

Definitions of Backing in Welding Consumables

Amended Guidance

Guidance for the Survey and Construction of Steel Ships Part M

Reason for Amendment

In general, welding consumables are approved as a combination consisting of the welding consumables themselves, electrode numbers, flux, filler and backing, etc. Additionally, it is specified in 2.4.1-2, Part M of the Rules that combinations which are different to those approved by the Society may be used for backing.

In submerged arc one side automatic welding, there may be some misunderstanding that “backing” means “backing flux”. Therefore, it has been specified that the backing flux used for submerged arc one side automatic welding is not included in the backing which can be used in different welding consumable combinations.

Outline of Amendment

It has been specified that the backing flux used in submerged arc one side automatic welding is not considered to be backing with respect to the approval of welding consumables.