



**INTERNATIONAL STANDARD ISO 18275:2005**  
**TECHNICAL CORRIGENDUM 1**

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INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

**Welding consumables — Covered electrodes for manual metal arc welding of high-strength steels — Classification**

**TECHNICAL CORRIGENDUM 1**

*Produits consommables pour le soudage — Électrodes enrobées pour le soudage manuel à l'arc des aciers à haute résistance — Classification*

*RECTIFICATIF TECHNIQUE 1*

Technical Corrigendum 1 to ISO 18275:2005 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 3, *Welding consumables*.

Requests for official interpretations of any aspect of Technical Corrigendum 1 to ISO 18275:2005 should be directed to the Secretariat of ISO/TC 44/SC 3 via your national standards body. A complete listing of these bodies can be found at [www.iso.org](http://www.iso.org).

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*Pages 9, 10, Table 8B*

Replace Table 8B with the version appearing in this Technical Corrigendum. In addition to changed headings for columns 2 to 5, certain table entries, indicated in bold type, have been updated.

**Table 8B — Mechanical test requirements**  
(Classification by tensile strength and 27 J impact energy)

Classification, compulsory section	Tensile strength	Yield strength <sup>a</sup>	Minimum elongation <sup>b</sup>	Temperature for 27 J Charpy V-notch test
	MPa	MPa	%	°C
E5916-3 M2 A and/or P	590	490	16	- 20
E5916-N1M1 A and/or P	590	490	16	- 20
E5916-N5M1 A and/or P	590	490	16	- 60
E5918-N1M1 A and/or P	590	490	16	- 20
E6210-G A and/or P	620	530	15	N.S.
E6211-G A and/or P	620	530	15	N.S.
E6213-G A and/or P	620	530	12	N.S.
E6215-G A and/or P	620	530	15	N.S.
E6216-G A and/or P	620	530	15	N.S.
E6218-G A and/or P	620	530	15	N.S.
E6215-N13L P	620	530	15	- 115
E6215-3 M2 P	620	530	15	- 50
E6216-3 M2 A and/or P	620	530	15	- 20
E6216-N1M1 A and/or P	620	530	15	- 20
E6216-N2M1 A and/or P	620	530	15	- 20
E6216-N4M1 A and/or P	620	530	15	- 40
E6216-N5M1 A and/or P	620	530	15	- 60
E6218-3 M2 P	620	530	15	- 50
E6218-3 M3 P	620	530	15	- 50
E6218-N1M1 A and/or P	620	530	15	- 20
E6218-N2M1 A and/or P	620	530	15	- 20
E6218-N3M1 A	620	540 to 620 <sup>c</sup>	21	- 50
E6910-G A and/or P	690	600	14	N.S.
E6911-G A and/or P	690	600	14	N.S.
E6913-G A and/or P	690	600	11	N.S.
E6915-G A and/or P	690	<b>600</b>	14	N.S.
E6916-G A and/or P	690	<b>600</b>	14	N.S.
E6918-G A and/or P	690	<b>600</b>	14	N.S.
E6915-4 M2 P	690	600	14	- 50
E6916-4 M2 P	690	600	14	- 50
E6916-N3CM1 A	690	600	14	- 20
E6916-N4M3 A and/or P	690	600	14	- 20
E6916-N7CM3 A	690	600	14	- 60
E6918-4 M2 P	690	600	14	- 50