
**Welding consumables — Technical
delivery conditions for filler materials and
fluxes — Type of product, dimensions,
tolerances and markings**

*Produits consommables pour le soudage — Conditions techniques de
livraison des matériaux d'apport et des flux — Type de produit,
dimensions, tolérances et marquage*

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Foreword

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International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 544 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 3, *Welding consumables*.

This fourth edition cancels and replaces the third edition (ISO 544:2003), which has been technically revised.

Requests for official interpretations of any aspect of this International Standard 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.

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Welding consumables — Technical delivery conditions for filler materials and fluxes — Type of product, dimensions, tolerances and markings

1 Scope

This International Standard specifies technical delivery conditions for filler materials and fluxes for fusion welding.

This International Standard does not apply to other auxiliary materials such as shielding gases.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 14174, *Welding consumables — Fluxes for submerged arc welding and electroslag welding — Classification*¹⁾

ISO 14344, *Welding consumables — Procurement of filler materials and fluxes*

ISO 80000-1:2009, *Quantities and units — Part 1: General*

3 Product type and welding process

The types of products covered by this International Standard and the welding process(es) in which they are used are listed in Table 1.

NOTE The corresponding reference numbers for each welding process in accordance with ISO 4063:2009^[1] are given for information.

4 Dimensions and tolerances

4.1 Solid wires and solid wire electrodes, tubular cored wires and tubular cored electrodes, solid and tubular cored rods and covered electrodes

Dimensions and tolerances for solid wires and solid wire electrodes, tubular cored wires and tubular cored electrodes, solid and tubular cored rods and covered electrodes are given in Table 2.

1) To be published. (Revision of ISO 14174:2004)

Table 1 — Product type and welding process

Product type	Welding process(es) ^a
Cored strip electrode	EG, ES, S
Covered electrode	E
Solid rod	W, O, P
Solid strip electrode	ES, S
Solid wire	W, P, L, EB
Solid wire electrode	EG, ES, G, S
Tubular cored rod	W, O, P
Tubular cored wire	L, W
Tubular cored electrode	EG, ES, P, S, T
Thin foil	L, EB

^a The corresponding reference numbers for each welding process in accordance with ISO 4063:2009^[1] are:

- E Manual metal arc welding (111);
- EB Electron beam welding (51);
- EG Electroslag welding (73);
- ES Electroslag welding (72);
- G MIG/MAG welding with solid wire electrode (131, 135);
- L Laser welding (52);
- O Oxyfuel gas welding (31);
- P Plasma arc welding (15);
- S Submerged arc welding (12);
- T Metal arc welding with tubular cored electrode with a gas shield (132, 133, 136 and 138) or without a gas shield (114);
- W Gas tungsten arc welding (14).

4.2 Solid strip electrodes

Dimensions and tolerances for solid strip electrodes are given in Table 3.

4.3 Cored strip electrodes and thin foils

Dimensions and tolerances for cored strip electrodes and thin foils shall be in accordance with the relevant application standard.

Table 2 — Dimensions and tolerances for wires, rods, and covered electrodes

Dimensions in millimetres

Nominal diameter	Solid wires and solid wire electrodes ^a		Tubular cored wires and tubular cored electrodes ^a		Solid and tubular cored rods ^a			Covered electrodes ^{ab}						
	S, ES, EG Diameter tolerance		T, S, EG Diameter tolerance		Diameter tolerance	Length	Length tolerance	Weiding process						
	G, W, L, EB Diameter tolerance	W, O, P Length		E				E		E				
0,5	+0,01 -0,03	—	—	—	—	—	—	—	—	—	—	—	—	
0,6														
0,8														
0,9			+0,02 -0,05											
1,0														
1,2														
1,4														
1,6	+0,01 -0,04													
1,8														
2,0		±0,04												
2,4														
2,5														
2,8														
3,0	+0,01 -0,07													
3,2														
4,0														
5,0														
6,0														
8,0														

^a Other dimensions may be agreed. For intermediate dimensions, tolerances given in this table shall be used.

^b Dimensions for the core wire.

^c For special cases (e.g. gravity welding), length, $l < 1\,000$ mm.

Table 3 — Dimensions and tolerances for solid strip electrodes

Parameter	Dimensions mm	Tolerances mm
Nominal thickness	≤1,0	±0,05
Nominal width	≤100	+0,5 0
	>100	+0,8 0

4.4 Fluxes

The flux shall be granular and so constituted that it can be conveyed freely by the flux feed system. The particle size distribution shall be uniform and consistent in the different packaging units. The fluxes are obtainable in different particle size distributions (see ISO 14174).

5 Rounding procedure

For the purposes of determining compliance with the requirements of this International Standard, the actual test values obtained shall be subjected to ISO 80000-1:2009, B.3, Rule A. If the measured values are obtained by equipment calibrated in units other than those of this International Standard, the measured values shall be converted to the units of this International Standard before rounding. If an arithmetic average value is to be compared to the requirements of this International Standard, rounding shall be done only after calculating the arithmetic average. If the test method standard cited in Clause 2 contains instructions for rounding that conflict with the instructions of this International Standard, the rounding requirements of the test method standard shall apply. The rounded results shall fulfil the requirements of the appropriate table for the classification under test.

6 Condition of welding consumables

6.1 Covered electrodes

The electrode covering shall be concentric and consistent along the electrode length in order to avoid asymmetrical melting-off of the covering during welding. The electrode covering shall not exhibit any irregularities, cracks or other surface defects which would adversely affect the welding operation. The coating shall firmly adhere to the core wire and shall not break off during proper handling and usage.

The grip end of the electrode shall be free from covering material over a length of at least 15 mm.

NOTE The striking end can include arc ignition enhancing material.

6.2 Wires, rods, and strips

The surface of the welding consumables shall be free from contamination and surface defects that can adversely affect welding. Any surface finish is allowed, provided that the welding operation and the properties of the weld metal are not adversely affected.

All tubular cored electrodes shall have the core ingredients distributed uniformly throughout their length such that the performance of the products, the chemical composition and the properties of the deposited weld metal are not adversely affected.

Wires and strips can be delivered in coils or wound on spools in accordance with Figure 1 and Table 4. Coils and spools shall not exhibit kinks, waves, sharp bends or other irregularities that could interfere with continuous feeding. The beginning and end of the wire, spooled in one length, shall be secured.

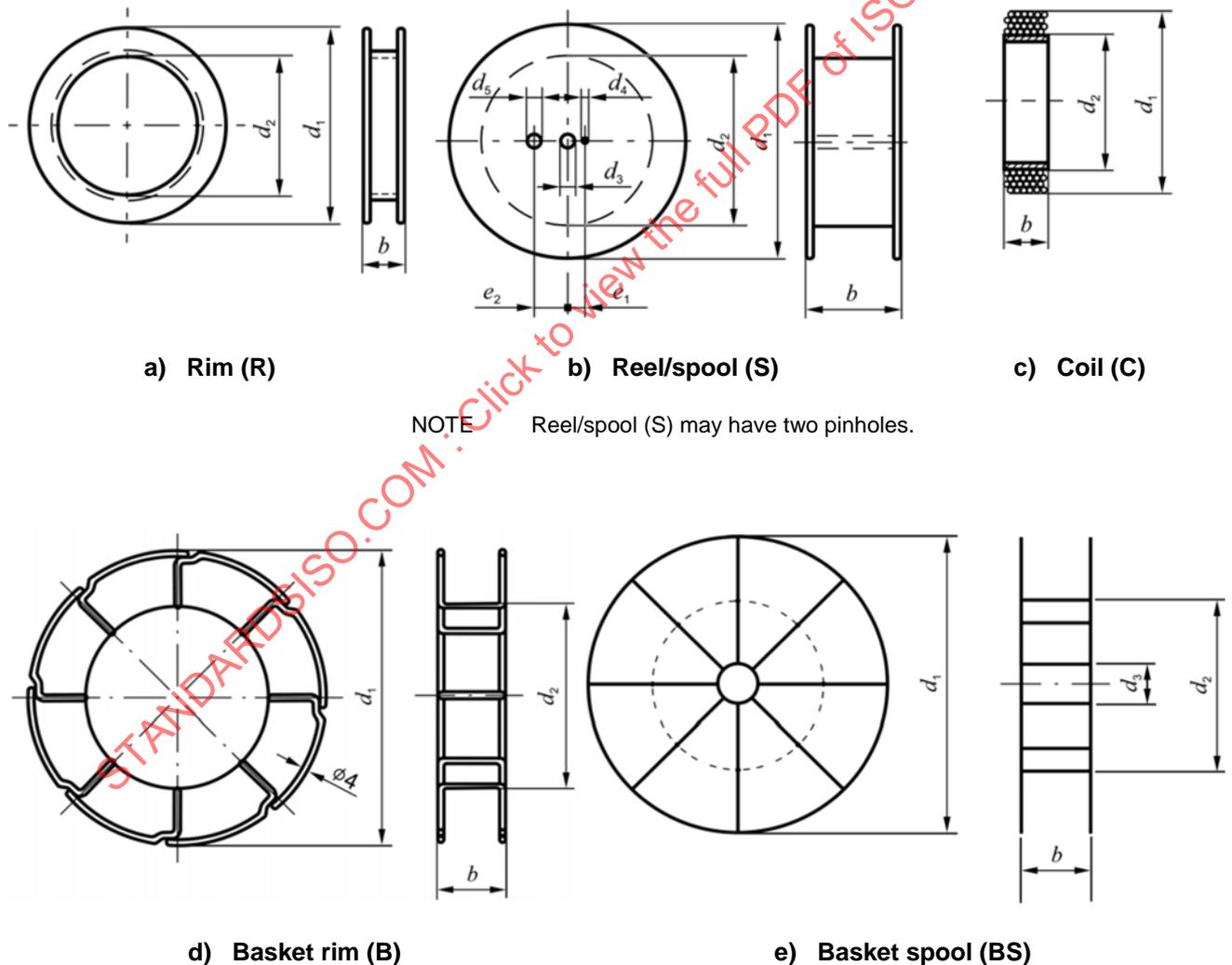
Welding consumables on coils without formers shall be tied in at least three places spaced approximately equally around the circumference of the coil.

Solid wires and solid wire electrodes for steel shall not exhibit a helix greater than specified in the next two paragraphs.

The helix is defined as the vertical separation between any part of one loop of wire placed on a flat surface without restraint and the flat surface. It shall not be more than 25 mm for spools having an outside diameter of up to 200 mm (S 200) and not more than 50 mm for spools having a diameter of more than 200 mm (see Table 4).

The cast (diameter of some loops of wire placed on a flat surface without restraint), helix and condition of all wires shall be such as to be suitable for uniform uninterrupted feeding on automatic or semi-automatic welding equipment.

Dimensions in millimetres



Key

$b, d_1, d_2, d_3, d_4, d_5, e_1, e_2$ for definitions, see Table 4

Figure 1 — Reels, rims, spools and coils

Table 4 — Dimensions and tolerances of reels, rims, spools, and coils

Dimensions in millimetres

Type	Designation ^a	Outer diameter ^a d_1	Inner diameter ^a d_2	Outer width ^a b	Bore diameter ^a d_3	Diameter ^a		Pinhole	
						d_4	d_5	e_1	Distance from axis ^a e_2
Reel/spool (S)	S 100	100 ± 2	—	45 ⁰ ₋₂	16,5 ⁺¹ ₀	—	—	—	—
Reel/spool (S)	S 117	117 ± 1	—	71 ⁰ ₋₂	48,0 ^{+0,6} ₀	—	—	—	—
Reel/spool (S)	S 200	200 ± 3	—	55 ⁰ ₋₃	50,5 ^{+2,5} ₀	10 ⁺¹ ₀	—	44,5 ± 0,5	—
Reel/spool (S)	S 300	300 ± 5	—	103 ⁰ ₋₃	50,5 ^{+2,5} ₀	10 ⁺¹ ₀	—	44,5 ± 0,5	—
Reel/spool (S)	S 350	350 ± 5	—	103 ⁰ ₋₃	50,5 ^{+2,5} ₀	10 ⁺¹ ₀	—	44,5 ± 0,5	—
Reel/spool (S)	S 560	560 ⁰ ₋₁₀	—b	305 ⁰ ₋₁₀	35,0 ± 1,5	16,7 ± 0,7	16,7 ± 0,7	63,5 ± 1,5	63,5 ± 1,5
Reel/spool (S)	S 610	610 ⁰ ₋₁₀	—b	345 ⁰ ₋₁₀	35,0 ± 1,5	16,7 ± 0,7	16,7 ± 0,7	63,5 ± 1,5	63,5 ± 1,5
Reel/spool (S)	S 760E	760 ⁰ ₋₁₀	—	290 ⁺¹⁰ ₋₁	40,5 ⁺¹ ₀	25 ⁺¹ ₀	35 ⁺¹ ₀	65 ± 1	110 ± 1
Reel/spool (S)	S 760A	760 ⁰ ₋₁₀	—b	345 ⁰ ₋₁₀	35,0 ± 1,5	16,7 ± 0,7	16,7 ± 0,7	63,5 ± 1,5	63,5 ± 1,5
Rim (R)	R 435	435 ± 5	300 ⁺¹⁵ ₀	90 ⁰ ₋₁₅	—	—	—	—	—

Table 4 (continued)

Dimensions in millimetres

Type	Designation ^a	Outer diameter ^a d_1	Inner diameter ^a d_2	Outer width ^a b	Bore diameter ^a d_3	Pinhole		
						Diameter ^a d_4	Diameter ^a d_5	Distance from axis ^a e_1 e_2
Basket rim (B)	B 300	300 ⁰ ₋₅	180 ± 2	100 ± 3	—	—	—	—
Basket rim (B)	B 435	435 ⁰ ₋₅	300 ± 5	70 ± 3	—	—	—	—
Basket rim (B)	B 450	≤ 450	300 ± 5	100 ± 3	—	—	—	—
Basket spool (BS)	BS 200	200 ⁺⁴ ₋₃	100 ⁺⁷ ₋₅	55 ± 3	50,5 ^{+2,5} ₀	—	—	—
Basket spool (BS)	BS 300	300 ± 5	189 ± 0,5	103 ⁰ ₋₃	50,5 ^{+2,5} ₀	—	—	—
Coil (C)	C 435	≤ 435	300 ⁺¹⁵ ₀	90 ⁰ ₋₁₅	—	—	—	—
Coil (C)	C 450	≤ 450	300 ⁺¹⁵ ₋₅	100 ⁺¹⁰ ₋₅	—	—	—	—
Coil (C)	C 750	≤ 750	570 ⁺²⁰ ₀	90 ⁰ ₋₁₀	—	—	—	—
Coil (C)	C 800	≤ 800	600 ⁺²⁰ ₀	120 ⁺¹⁰ ₋₅	—	—	—	—

^a Other dimensions can be agreed.

^b Outside diameter of barrel, d_2 , shall be such as to permit feeding of the filler materials.