

2<sup>nd</sup> Amendment of answer to the mandate M120

Document identification: CEN/TC 121 N 1847

Technical Committee TC 121 – WG3

Date 2013-11-28

Documents	Reference Number	Date of issue
Mandate number	M120	1998.03.11
Original answer to the Mandate	CEN/TC 121 N 808	31.08.2000
Commission's acceptance	08707 - 855249	13.07.2001
1 <sup>st</sup> amendment of the answer to the mandate	CEN/TC 121 N 1390	31.10.2006
Commission's acceptance	Ares(2011)909641	27.07.2011
2 <sup>nd</sup> amendment of the answer to the mandate	This document	dd.mm.yyyy
Commission's acceptance		

List of changes :

Clause of the original document	Reason for the change (short description)	Supporting information (if relevant)
<b>A.1</b>	It is proposed to modify the clause as follows: prEN 13479	Missing in the original answer.
<b>A.1 (i)</b>	It is proposed to modify the title as follows: Welding consumables - General product standard for filler materials and fluxes for fusion welding of metallic materials	It better reflects the product covered by the standard.
	It is proposed to modify the availability dates as follows: Dates of availability: Stage 32: 2014-08 Stage 40: 2014-11 Stage 49: 2015-12	Updating of the availability dates.
<b>A.1 (ii)</b>	It is proposed to modify the scope as follows: This European standard specifies product characteristics and related test/assessment methods for filler materials (welding consumables as defined in ISO/TR 25901) and fluxes. This standard does not cover shielding gases and ceramic backings (as defined in ISO/TR 25901).	It better specifies the products covered by the standard better.
<b>A.1 (iii)</b>	It is proposed to modify the intended use as follows: "Filler materials and fluxes to be used for fusion welding of metallic structures or composite metals and concrete structures in construction works."	Composite metals and concrete structures were missing.
<b>A.1 (iv)</b>	It is proposed to modify the essential characteristic as follows:	The standard covers filler materials and fluxes which are

	<p>1 - Delete "Tolerances on dimension and shape"</p> <p>2 - Delete "Elongation"</p> <p>3 - Delete "Tensile strength"</p> <p>4 - Delete "Yield strength"</p> <p>5 - Delete "Impact strength"</p> <p>6 - Change "Weldability" into EC "Chemical composition"</p>	<p>consumed during welding operations. It is considered that mandated characteristics for which deletion is proposed should not be considered relevant for the products covered by the standard. They could be relevant for the weldment obtained. The properties of the weldment depend partially on the chemical composition but also on the qualification of the welder, the welding procedure qualification (such as e.g. shielding gas, polarity, amperage, voltage, preheat and interpass temperature, heat input), post weld heat treatment if applicable, the geometry of the weld and the base material.</p> <p>Weldability is determined by the chemical composition which is the only measurable aspect for the products covered by the standard</p>
<b>A.1 (v)</b>	It is proposed to delete the "Durability (chemical composition)".	There are no known durability aspects affecting the chemical composition. Similarly there are no corrosion effects on wire if the manufacturers handling and storage instructions are followed.
<b>A.1 (vi)</b>	<p>It is proposed to modify as follows:</p> <p><b>(vi) Other aspects</b></p> <p>This harmonized product standard will also contain:</p> <ul style="list-style-type: none"> <li>- a reference to the Commission decision on attestation of conformity</li> <li>- clauses on assessment and verification of constancy of performance</li> <li>- guidance on the characteristics to be stated in the labelling accompanying the CE marking." </li></ul>	Missing in the original answer.
<b>A.2</b>	It is proposed to modify as follows: "None"	The supporting standards listed are not relevant anymore if the essential characteristics are reduced as proposed above.

The changes listed here above are detailed here below in the relevant clauses on basis of the template for the answer to the Mandate (Document CMF N032 rev.2 Suppl. to BTS1 N877).

## **A WELDING CONSUMABLES**

### **A.1 Harmonised product standard – EN 13479**

**Dates of availability**

**Stage 32: 2014-05**

**Stage 40: 2014-12**

**Stage 49: 2015-06**

- (i) **Title:** Welding consumables — General product standard for filler materials and fluxes for fusion welding of metallic materials.
- (ii) **Scope:** This European standard specifies product characteristics and related test/assessment methods for filler materials (welding consumables as defined in ISO/TR 25901) and fluxes. This standard does not cover shielding gases and ceramic backings (as defined in ISO/TR 25901).
- (iii) **Intended use:** Filler materials and fluxes to be used for fusion welding of metallic structures or composite metals and concrete structures in construction works.
- (iv) **The essential characteristics according to the mandate which will be dealt with in the above standard will be:**  
**Chemical composition**
- (v) **Durability** None
- (vi) **Other aspects**  
This harmonized product standard will also contain:  
- a reference to the Commission decision on attestation of conformity  
- clauses on assessment and verification of constancy of performance  
- guidance on the characteristics to be stated in the labelling accompanying the CE marking."

### **A.2 Supporting standards**

None