-X, FXX-ECXXX-X AND FXX-EXXX-XN, FXX-ECXXX-XN
	6	SFA 5.28	ER-XXX-X AND E-XXX-X

