Society of Automotive Engineers, Inc.
TWO PENNSYLVANIA PLAZA, NEW YORK, N.Y. 1000

AEROSPACE MATERIAL SPECIFICATION

AMS 2813B
Superseding AMS 2813A
Issued 1-15-63
Revised 11-1-68

PACKAGING OF WELDING WIRE
Standard Method

1. ACKNOWLEDGMENT: A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.

2. APPLICATION: To assure cleanliness of bare wire for welding.

3. PACKAGING: Wire shall be packaged in such a manner as to ensure that the wire, during shipment and storage, will be protected against mechanical injury, dirt, grease, and other contamination.

3.1 Cut Lengths: Wire shall be furnished in standard containers of approximately 5, 10, 25, 50, or 100 lb weight, as ordered.

3.2 Spooled Wire:

3.2.1 Spools shall be of such material and construction as to provide adequate strength and rigidity to prevent damage or distortion in normal handling and use and to insulate the wire from the spindle.

3.2.2 Unless otherwise specified, spool dimensions shall conform to the dimensions shown in Fig. 1 or Fig. 2, as applicable. Barrel outside diameter "B" shall be such as to permit proper feeding of the wire; barrel inside diameter "C" of Fig. 2 shall be such that swelling of the barrel or misalignment of the barrel and flanges will not prevent free assembly of the spool on a welding machine. Holes shall be provided in the flange at the surface of the hub and near the OD of the flange for the start and finish ends of the wire. These holes need not be in line.

3.2.3 Unless otherwise specified, wire shall be one continuous length, layer wound, and furnished on spools containing approximately the ordered net weight selected from the following table; up to Ø 20% of the net weight of any lot in the shipment may be on spools containing not less than 50% of the ordered spool net weight. Welding to form a continuous length is not permitted unless performed prior to the final drawing operation.

Material	Spool Net Weight, lb
Aluminum	1, 10, 12-1/2
Magnesium	3/4, 1, 9, 10
Titanium	1, 10, 20
Copper	25, 50
Steels, Corrosion Resistant Alloys, and Refractory Metals	25, 35, 60

4. PACKING: Containers of cut lengths shall be packed in standard exterior shipping containers of approximately 5, 10, or 100 lb, as ordered. Containers of spooled wire shall be packed in standard exterior shipping containers containing the ordered multiple of standard spool weights up to a maximum net weight of 120 pounds.

5. IDENTIFICATION:

5.1 Cut Lengths: Each container shall be imprinted with, or shall bear a label showing, the following information:

_____WIRE, WELDING
WIRE SPECIFICATION NUMBER _____
SIZE _____
QUANTITY _____
HEAT NUMBER (If Applicable) _____
MANUFACTURER'S IDENTIFICATION _____
WIRE IDENTIFICATION SPECIFICATION (AMS 2815 or AMS 2816)
CODE NUMBER (From AMS 2815 or AMS 2816) _____

5.2 Spooled Wire: Spools shall be marked as required by the applicable wire identification or material specification; one end of each spool container shall be permanently and legibly marked with the following information:

_____WIRE, WELDING
WIRE SPECIFICATION NUMBER _____
SIZE _____
QUANTITY _____
HEAT NUMBER (If Applicable) _____
MANUFACTURER'S IDENTIFICATION _____
WIRE IDENTIFICATION SPECIFICATION (AMS 2815 or AMS 2816)
CODE NUMBER (From AMS 2815 or AMS 2816) _____

5.3 Exterior Shipping Containers: Each container of cut lengths and of spools shall be permanently and legibly marked with the following information:

_____WIRE, WELDING
WIRE SPECIFICATION NUMBER _____
SIZE _____
QUANTITY _____
HEAT NUMBER (If Applicable) _____
PURCHASE ORDER NUMBER _____
MANUFACTURER'S IDENTIFICATION _____
WIRE IDENTIFICATION SPECIFICATION (AMS 2815 or AMS 2816)
PACKAGED PER AMS 2813

6. REJECTIONS: Wire not packaged in accordance with this specification or with authorized modifications will be subject to rejection.