

Core Wire for Covered Electrodes*

1. **Scope** This standard specifies core wire of covered electrodes (hereinafter referred to as the "core wire") principally used in arc welding of mild steel.

3.1 The core wire shall be manufactured from the wire rod conforming to JIS G 3503-Wire Rod for Core Wire of Arc Coated Electrodes by cold drawing.

4.1 The core wire shall have, on finished goods, the chemical composition as given in Table 1.

Table 1

Class	Symbol	Chemical composition %					
		C	Si	Mn	P	S	Cu
Class 1	No. 1 SWY 11	0.09 Max	0.03 Max	0.35 ~0.65	0.020 Max	0.023 Max	0.20 Max
	No. 2 SWY 12	0.09 Max	0.03 Max	0.35 ~0.65	0.030 Max	0.030 Max	0.30 Max
Class 2	No. 1 SWY 21	0.10 ~0.15	0.03 Max	0.35 ~0.65	0.020 Max	0.023 Max	0.20 Max
	No. 2 SWY 22	0.10 ~0.15	0.03 Max	0.35 ~0.65	0.030 Max	0.030 Max	0.30 Max

5.1 The diameter of core wire shall be in accordance with Table 2.

Table 2

Diameter	Unit : mm							
	1.0	1.4	2.0	2.6	3.2	4.0		
	4.5	5.0	5.5	6.0	6.4	7.0	8.0	9.0 10.0

5.2 The tolerance on diameter of core wire shall be in accordance with Table 3.

Table 3

Diameter	Unit : mm	
	Tolerance	
8 Max	±0.05	
Exceeding 8	±0.10	

Wire Rope *

1. Scope

This standard covers steel wire ropes for machines, construction work, ships, fisheries, logging, mining, aerial ropeways, elevators and others, hereinafter referred to as "rope".

2. Classification

2.1 Type of Construction Ropes shall be classified into 23 kinds of Type 1 to Type 23 according to the type of construction as listed in Table 1. The constructions and cross section of ropes are represented by Type Number or Rope Designation.