

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION R 547

LENGTHS AND TOLERANCES OF ELECTRODES
FOR THE WELDING OF MILD STEEL
AND LOW ALLOY HIGH TENSILE STEEL

1st EDITION

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BRIEF HISTORY

The ISO Recommendation R 547, *Lengths and Tolerances of Electrodes for the Welding of Mild Steel and Low Alloy High Tensile Steel*, was drawn up by Technical Committee ISO/TC 44, *Welding*, the Secretariat of which is held by the Association Française de Normalisation (AFNOR).

Work on this question by the Technical Committee began in 1955 and led, in 1957, to the adoption of a Draft ISO Recommendation.

In September 1958, this Draft ISO Recommendation (No. 232) was circulated to all the ISO Member Bodies for enquiry. It was approved, subject to a few modifications of an editorial nature, by the following Member Bodies:

Austria	Germany	Poland
Belgium	India	Republic
Bulgaria	Israel	of South Africa
Burma	Italy	Romania
Denmark	Japan	Spain
Finland	Netherlands	Sweden
France	Norway	Switzerland

Three Member Bodies opposed the approval of the Draft:

Canada
United Kingdom
U.R.S.S.

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in January 1967, to accept it as an ISO RECOMMENDATION.

**LENGTHS AND TOLERANCES OF ELECTRODES
FOR THE WELDING OF MILD STEEL
AND LOW ALLOY HIGH TENSILE STEEL**

1. LENGTHS

Diameter	Length	
	mm	in
1	(150)	(6)
	200	8
1.25	(150)	(6)
	200	8
1.6	(150)	(6)
	200	8
	250	10
2	200	8
	250	10
	300	12
	350	14
2.5	250	10
	300	12
	350	14
above	350	14
2.5	450	18

The value in brackets should be avoided as far as possible. The inch values in this table correspond approximately to the exact metric values.

2. TOLERANCES ON LENGTHS

± 2 mm for metric measurements.

$\pm 1/12$ in for measurements expressed in inches.