

Table 6 Diameter of Cast and Helix

(Clauses 10 2 2 and 10 2 3)

Type of Package	Standard Size mm	Cast mm	Maximum Helix, mm
100 mm spool	1 2 and less	200-230	13
All except 100 mm spool	0 8 and less	305 Minimum	25
	0 9 and larger	380 Minimum	25

11.2 In a classification, for example, S5-M 504 where S5 indicates chemical composition of the wire, M indicates that it is mixed gas, 50 indicates tensile strength of minimum 500 MPa and 4 indicates the impact values at 27 joules at minus 30°C

12 CHEMICAL COMPOSITION

The chemical composition of filler rods and wires when analyzed in accordance with the relevant part of IS 228 shall be as given in Table 7

13 MECHANICAL PROPERTY REQUIREMENTS

also the soundness and mechanical properties of the weld deposits

14.1 Chemical Composition

The chemical composition of the filler wire/rod should satisfy the chemical analysis as per Table 7 The chemical analysis shall be made using either 1 2 mm or 1 6 mm diameter filler metal If the above sizes are not in the manufacturing range, then the size being manufactured nearer to 1 2 mm or 1 6 mm diameter shall be taken for chemical analysis In case of GTAW preferred size shall be 2 4 or 3 2 mm