

INTERNATIONAL STANDARD



547

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Electrodes for the welding of mild steel and low alloy high tensile steel — Lengths and tolerance

Électrodes pour le soudage des aciers doux et des aciers faiblement alliés à haute résistance — Longueurs et tolérance

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FOREWORD

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO Member Bodies). The work of developing International Standards is carried out through ISO Technical Committees. Every Member Body interested in a subject for which a Technical Committee has been set up has the right to be represented on that Committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work.

Draft International Standards adopted by the Technical Committees are circulated to the Member Bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 547 was drawn up by Technical Committee ISO/TC 44, *Welding*, and circulated to the Member Bodies in October 1973.

It has been approved by the Member Bodies of the following countries :

Australia	Germany*	South Africa, Rep. of
Austria	India	Spain
Belgium	Ireland	Sweden
Bulgaria	Israel	Switzerland
Canada	Italy	Thailand
Chile	Mexico	Turkey
Czechoslovakia	Netherlands	United Kingdom
Egypt, Arab Rep. of	New Zealand	U.S.A.
Finland	Portugal	U.S.S.R.
France	Romania	Yugoslavia

The Member Body of the following country expressed disapproval of the document on technical grounds :

Japan

* with the exception of clause 3.

This International Standard cancels and replaces ISO Recommendation R 547-1967, of which it constitutes a technical revision.

Electrodes for the welding of mild steel and low alloy high tensile steel — Lengths and tolerance

1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies lengths and tolerance of electrodes in relation to their diameter.¹⁾

It only deals with electrodes for the welding of mild steel and low alloy high tensile steel.

2 LENGTHS

Dimensions in millimetres

Diameter	Length
1	(150) 200
1,25	(150) 200
1,6	(150) 200 250
2	(200) 250 300 350
2,5	250 300 350
3,15	350 450
4 and over	350 450 500 600 700 900

The values in brackets should be avoided as far as possible.

3 TOLERANCE ON LENGTHS

The tolerance on lengths is ± 2 mm.

1) See ISO 544, *Electrodes for manual arc welding and filler metals for gas welding — Diameters and tolerances*.