

INDEX

FIRMS SUPPLYING CONSUMABLES FOR WELDING IN SHIP CONSTRUCTION

Sections

ARGENTINA

CONARCO S.A. 3 4 5

AUSTRALIA

BOC LIMITED 5
THE LINCOLN ELECTRIC CO (AUSTRALIA) PTY LTD 4 5
WELDING INDUSTRIES OF AUSTRALIA 3 5 9

AUSTRIA

BOHLER SCHWEISSTECHNIK AUSTRIA GMBH 3 5 8

BANGLADESH

BANGLADESH WELDING ELECTRODES LTD 3
BOC BANGLADESH LIMITED DHAKA PLANT 3

BELGIUM

LASTEK BELGIUM N.V. 3 5 8

BOSNIA & HERZEGOVINA, REPUBLIC OF

ELVACO 3
ZICA d.d. 5

BRAZIL

BELGO MINEIRA BEKAERT ARAMES S/A 4 5
ESAB S/A - INDUSTRIA E COMERCIO 3 4 5
GERDAU S.A. 4 5

BULGARIA

"ELECTRODES" JSC 3

CANADA

AIR LIQUIDE CANADA INC 3 5 8
COREX CANADA INC. 3 5
HOBART BROTHERS OF CANADA/ITW CANADA COMPANY 5
INDALCO ALLOYS INC 9
LINCOLN ELECTRIC CO. OF CANADA LTD 3 4 5
LINCOLN ELECTRIC COMPANY OF CANADA LTD (ARCWELD) 3 5
PRAXAIR CANADA INC. 5

CHILE

INDURA S.A. INDUSTRIA Y COMERCIO 3 5
M & H COMERCIAL E INDUSTRIAL LTDA 3 5

CHINA, PEOPLE'S REPUBLIC OF

ADVANCED TECHNOLOGY & MATERIALS CO LTD 5
ATLANTIC CHINA WELDING CONSUMABLES, INC. 3 4 5
BEIJING GANGLIAN WELDING MATERIALS CO LTD 5
BEIJING GOLDEN SUN FLUX-CORED WIRE CO LTD 5
CHANGZHOU CHANGJIANG WELDING MATERIALS CO LTD 5
CHANGZHOU CITY YUNHE WELDING MATERIAL CO LTD 5
CHANGZHOU HUATONG WELDING WIRE CO LTD 4 5
CHANGZHOU JIUTONG WELDING WIRE CO LTD 5
CHANGZHOU ZHENGYANG WELDING MATERIAL CO LTD 5

CHINA, PEOPLE'S REPUBLIC OF

CHANGZHOU ZHONGJIANG WELDING WIRE CO LTD	5
DANDONG JINXIUXIANG WELDING CONSUMABLES CO LTD	3
DATANG SPECIAL WELDING WIRE FACTORY	5
ESAB WELDING PRODUCTS (JIANGSU) CO LTD	5
GUILIN WELDING ELECTRODE FACTORY	3
HANGZHOU WELDING ELECTRODES CO LTD	3
HEBEI YICHEN INDUSTRIAL GROUP CO LTD	5
HULUDAO BOCHUAN SANYING WELDING CO LTD	5
JINGJIANG SAINTEAGLE WELDING DEVELOPMENT CO LTD	5
JINZHOU JIN TAI WELDING & METAL CO LTD	3 4 5 8
JINZHOU SWAN WELDING CONSUMABLE CO LTD	3 4
JIUQUAN IRON & STEEL GROUP LANZHOU CHANGHONG WELDING MATERIAL CO LTD	3 5
KISWEL DALIAN LTD	5
KOBE WELDING OF TANGSHAN CO LTD	5
KUNSHAN GINTUNE WELDING CO LTD	3 5 8
KUNSHAN GINTUNE WELDING CO LTD	8
LONGTOU WELDING FLUX FACTORY	4
MAGNA INDUSTRIAL CO LTD	3
NANTONG CHENGXI WELDING CO LTD	5
NINGBO HAOBANG WELDING INDUSTRY CO LTD	5
SHANGDONG FEILE WELDING PRODUCTS CO LTD	5
SHANGHAI ATLANTIC WELDING CONSUMABLES CO LTD	3 5
SHANGHAI BAOSTEEL METALLURGICAL CONSTRUCTION CORP	4 5
KUNSHAN WELDING WIRE FACTORY	
SHANGHAI DONGQIAO STEEL INDUSTRIAL TECHNOLOGY DEVELOPMENT CO LTD	4 7
SHANGHAI GULLCO INDUSTRIAL CORP.	7
SHANGHAI JIHAOWANG SHIPBUILDING TECHNOLOGY DEVELOPMENT CO LTD	4 7
SHANGHAI WELDING EQUIPMENTS AND CONSUMABLES CO LTD	3 4
SHENZHEN ATLANTIC WELDING ELECTRODE CO LTD	3
SHIJIANZHUANG RADA WELDING MATERIALS CO LTD	5
SHIJIAZHUANG MAGIC WELDING CONSUMABLES CO LTD	3
SHIJIAZHUANG SPECIAL WELDING ELECTRODE FACTORY	3
SUPERTECH (KUNSHAN) CO LTD	3 4 5 7
TAIZHOU UNIVERSE WELDING MATERIAL CO LTD	3 5
THE LINCOLN ELECTRIC (INNER MONGOLIA) WELDING CO LTD	3
THE NANJING LINCOLN ELECTRIC CO LTD	3
THE SHANGHAI LINCOLN ELECTRIC CO LTD	5
TIANJIN BRIDGE WELDING MATERIAL GROUP CO. LTD	3 5
TIANJIN GOLDEN BRIDGE WELDING MATERIALS GROUP CO LTD	3 4 5
TIANJIN GOLDEN BRIDGE WELDING MATERIALS GROUP CO LTD WUXI SHUOFANG BRANCH CO	3 5
TIANJIN MINMETALS CO LTD	3
TIANJIN PERMANENT WELDING CONSUMABLES CO LTD	3
TIANJIN SAINTEAGLE WELDING CO LTD	5
TIANJIN YANQIAO WELDING MATERIALS CO LTD	3
TIEN TAI ELECTRODE (KUNSHAN) CO LTD	3 5 8
TONGSHAN HONGPENG WELDING INDUSTRY CO LTD	4 5
WUHAN ANCHOR WELDING CONSUMABLE CO. LTD. DALIAN BRANCH	3 5
WUHAN ANCHOR WELDING CONSUMABLES CO LTD	3 4 5
WUHAN TIANGAO WELDING CO LTD	7
XIAMEN LUGUANG WELDING CONSUMABLES CO LTD	3
XUZHOU ZHENGQUANG WELDING MATERIAL FACTORY	3 5
ZHANGJIAGANG HENGCHANG PLATING SOLDER FACTORY	5
ZHUZHOU XIANGJIANG WELDING ELECTRODE CO LTD	3
ZIBO QILU WELDING INDUSTRY CO LTD	3
ZIBO TAA WELDING CO LTD	5
ZIGONG ATLANTIC WELDING WIRES CO LTD	5

COLOMBIA

ELECTROMANUFACTURAS S.A. 3

CROATIA

ELEKTRODA ZAGREB D.D 3 5 8

CYPRUS

A. EPIPHANIOU INDUSTRIES LTD. 3 5

CZECH REPUBLIC

ESAB VAMBERK s.r.o. - ESAB 4 5 8

ESAB VAMBERK s.r.o. - FILARC 5 8

EGYPT, ARAB REPUBLIC OF

AL SALEM RODS 4

EGYPTIAN SWEDISH WELDING ELECTRODES CO., S.A.E. 3

INDUSTRIAL GASES CO. 3

KADESIA ENGINEERING INDUSTRIES "BOHLER EGYPT" 3

OERLIKON EGYPT FOR ELECTRODES AND WELDING EQUIPMENT 3 5

THE UNITED FOR TRADING & INDUSTRY (E. EL - GHAZAWI) 3

FINLAND

WALLIUS HITSASKONEET OY 3

FRANCE

AIR LIQUIDE WELDING / BRAND OERLIKON 3 4 5

AIR LIQUIDE WELDING FRANCE/BRAND SAF - FRO 5

LA SOUDURE AUTOGENE FRANCAISE 3 4 5 8

LINCOLN ELECTRIC FRANCE 4

OERLIKON SOUDURE FRANCE 3

SAUVAGEAU COMMERCE SOUDURE 3 4 5 9

SELECTARC INDUSTRIES - FORGES DE SAINT-HIPPOLYTE 3

SOUDAGE AUTOMATIQUE SARL 8

GERMANY, FEDERAL REPUBLIC OF

3 5

BOHLER SCHWEISSTECHNIK DEUTSCHLAND GMBH, HAMM 3 4 5 7 8 9

DRAHTWERK ELISENTAL W. ERDMANN GMBH & CO 9

DRAHTZUG STEIN WIRE & WELDING GMBH & CO KG 4 5 7

DZW DRAHTZIEHEREI WIESENBURG GMBH 5

KJELLBERG ELEKTRODEN & MASCHINEN GMBH 3

METAL TECHNOLOGY-CANTERBO GMBH 9

OERLIKON SCHWEISSTECHNIK GMBH 3 4 5 8 9

UTP SCHWEISSMATERIALIEN GMBH/SOUDOKAY 3

WESTFALISCHE DRAHTINDUSTRIE GMBH, HAMM 5

WESTFALISCHE DRAHTINDUSTRIE GMBH, ROTHENBURG 5

GREECE

ERLIKON WIRE PROCESSING S.A. 3 5

HUNGARY

ESAB-MOR KFT - ARCOS 3

ESAB-MOR KFT - ESAB 3 4

ESAB-MOR KFT - FILARC 3

ESAB-MOR KFT - MUREX 3

ESAB-MOR KFT- VAMBERK 3

WELD-TEAM KFT 5

INDIA

ADOR WELDING LIMITED BHANDUP PLANT	3
ADOR WELDING LIMITED CHENNAI PLANT	3 5
ADOR WELDING LIMITED RAIPUR PLANT	3 5
ADOR WELDING LIMITED SILVASSA PLANT	3
ANAND ARC ELECTRODES (P) LTD	3
CALCUTTA ELECTRODES PRIVATE LIMITED, RAIPUR	3
D & H SECHERON ELECTRODES PRIVATE LTD, DAKACHYA PLANT	3
D & H SECHERON ELECTRODES PRIVATE LTD, KILAMAIDAN PLANT	3
D & H WELDING ELECTRODES (INDIA) LTD	3
DIFFUSION ENGINEERS LIMITED	3 8
DWEKAM ELECTRODES PRIVATE LIMITED	3 4 5
ESAB INDIA LIMITED, AMBATTUR PLANT, CHENNAI	3 4
ESAB INDIA LTD. KALMESHVAR PLANT	5
ESAB INDIA LTD. INDARC PRODUCTS DIVISION KHARDAH PLANT	3
GEE LIMITED	3
GLOBAL ELECTRODES PRIVATE LTD	3
HONAVAR ELECTRODES LTD	3
KM CROWN WELDING CONSUMABLES PVT LTD	3 5
MAGNARC ELECTRODES PVT LTD	3
MAILAM INDIA LIMITED	3 5
MARUTHI ELECTRODES PVT LTD	3
MARUTI WELD LIMITED	3
MODI ARC ELECTRODES CO	3
NOWELCO INDUSTRIES PRIVATE LIMITED RAIPUR PLANT	3
RAAJRATNA ELECTRODES PVT LTD	3 8
RAJ KESARI ELECTRODES PVT LTD	3
ROYAL ARC ELECTRODES LTD	3 5
S. CHEMS & ALLIED PRODUCERS PVT LTD	4
SETH ELECTRODES CO LTD	3
SHAKUNT ENTERPRISES (P) LTD	5
SHARP ELECTRODES PVT LTD	3
SUPERON SCHWEISSTECHNIK INDIA LTD	3
UNIWELD ELECTRODES	3
USHA MARTIN LIMITED	5
VARUN ELECTRODES PVT LTD	3 5
VOLTARC ELECTRODES PRIVATE LTD	3
WELD ALLOY PRODUCTS	3
WELD EXCEL INDIA LIMITED, LUDHIANA	3
WELDCRAFT PVT LTD	3
WELDWELL ELECTRODES	3

INDONESIA

PT. ALAM LESTARI UNGGUL	3
PT. INTAN PERTIWI INDUSTRI	3
PT. KARYA YASANTARA CAKTI	3 4
PT. LINCOLN ELECTRIC INDONESIA	3
PT. ONTOREJA KANCA SEJAHTERA	3
PT. THYSINDO SEJATI UTAMA	3

IRAN

AMA INDUSTRIAL C	3 4
JOUSH VA OXYGEN IRAN CO (I.W.O.C.)	3
PARS ELECTRODE MANUFACTURING CO	3 5
S.S. KARKHANEJAT SANYA-YE FELEZI VA MIKHSAZI PARS	3
TIC TAC CO	5
WELDING INDUSTRIES & ELECTRODE MANUFACTURING CO	3

ISRAEL

ZIKA INDUSTRIES LTD	3
---------------------	---

ITALY

BTF S.P.A.	5
C.I.F.E., S.R.L.	5
ELBOR S.R.L.	5
ESAB SALDATURA S.P.A.	3 4 7
ESARC S.P.A.	3
ETC ELETTROTERMOCHIMICA S.R.L.	3 4 5 8 9
FIDAT S.R.L.	9
FRO S.R.L. DUE CARRARE	3
FRO S.R.L., CITTADELLA PLANT	4 5 7
FRO S.R.L., VERONA	3 5
FRO S.r.l., ARDENNO (SONDRIO) PLANT	4 7
I.N.E.-INDUSTRIA NAZIONALE ELETTRODI S.P.A.	3 5
ISAF S.P.A.	5
ITALFIL S.P.A.	5
LAFILI S.R.L.	5
METALLI TRAFILATI LAMINATI S.R.L.	9
NOVOFIL S.R.L.	5
S.I.A.T. S.P.A	4 5
SAFRA S.P.A.	9
SIDERARCO S.P.A.	3
SIDERGAS S.P.A.	5
TRAFILERIE DI CITTADELLA SPA	4 5

JAPAN

KOBE STEEL LIMITED, FUJISAWA BRANCH	5 6 8
KOBE STEEL LIMITED, FUKUCHIYAMA BRANCH	4 5 7 9
KOBE STEEL LIMITED, IBARAKI PLANT	3 5 7 8
KOBE STEEL LIMITED, SAIJO PLANT	3
MATSUSHITA WELDING SYSTEMS CO. LTD	5
NIKKEI SANGYO CO. LTD, KAMBARA FACTORY	9
NIKKO YOZAI MANUFACTURING CO LTD, IKOMA WORKS	5
NIPPON STEEL & SUMIKIN WELDING CO LTD HIKARI PLANT	3 5 7 8
NIPPON STEEL & SUMIKIN WELDING CO LTD KASHIWA PLANT	5 6 7 8
NIPPON STEEL & SUMIKIN WELDING CO LTD NARASHINO PLANT	4 5 6 7 8
NIPPON WELDING ROD CO. LTD, HAMAKITA FACTORY	8
SHIKOKU WELDING ELECTRODE CO. LTD	3 5
SUMITOMO ELECTRIC TOYAMA CO LTD	9
TASETO CO LTD	8

KOREA

CHOSUN WELDING CO LTD ONSAN PLANT	4 5 7 8
CHOSUN WELDING CO LTD POHANG PLANT	3 5 8
DONGIL CERAMIC CO.	7
ESAB SEAH CORPORATION	4 5 8
GENTECH HOLDINGS CO LTD, POHANG PLANT	5 8
HYUNDAI WELDING CO. LTD	3 4 5 6 7 8
INTERCOWEL CO. LTD, IKSAN PLANT	3 8
JAEL WELDING WIRE IND CO	5
KISWEL LTD	3 4 5 7 8
KOBE WELDING OF KOREA CO. LTD	5 7
KYUNG EUN CO LTD	7
MABA TRADING CO	7

MALAYSIA

IMPRESS STEEL WIRE INDUSTRIES SDN. BHD	5
KISWEL SDN. BHD.	3 5 7 8
KOBEWEL KOGYO MARKETING SDN. BHD	3
KUNCI QUANTUM SDN. BHD.	3
MOX GASES SDN BHD	3 8

MALAYSIA

POWER WELD SENDIRIAN BERHAD	3 5
S T KOBE WELDING (MALAYSIA) SDN. BHD	3
SOUTHERN WIRE INDUSTRIES (M) SDN BHD	5
UNITY SALES AND SERVICES SDN. BHD	3

MEXICO

ELECTRODOS INFRA S.A.	3 5 8
-----------------------	-------

NETHERLANDS

HILARIUS HAARLEM HOLLAND B.V.	3 4 5 8 9
KOBELCO WELDING OF EUROPE B.V.	5 8
LINCOLN ELECTRIC EUROPE/LINCOLN SMITWELD B.V.	3 4 5 7 8
VENVULAS B.V.	5
WPC NETHERLANDS B.V.	5

NEW ZEALAND

FLETCHER EASYSTEEL	3
WELDWELL NEW ZEALAND	3

NORWAY

NORSK SVEISETEKNIKK A/S	5
WILHELMSSEN MARITIME SERVICES AS	3 8

PAKISTAN

BOC PAKISTAN LIMITED	3
PAKISTAN WELDING ELECTRODES LTD	3

PERU

EXSA S.A. DIVISION SOLDADURAS	3 4 5
-------------------------------	-------

PHILIPPINES

INDUSTRIAL WELDING CORPORATION	3
WELDING INDUSTRIES OF THE PHILIPPINES INC.	3 4

POLAND

ARCELORMITTAL POLAND S.A.	5
EMA BRZEZIE SP. Z.O.O.	4
ESAB SP. Z.O.O.	3 4 5 6
ESAB SP. Z.O.O. - FILARC	5
ESAB SP. Z.O.O. - MUREX	5
HARRIS CALORIFIC INTERNATIONAL SP. Z.O.O.	5
METALWELD - FIPROM	3
MULTIMET SP. Z.O.O.	5
PRZEDSIĘBIORSTWO USŁUGOWO - HANDLOWE "TIS"	5
RYWAL RHC SP. Z.O.O.	3 5 9
SPAWMET SP. Z.O.O.	3 5

PORTUGAL

AIR LIQUIDE SOLDADURA LDA	3 5
ELECTRO PORTUGAL LDA	3
ELECTRO-ARCO SA	3 4 5

ROMANIA

MECHEL CAMPPIA TURZII S.A.	3 5
S.C. DUCTIL S.A.	3 8
SPS S.R.L.	5

RUSSIA

"ROTEX" COMPANY LIMITED	3
JSC ELECTRODE PLANT, ST. PETERSBURG	3
OAO INZHENERNO-TEKNOLOGICHESKY CENTER "PROMETHEY"	4 5
SYCHEVSKY ELECTRODNY ZAVOD	3
ZAO ESAB SVEL	3

SINGAPORE

KOBE WELDING (SINGAPORE) PTE LTD	3
THE LINCOLN ELECTRIC COMPANY (ASIA PACIFIC) PTE LTD	5

SLOVENIA

ELEKTRODE JESENICE d.o.o.	3 4 5
---------------------------	-------

SOUTH AFRICA

AFRICAN OXYGEN LIMITED	3 5
CHISA WELDING CONSUMABLES (PTY) LTD	3
OESA (PTY.) LTD	3 5

SPAIN

GEVENSA S.A.	3 4 5
LINCOLN-KD S.A.	3
OERLIKON SOLDADURA S.A.	3

SWEDEN

ELGA AB	3 4 5 8
ESAB AB	3 4 5 8 9
ESAB AB - FILARC	3
ESAB AB - MUREX	3 5
GRYTGOLS BRUKS AB	5

SWITZERLAND

NOVAMETAL S.A.	9
----------------	---

TAIWAN, REPUBLIC OF CHINA

CHINA ELECTRODE & MACHINERY COMPANY LIMITED	3
CHUAN WAN MACHINERY INDUSTRIAL CO. LTD.	5
GOODWELD CORPORATION TAINAN WORKS	3 5
KUANG TAI METAL INC CO LTD	5
SOREX WELDING CO LTD	5 8
TIEN TAI ELECTRODE COMPANY LIMITED	3 4 5 8

THAILAND

GEMINI (THAILAND) CO. LTD	3 8
KOBE MIG WIRE (THAILAND) CO. LTD	5
MENAM STAINLESS WIRE CO LTD	8
SING SANGUAN & SONS CO., LTD.	3 5
THAI KOBE WELDING CO. LTD	3
THAI TOKUDEN CO LTD	3
THAI WELCON INDUSTRY CO LTD	3
THAI-SUN WELDING CO. LTD	3
THANYANORASETH CO LTD	3 5
USHA SIAM STEEL INDUSTRIES PUBLIC COMPANY LIMITED	5

TURKEY

BOHLER KAYNAK CUBUKLARI, ELEKTRODLARI SANAYII VE TICARET A.S.	3
	3

TURKEY

BORKIM BORU PROFIL FILMASIN VE KIMYASAL URUNLER SANAYI TICARET LTD.STI.	
ELGA ELEKTROD VE GAZ ALTI KAYNAK TELI SAN VE TIC LTD	3
GEDIK KAYNAK SANAYI VE TICARET A.S.	3 4 5
KAYNAK TEKNIGI SANAYII VE TICARET A.S.	3 4 5
OERLIKON KAYNAK ELEKTRODLARI VE SANAYI A.S.	3

UKRAINE

"TM WELTEK" LTD	5
ARCSEL LTD	5
UKRAINIAN SOUTHERN COMPANY	3

UNITED ARAB EMIRATES

TTS ARC INDUSTRIES LLC	3
------------------------	---

UNITED KINGDOM

LINCOLN ELECTRIC (UK) LIMITED	4 5
METRODE PRODUCTS LTD	8
SAF WELDING PRODUCTS LTD	8
W.B. ALLOY WELDING PRODUCTS LTD	3 5

UNITED STATES OF AMERICA

ALCOTEC WIRE CO.	9
HOBART BROTHERS CO, TUBULAR WIRE BUSINESS - COREX	3 5
HOBART BROTHERS CO, TUBULAR WIRE BUSINESS - HOBART	3 5
HOBART BROTHERS CO, TUBULAR WIRE BUSINESS - MACKAY	3 5 8
HOBART BROTHERS CO, TUBULAR WIRE BUSINESS - TRI-MARK	5
LINCOLN ELECTRIC COMPANY	3 4 5 9
MEC WEAR AND FUSION TECHNOLOGY	3
SELECT-ARC INC.	5
THE ESAB GROUP INC - ALLOY RODS	3 5 8
THE ESAB GROUP WELDING & CUTTING SYSTEMS	5
UNIWELD PRODUCTS, INC	3

VENEZUELA

INVERSIONES ARCOMETAL, C.A.	3 5
LINCOLN SOLDADURAS DE VENEZUELA C.A.	3

VIETNAM

NAM TRIEU WELDING MATERIAL INDUSTRY COMPANY, HAI PHONG	3 5
--	-----

YUGOSLAVIA

DD FEP "PIVA" PLUZINE	3 4 5
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INTRODUCTION

These notes are specific to this edition of the publication and changes have been made for consistency with the 1999 edition of the Rules and Regulations for the Classification of Ships, Part 2, "Rules for the Manufacture, Testing and Certification of Materials", hereafter referred to as the Materials Rules.

The welding consumables and consumable combinations listed have complied with the approval requirements set out in the relevant Sections of Chapter 11 of the Materials Rules. The consumables are retained in these lists subject to satisfactory annual tests made in accordance with the Materials Rules, the results of which are reported to the Head Office of Lloyd's Register. Further information may be found in the Materials and Qualification Procedures for Ships, Book J, Procedures for Approval of Welding Consumables and Manufacture of Fabricated Steel Sections.

The responsibility for compliance with national or other standards indicated by labelling or implied by the trade name rests with the Manufacturer.

It should be noted that unaccountable delays in the receipt of satisfactory annual test results will lead to deletion from the approved list.

The Sections are numbered in accordance with the numbering of the respective Sections of the Materials Rules, Chapter 11, namely:

Section 3:	Consumables for Manual and Gravity Metal Arc Welding of Steels.
Section 4:	Consumables for Submerged Arc Welding of Steels.
Section 5:	Consumables for Gas Tungsten Arc, Gas Shielded Metal Arc and Self Shielding Metal Arc Welding of Steels.
Section 6:	Consumables for Electroslag and Electrogas Welding of Steels.
Section 7:	Consumables for One-Side Welding of Steels with Temporary Backing Materials.
Section 8:	Consumables for Welding Austenitic and Duplex Stainless Steels.
Section 9:	Consumables for Welding Aluminium Alloys.

The Section number and title (in brief) is repeated at the head of each page.

The continuing process of new approvals and up-grading, deletions and down-grading means that this published list records the status only at the deadline for printing.

Any queries concerning the validity of an approval can be resolved by reference to one or more of the following:-

- a) The initial approval certificate, for 12 months from the date of issue.
- b) The annual re-approval certificate, taking due note of the period of validity indicated on it by the "year ending" date.
- c) The local office of Lloyd's Register.
- d) Materials and Non Destructive Examination Department,
Lloyd's Register,
71 Fenchurch Street
London, EC3M 4BS
Telephone: 020 7709 9166
Telex: 888379 LR LON G
Fax: 020 7488 4796

The use of approved welding consumables in a shipyard should be subject to satisfactory results being obtained from welding procedure tests carried out in that shipyard. Such tests are always to be carried out where the shipyard has not previously welded that particular material or where a welding process or technique is newly introduced to that shipyard.

The explanatory notes and abbreviations set out below are applicable to most Sections. Where they are not, this is clearly indicated.

EXPLANATORY NOTES AND ABBREVIATIONS

Names

Within each Section, welding consumables or consumable combinations are listed, in alphabetical order, under Country, Supplier (including Plant if required) and Trade Name. Sub-headings separate different welding consumable combination types and processes. A supplier is not necessarily the manufacturer.

Some manufacturers, in some countries, may not have listed all of the approved products which they sell. This can occur where products manufactured in one country are sold by an associated company of the same (or similar) name in another country. In such cases, the status of approval can be found by identifying the country of manufacture from the packaging and examining the listing under the name of the supplier in the country identified.

Welding Positions

Consumables are approved for welding only in those positions which are specifically indicated by one or more of the following letters:

D	approved for Downhand (flat) welding. Where approved for fillet welding as well as, or instead of, butt welding, this designation refers to downhand and horizontal-vertical fillet welding.
X	approved for horizontal-vertical welding.
Vu	approved for Vertical welding with progression in the upward direction only.
Vd	approved for Vertical welding with progression in the downward direction only.
Vud	approved for Vertical welding with progression in either upward or downward direction.
O	approved for Overhead welding.

Joint Type

Approval applies only to the joint type indicated by the following letters:

B	approved for welding Butt joints.
F	approved for Fillet welding.

Grade + Technique

The consumable Grade description differs according to the Section as described later. For special purposes “dual grading” involving a two-line entry is employed.

The Grade may be modified by appended letters which indicate the post weld condition for which approval has been given:-

sr	stress relief heat treated after welding.
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The welding Technique is indicated by a letter added to follow the Grade:-

p	manual electrodes suitable for deep penetration welding.
m	manual welding using electrodes for normal penetration, or consumables for manual gas tungsten arc welding.
G	Gravity or contact welding.
S	Semi-automatic multi-run welding.
M	automatic Multi-run welding (submerged arc, gas tungsten arc and gas metal arc).
T	Two-run technique welding (submerged arc, and gas metal arc).
A	Automatic high heat input welding, used for one-side welding, Section 7.

Low Hydrogen Approval

This appears as a column heading for approvals under Sections 3, 4, 5, and 7. It does not appear for approvals under Section 6, 8 and 9 as the significance of hydrogen content is unclear and there are no currently agreed test methods for electroslag and electrogas welding and for the welding of austenitic and duplex stainless steels and aluminium alloys.

No	No hydrogen approval.
H15	low Hydrogen approved, conforming to standard weld metal containing not more 15 cm ³ of hydrogen in 100 g of weld deposit.
H10	low Hydrogen approved, conforming to standard weld metal containing not more 10 cm ³ of hydrogen in 100 g of weld deposit.
H5	low Hydrogen approved, conforming to standard weld metal containing not more 5 cm ³ of hydrogen in 100 g of weld deposit.
NR	testing for low hydrogen approval is Not Required , because the consumable and process in which it is used are not considered to involve a risk of hydrogen cracking in normal construction.

Maximum Thickness

The “**t max**” entry indicates the **maximum thickness** for which the consumable is approved in conjunction with the relevant Section and Grade + Technique as described later.

NA **Not Applicable** because there is no thickness limit relevant to the approval.
35 where the Grade + Technique is approved but is limited to plates with a maximum
thickness of **35 mm**.

Use on greater thickness than that indicated, will be subject to satisfactory welding procedure tests.

Grades for Steels, Sections 3, 4, 5, 6 & 7.

The Grade for consumables suitable for welding **normal strength steels** consists of a single digit number from 1 to 3 referring to the notch impact test temperature (which may be followed optionally by the letter **N**).

- 1** tested at **20°C** suitable for welding Grade A steel.
- 2** tested at **0°C** suitable for welding Grades B and D steel.
- 3** tested at **-20°C** suitable for welding Grade E steel.

The Grade for consumables suitable for welding **higher strength steels** consists of a single digit number from 1 to 5 referring to the toughness level followed by the letter **Y** for consumables approved for the welding of Grade 32 and Grade 36 steels. For other higher strength steels the letter Y is followed by a two digit number indicating the approved specified minimum yield strength in N/mm² divided by 10.

- 4Y** tested at **-40°C**.
- 5Y40** tested at **-60°C**.

The Grade of a consumable approved for the welding of a nickel alloy steels is indicated by the nominal alloy content.

The consumable approval Grades and the steel Grades for which they are considered suitable, are shown in the following table.

Consumable grade	Suitable for steel grades
1 (N)	A
2 (N)	B, D
3 (N)	E
1Y	AH32 (LT-AH32), AH36 (LT-AH36)
2Y	DH32 (LT-DH32), DH36 (LT-DH36)
3Y	EH32 (LT-EH32), EH36 (LT-EH36)
2Y40	AH40 (LT-AH40)
3Y40, 3Y42, 3Y46, to 3Y69	DH40 (LT-DH40), DH42, DH46, to DH69
4Y	FH32 (LT-FH32), FH36 (LT-FH36)
4Y40	EH40 (LT-EH40)
4Y42, 4Y46 to 4Y69	EH42, EH46, to EH69
5Y40	FH40 (LT-FH40)
5Y42, 5Y46, to 5Y69	FH42, FH46, to FH69
1½Ni	1½Ni
3½Ni	3½Ni
5 Ni	5 Ni
9 Ni	9 Ni
(N) Use of N is optional.	

For joining different Grades of steel of a given strength, consumables suitable for the lower toughness Grade are generally acceptable, except at discontinuities or other points of stress concentration, where the Grade appropriate to the tougher steel will be expected.

For the joining of steel of different tensile strengths, the consumables are to be suitable for the strength of the weaker member, or in the case of fillet welded connections, on the strength of the component used as the basis for the fillet size.

Manual and Gravity Electrodes, Section 3

The steel Grade is used with an appended letter corresponding to one of the welding techniques m, p and G. The use of the technique as part of the Grading is optional for manual electrodes so that, for example, 3m can be expressed as 3 and 3Ym as 3Y.

3m = 3 ; 3Ym = 3Y ; 3YG = 3G + 3YG

Submerged Arc Consumables, Section 4

The steel Grade is used with an appended letter corresponding to one of the welding techniques M and T. The use of the Grade + Technique is mandatory. Note that abbreviations of Grade + Technique combinations are common and that for the M technique the approval covers two strength levels below that tested so that 3YM covers both 3M and 3Y.

3T, 3M = 3TM ; 3YT, 3YM = 3YTM ; 3T, 3M, 3YM, 3YT = 3TM, 3YTM ;
3M, 3YM = 3YM ; 3T, 3YM, 3YT = 3TM, 3YTM

Approval for the M technique does not have any restriction on thickness.

Approval for the T technique is limited to the maximum thickness entered in the "t_{max} in T technique" column.

Gas Shielded Metal Arc Etc., Section 5

The steel Grade is used with an appended letter corresponding to one of the welding techniques m, S, M or T.

Approval for the m, S or M techniques do not have any restriction on thickness.

Approval for the T technique is limited to the maximum thickness entered in the "t_{max} in T technique" column.

Unless otherwise expressed, consumables for downhand semi-automatic welding are also approved for downhand automatic multi-run welding.

DXVuO; 3S; 3YS; etc. also means: D; 3M; 3YM; etc.

Electroslag and Electrode Gas Consumables, Section 6

Steel Grades are used without any appended technique letter.

Superscript numbers are applied to the "Y" of higher strength steel consumables, e.g. 2Y¹, to indicate the type of parent steel for which approval is applicable:-

- | | |
|----------------|---|
| Y ¹ | approval Grade for higher strength steel is limited to parent steel which has been treated only with aluminium . |
| Y ² | approval Grade for higher strength steel is appropriate to niobium -treated steels, whether aluminium-treated or not. It also covers steels treated only with aluminium. |

The approval is limited to the maximum thickness entered in the "t_{max}" column.

Consumables for One-Side Welding, Section 7

The steel Grade is used with an appended letter corresponding to one of the welding techniques m, S, M or A.

Technique A, Automatic high heat input welding, is used only for one-side welding, Section 7, for which not more than 4 runs are used to complete a butt weld in 20 mm plate, or 8 for 35 mm. Approval for the A technique is limited to the maximum thickness entered in the "t_{max} in A technique" column.

Where S and M are used in Section 7, these refer to semi-automatic and automatic multi-run welding in which a greater number of runs are used than for Technique A.

Consumables for Stainless Steels, Section 8

Chemical Use, Cryogenic Use The Grade and appended technique letter are entered in each column in accordance with the application approved. The Grade corresponds to the type of approved stainless steel parent material for which the welding consumable is approved.

The available Grades are: Austenitic: 304L, 304LN, 316L, 316LN, 317LN, 321, 347, S 31254, N 08904.
 Duplex: S 31260, S 31803, S 32550, S 32750, S 32760.

SS/CMn in the Chemical Use column indicates approval for joining any of the austenitic types of stainless steel to any of the normal or higher strength ship steels up to and including Grade EH36.

Where "SS/CMn" appears in the Cryogenic Use column, it indicates approval for joining any of the austenitic stainless steels to ship steels up to and including Grade FH40 (LT-FH40) for low temperature applications for which the ship grade used is suitable.

Dup/CMn indicates approval for joining any of the duplex types of stainless steel to any of the normal strength or Grade 36 higher tensile ship steels. Approval is currently available only for "Chemical Use". Approval for cryogenic applications must be obtained as part of normal welding procedure qualification for each application.

CPT, the **Critical Pitting Temperature** is the maximum temperature at which pitting was not observed in a standard corrosion test to ASTM G48 Method C.

Consumables for Welding Aluminium Alloys, Section 9

The Grade of approval is indicated by the alloy type and condition of the parent material with an appended letter corresponding to one of the welding techniques m, S, M or T.

The available Grades are: 5083-O & F, 5083-H321, 5086-O & F, 5086-H112, 5086-H321, 6061-T6, 6082-T6.

HIGHER STRENGTH STEEL

The weldability of high strength steel of the carbon-manganese type has been assessed from the carbon equivalent value calculated using the formula:

$$\text{Carbon equivalent} = C + \frac{\text{Mn}}{6} + \frac{\text{Cr} + \text{Mo} + \text{V}}{5} + \frac{\text{Ni} + \text{Cu}}{15}$$

This is relevant to the avoidance of hydrogen induced delayed cold cracking during fabrication of ship structures and similar applications.

The following table summarises the minimum hydrogen requirements for approval in accordance with the Materials Rules.

Approval Grade	Process & Technique			
	SMAW,m	SAW,M	SAW,T&A	ES
	GMAW,S	GMAW,M	GMAW,T&A	EG
N Y (CE<0.41) Y (CE>0.41) Y40 1.5 Ni steel	NR	NR	NR	NR
Y42	H10		H15	Not Applicable
Y46				
Y50	H10			
Y55	H5			
Y62				
Y69				
Austenitic & Duplex Stainless Steels	Not Applicable			

Use of consumables presumes that their low hydrogen condition will be safeguarded up to and including the point of use, and that welding procedures will be set to minimise the risk of hydrogen cracking by controlling the weld heat input and preheat to appropriate levels for the joints being made. These procedures will take into account also the steel being welded and the actual low hydrogen approval of the consumables used. In highly critical situations the manufacturer may be willing to supply and certify consumables subjected to batch control testing.

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