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Superseding AMS2819A	

Identification, Welding Wire
Direct Color Code System

RATIONALE

AMS2819B has been reaffirmed to comply with the SAE five-year review policy.

1. SCOPE

This specification covers the procedures for identification and marking of bare welding wire by a color code system and marking of spools.

2. APPLICABLE DOCUMENTS

Not applicable.

3. TECHNICAL REQUIREMENTS

3.1 Marking Methods

3.1.1 Cut Lengths

Individual cut lengths shall be marked in accordance with 3.1.1.1. All containers, bags, tubes, etc, for wire shall be marked in accordance with 3.1.3.

3.1.1.1 The first color band shall be approximately 1/4 inch (6.4 mm) from one end of the wire and shall be 1/2 inch (12.7 mm) wide to designate the first number in the AMS specification. Each succeeding band shall be 1/4 inch (6.4 mm) wide with a 1/4 inch (6.4 mm) space between bands representing the succeeding numbers of the AMS specification in the proper order. The total length of the color code shall not exceed 2 1/4 inches (57.2 mm) from one end of the wire. Only one set of color bands shall be applied to each length of wire. The bands shall extend completely around the circumference of the wire.

TABLE 1 - COLOR CODE

Number	Color	Number	Color
0	Yellow	5	Green
1	Black	6	Orange
2	Blue	7	Violet
3	Brown	8	Red
4	Gray	9	White

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<http://www.sae.org/technical/standards/AMS2819B>

3.1.2 Spooled Wire

Wire shall not be color coded, but the outer face of one or both flanges of each spool shall be permanently and legibly marked with not less than the following minimum information:

Welding Wire Specification Number and Revision Letter (if any)
Size or Diameter
Quantity or Weight
Heat Number
Manufacturer's Identification

3.1.3 Container Labels

All containers, bags, tubes, etc, shall be marked with a pressure sensitive label providing the minimum information shown in 3.1.2.

4. QUALITY ASSURANCE PROVISIONS

Not applicable.

5. PREPARATION FOR DELIVERY

Not applicable.

6. ACKNOWLEDGMENT

Not applicable.

7. REJECTIONS

Wire not identified in accordance with this specification, or with modifications authorized by purchaser, will be subject to rejection.

8. NOTES

8.1 A change bar (I) located in the left margin is for the convenience of the user in locating areas where technical revisions, not editorial changes, have been made to the previous issue of this document. An (R) symbol to the left of the document title indicates a complete revision of the document, including technical revisions. Change bars and (R) are not used in original publications, nor in documents that contain editorial changes only.

8.2 Terms used in AMS are clarified in ARP1917.

8.3 Dimensions and properties in inch/pound units and the Fahrenheit temperatures are primary; dimensions and properties in SI units and the Celsius temperatures are shown as the approximate equivalents of the primary units and are presented only for information.