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# **RULES FOR THE SURVEY AND CONSTRUCTION OF STEEL SHIPS**

**Part M**    **Welding**

**RULES**

## **2012    AMENDMENT NO.1**

Rule No.29            15th June 2012

Resolved by Technical Committee on 10th February 2012

Approved by Board of Directors on 6th March 2012

AMENDMENT TO THE RULES FOR THE SURVEY AND CONSTRUCTION OF STEEL SHIPS

“Rules for the survey and construction of steel ships” has been partly amended as follows:

**Part M WELDING**

**Chapter 6 WELDING CONSUMABLES**

**6.9 Welding Consumables for Quenched and Tempered High Tensile Steels for Structures**

Table M6.60 has been amended as follows.

Table M6.60 Test Requirements for Deposited Metal

Grades of welding consumables	Tensile test			Impact test	
	Tensile strength ( $N/mm^2$ ) <sup>(1)</sup>	Yield point or proof stress ( $N/mm^2$ )	Elongation (%)	Test temperature (°C)	Minimum mean absorbed energy( $J$ )
<i>KMW2Y42, KSW2Y42, KAW2Y42</i>	530~680	420 min.	20 min.	0	47
<i>KMW3Y42, KSW3Y42, KAW3Y42</i>				-20	
<i>KMW4Y42, KSW4Y42, KAW4Y42</i>				-40	
<i>KMW5Y42, KSW5Y42, KAW5Y42</i>				-60	
<i>KMW2Y46, KSW2Y46, KAW2Y46</i>	570~720	460 min.	<del>18</del> 20 min.	0	47
<i>KMW3Y46, KSW3Y46, KAW3Y46</i>				-20	
<i>KMW4Y46, KSW4Y46, KAW4Y46</i>				-40	
<i>KMW5Y46, KSW5Y46, KAW5Y46</i>				-60	
<i>KMW2Y50, KSW2Y50, KAW2Y50</i>	610~770	500 min.	<del>17</del> 18 min.	0	50
<i>KMW3Y50, KSW3Y50, KAW3Y50</i>				-20	
<i>KMW4Y50, KSW4Y50, KAW4Y50</i>				-40	
<i>KMW5Y50, KSW5Y50, KAW5Y50</i>				-60	
<i>KMW2Y55, KSW2Y55, KAW2Y55</i>	670~830	550 min.	<del>16</del> 18 min.	0	55
<i>KMW3Y55, KSW3Y55, KAW3Y55</i>				-20	
<i>KMW4Y55, KSW4Y55, KAW4Y55</i>				-40	
<i>KMW5Y55, KSW5Y55, KAW5Y55</i>				-60	
<i>KMW2Y62, KSW2Y62, KAW2Y62</i>	720~890	620 min.	<del>16</del> 18 min.	0	62
<i>KMW3Y62, KSW3Y62, KAW3Y62</i>				-20	
<i>KMW4Y62, KSW4Y62, KAW4Y62</i>				-40	
<i>KMW5Y62, KSW5Y62, KAW5Y62</i>	720~890	620 min.	<del>16</del> 18 min.	-60	62
<i>KMW2Y69, KSW2Y69, KAW2Y69</i>	770~940	690 min.	<del>15</del> 17 min.	0	69
<i>KMW3Y69, KSW3Y69, KAW3Y69</i>				-20	
<i>KMW4Y69, KSW4Y69, KAW4Y69</i>				-40	
<i>KMW5Y69, KSW5Y69, KAW5Y69</i>				-60	

Note:

- (1) Tensile strength specified in the table may be altered where deemed appropriate by the Society.

## EFFECTIVE DATE AND APPLICATION

1. The effective date of the amendments is 15 June 2012.
2. Notwithstanding the amendments of the Rules, the current requirements may apply to welding consumables other than those for which the applications for annual inspections or approval tests are submitted to the Society on or after the effective date.