



INTERNATIONAL STANDARD ISO 3581:2003
TECHNICAL CORRIGENDUM 1

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

**Welding consumables — Covered electrodes for manual metal arc welding of stainless and heat-resisting steels —
Classification**

TECHNICAL CORRIGENDUM 1

Produits consommables pour le soudage — Électrodes enrobées pour le soudage manuel à l'arc des aciers inoxydables et résistant aux températures élevées — Classification

RECTIFICATIF TECHNIQUE 1

Technical Corrigendum 1 to ISO 3581:2003 was jointly prepared by the International Institute of Welding, Commission II, *Arc welding and filler metals*, and Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 3, *Welding consumables*. IIW has been approved as an international standardizing body in the field of welding by the ISO Council.

Page 16, Table 7B, column 6

In row 1, “(maximum)” has been inserted after “(length of leg)”. In all cells of the subsequent rows “max.” and “min.” have been deleted. A corrected version of Table 7B appears overleaf.

Table 7B — Fillet weld test plate thickness and test results required
(classification according to alloy type)

ISO 3581-B symbols for position and coating type	Electrode diameter mm	Type of current	Nominal plate thickness <i>t</i> mm	Test position	Fillet size (length of leg) (maximum) mm	Maximum leg length difference mm	Maximum convexity mm
-15	4,0	d.c.+	6 or 8 or 10	PF	8,0	Not specified	2,0
	4,0		6 or 8 or 10	PB and PD	6,0	1,5	1,5
	4,8 or 5,0		10	PB	8,0	1,5	2,0
	5,6 or 6,0 or 6,4		10	PB	10,0	2,0	2,0
-16	4,0	a.c.	6 or 8 or 10	PF	8,0	Not specified	2,0
	4,0		6 or 8 or 10	PB and PD	6,0	1,5	1,5
	4,8 or 5,0		10	PB	8,0	1,5	2,0
	5,6 or 6,0 or 6,4		10	PB	10,0	2,0	2,0
-17	4,0	a.c.	6 or 8 or 10	PF	12,0	Not specified	2,0
	4,0		6 or 8 or 10	PB and PD	8,0	1,5	1,5
	4,8 or 5,0		10	PB	8,0	1,5	2,0
	5,6 or 6,0 or 6,4		10	PB	10,0	2,0	2,0
-25	4,0	d.c.+	10 or 12	PB	8,0	1,5	1,5
	4,8 or 5,0				8,0	1,5	2,0
	5,6 or 6,0 or 6,4				10,0	2,0	2,0
-26 or -27	4,0	a.c.	10 or 12	PB	8,0	1,5	1,5
	4,8 or 5,0				8,0	1,5	2,0
	5,6 or 6,0 or 6,4				10,0	2,0	2,0
-45, -46 or -47	2,4 or 2,5	d.c.+	6 or 8 or 10	PG	5,0	Not specified	2,0 ^a
	3,0 or 3,2			PG	6,0		3,0 ^a
	4,0			PG	8,0		4,0 ^a
	4,8 or 5,0			PG	10,0		5,0 ^a

^a Maximum concavity.