

Revised

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION
R 864

SOLID WIRES FOR GAS-SHIELDED
METAL-ARC WELDING OF MILD STEEL
DIMENSIONS OF WIRES, SPOOLS, RIMS AND COILS

1st EDITION
November 1968

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BRIEF HISTORY

The ISO Recommendation R 864, *Solid wires for gas-shielded metal-arc welding of mild steel – Dimensions of wires, spools, rims and coils*, 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 1965 and led, in 1966, to the adoption of a Draft ISO Recommendation.

In March 1967, this Draft ISO Recommendation (No. 1159) 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 :

Australia	Greece	South Africa, Rep. of
Belgium	India	Spain
Brazil	Ireland	Switzerland
Bulgaria	Israel	Thailand
Canada	Netherlands	Turkey
Czechoslovakia	New Zealand	U.A.R.
Denmark	Norway	United Kingdom
Finland	Poland	U.S.A.
France	Portugal	U.S.S.R.
Germany	Romania	Yugoslavia

One Member Body opposed the approval of the Draft :

Sweden

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in November 1968, to accept it as an ISO RECOMMENDATION.

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ISO Recommendation

R 864

November 1968

**SOLID WIRES FOR GAS-SHIELDED
METAL-ARC WELDING OF MILD STEEL**

DIMENSIONS OF WIRES, SPOOLS, RIMS AND COILS

1. DIMENSIONS OF WIRES – NOMINAL DIAMETERS AND TOLERANCES

TABLE 1

Dimensions in millimetres

Nominal diameters	Tolerances
0.5 0.6	} + 0.01 - 0.03
0.8 0.9 1.0 1.2 1.6	} + 0.01 - 0.04
2.0 (2.4)* 2.5 3.2	} + 0.01 - 0.07

* Non-preferred diameter.

2. DIMENSIONS OF SPOOLS, RIMS AND COILS WITH FORMER

2.1 Dimensions of spools

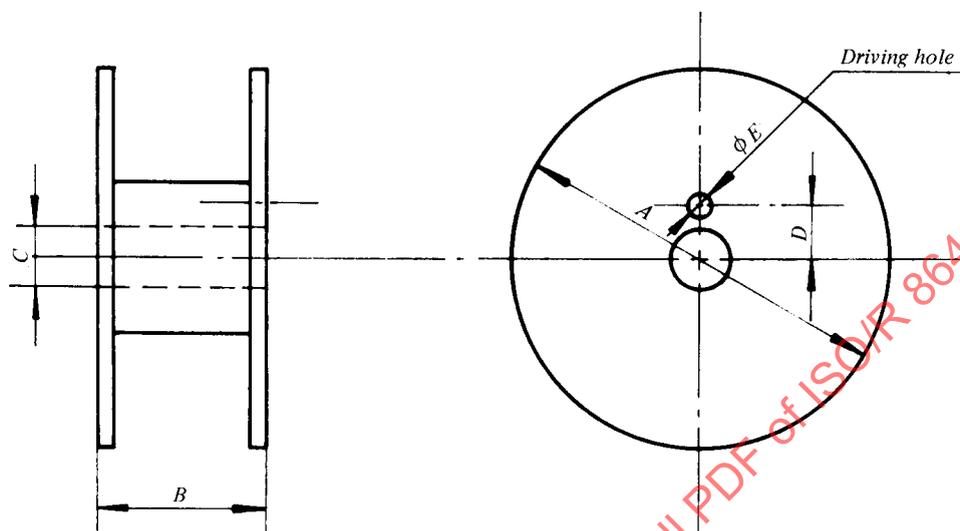


TABLE 2

Dimensions in millimetres

A		B		C		D		E	
Diameter	Tolerance	Width	Tolerance	Diameter	Tolerance	Distance between axes	Tolerance	Diameter	Tolerance
100	± 2	45	$\begin{matrix} 0 \\ -2 \end{matrix}$	16.0	$\begin{matrix} +1 \\ 0 \end{matrix}$	—	—	—	—
300	± 5	103	$\begin{matrix} 0 \\ -3 \end{matrix}$	50.5	$\begin{matrix} +2.5 \\ 0 \end{matrix}$	44.5	± 0.5	10	$\begin{matrix} +1 \\ 0 \end{matrix}$
350	± 5	103	$\begin{matrix} 0 \\ -3 \end{matrix}$	50.5	$\begin{matrix} +2.5 \\ 0 \end{matrix}$	44.5	± 0.5	10	$\begin{matrix} +1 \\ 0 \end{matrix}$
435	± 5	103	$\begin{matrix} 0 \\ -3 \end{matrix}$	50.5	$\begin{matrix} +2.5 \\ 0 \end{matrix}$	44.5	± 0.5	10	$\begin{matrix} +1 \\ 0 \end{matrix}$