

Sizes, Tolerances and Average Weights

Diameters and tolerances in accordance with IEC standard

Nominal diameter	Typical diameter		Range tolerance in accordance with IEC standard	Permissible flat spots
	mm	inch		
500	508	20	505...511	502
550	559	22	556...562	553
600	610	24	607...613	604
650	661	26	659...663	656
700	712	28	710...714	707
750	763	30	761...765	758

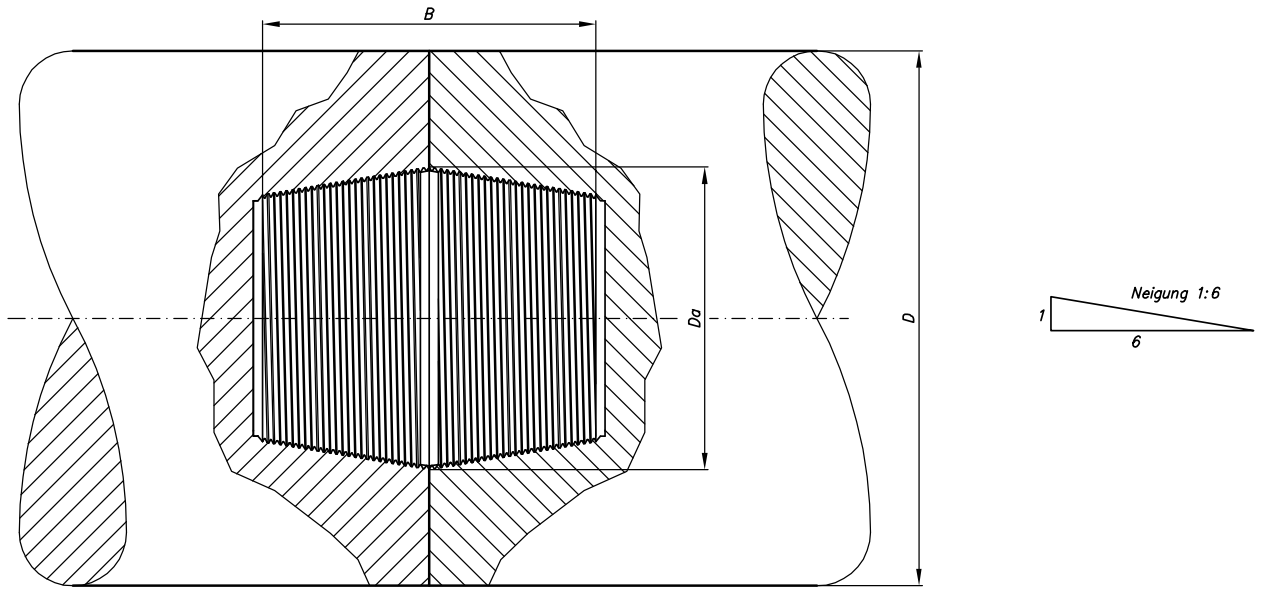
Lengths and tolerances in accordance with IEC standard

Nominal length	Tolerance in length		Shortfall in length, in mm (per delivery up to 15% permissible)
	max. mm	min. mm	
1800	+ 100	- 100	- 275
2100	+ 125	- 125	- 275
2400	+ 125	- 125	- 275
2700	+ 200	- 150	- 300

Standard Sizes and Average Weights of Electrodes and Nipples

Nominal diameter	Typical diameter		Length	
	mm	inch	mm	inch
500	508	20	1800	72
			2100	84
			2400	96
550	559	22	1800	72
			2100	84
			2400	96
600	610	24	2100	84
			2400	96
			2700	108
650	661	26	2100	84
			2400	96
			2700	108
700	712	28	2100	84
			2400	96
			2700	108
750	763	30	2400	96
			2700	108

Nominal Sizes of Taper Nipples



International code according to IEC	Sizes in millimetres			Sizes in inches		
	D	Da	B	D	Da	B
N 269 T4N	508	269.88	355.60	20	10 5/8	14
N 269 T4L	508	269.88	457.20	20	10 5/8	18
N 298 T4N	559	298.45	355.60	22	11 3/4	14
N 298 T4L	559	298.45	457.20	22	11 3/4	18
N 317 T4N	610	317.50	355.60	24	12 1/2	14
N 317 T4L	610	317.50	457.20	24	12 1/2	18
N 355 T4N	660	355.60	457.20	26	14	18
N 355 T4L	660	355.60	558.80	26	14	22
N 374 T4N	711	374.65	457.20	28	14 3/4	18
N 374 T4L	711	374.65	558.80	28	14 3/4	22