

**Table 5 – Wire Type IQI Selection**

**Table 5—Weld Thickness Versus Diameter of ASTM E 747 Wire Type IQI**

Weld Thickness		Essential Wire Diameter		ASTM Set Letter
Inches	Millimeters	Inches	Millimeters	
0 – 0.250	0 – 6.4	0.008	0.20	A
> 0.250 – 0.375	> 6.4 – 9.5	0.010	0.25	A or B
> 0.375 – 0.500	> 9.5 – 12.7	0.013	0.33	B
> 0.500 – 0.750	> 12.7 – 19.1	0.016	0.41	B
> 0.750 – 1.000	> 19.1 – 25.4	0.020	0.51	B
> 1.000 – 2.000	> 25.4 – 50.8	0.025	0.64	B

**Table 6—Weld Thickness Versus Diameter of ISO Wire Type IQI**

Weld Thickness		Essential Wire Diameter		Wire Identity
Inches	Millimeters	Inches	Millimeters	
0 – 0.250	0 – 6.4	0.008	0.20	13
> 0.250 – 0.375	> 6.4 – 9.5	0.010	0.25	12
> 0.375 – 0.500	> 9.5 – 12.7	0.013	0.33	11
> 0.500 – 0.750	> 12.7 – 19.1	0.016	0.41	10
> 0.750 – 1.000	> 19.1 – 25.4	0.020	0.51	9
> 1.000 – 2.000	> 25.4 – 50.8	0.025	0.64	8

**Table 1 - DIN Wire Type IQI**

DIN Pack Designation	Wire Diameter mm (inch) Corresponding Wire Number						
	3.20 (0.125) 1	2.50 (0.098) 2	2.00 (0.078) 3	1.60 (0.062) 4	1.25 (0.050) 5	1.00 (0.040) 6	0.80 (0.032) 7
1 FE DIN							
6 FE DIN	1.00 (0.040) 6	0.80 (0.032) 7	0.63 (0.024) 8	0.50 (0.020) 9	0.40 (0.016) 10	0.32 (0.013) 11	0.25 (0.010) 12
10 FE DIN	0.40 (0.016) 10	0.32 (0.013) 11	0.25 (0.010) 12	0.20 (0.008) 13	0.16 (0.006) 14	0.125 (0.004) 15	0.1 (0.004) 16

**Table 2 - ISO Wire Type IQI**

ISO Pack Designation	Wire Diameter mm (inch) Corresponding Wire Number						
	3.20 (0.125) 1	2.50 (0.098) 2	2.00 (0.078) 3	1.60 (0.062) 4	1.25 (0.050) 5	1.00 (0.040) 6	0.80 (0.032) 7
1 ISO 7							
6 ISO 12	1.00 (0.040) 6	0.80 (0.032) 7	0.63 (0.024) 8	0.50 (0.020) 9	0.40 (0.016) 10	0.32 (0.013) 11	0.25 (0.010) 12
10 ISO 16	0.40 (0.016) 10	0.32 (0.013) 11	0.25 (0.010) 12	0.20 (0.008) 13	0.16 (0.006) 14	0.125 (0.004) 15	0.1 (0.004) 16

**Table 3 - ASTM Wire Type IQI**

ASTM Set Designation	Wire Diameter mm (inch) Corresponding Wire Number					
	A	0.081 (0.0032) 1	0.102 (0.004) 2	0.127 (0.005) 3	0.160 (0.0063) 4	0.203 (0.008) 5
B	0.254 (0.010) 6	0.330 (0.013) 7	0.406 (0.016) 8	0.508 (0.020) 9	0.635 (0.025) 10	0.813 (0.032) 11
C	0.813 (0.032) 11	1.016 (0.040) 12	1.27 (0.050) 13	1.6 (0.063) 14	2.03 (0.080) 15	2.54 (0.100) 16
D	2.54 (0.100) 16	3.2 (0.126) 17	4.06 (0.160) 18	5.08 (0.200) 19	6.35 (0.250) 20	8.13 (0.320) 21

**Table 4 - Wire Type IQI Designation**

Wire diameter mm	DIN IQI wire Number	ISO IQI wire Number	ASTM IQI wire Number
8.0	NA	NA	21
6.4	NA	NA	20
5.1	NA	NA	19
4.0	NA	NA	18
3.2	1	1	17
2.5	2	2	16
2.0	3	3	15
1.6	4	4	14
1.25	5	5	13
1.0	6	6	12
0.80	7	7	11
0.63	8	8	10
0.50	9	9	9
0.40	10	10	8
0.32	11	11	7
0.25	12	12	6
0.20	13	13	5
0.16	14	14	4
0.125	15	15	3
0.100	16	16	2
0.08	NA	NA	1

**Note: The wire diameters in metric units are the standard. The metric values for ASTM wires are close to the US customary units.**

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**Table 6—Weld Thickness Versus Diameter of ISO Wire Type IQI**

Weld Thickness		Essential Wire Diameter		Wire Identity
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> 1.000 – 2.000	> 25.4 – 50.8	0.025	0.64	8