

Refer to Table 5 API 1104 20th Edition

Weld Thickness Inches	Essential Wire Diameter Inches	ASTM Set Letter
0–0.250	0.008	A
> 0.250–0.375	0.010	A or B
> 0.375–0.500	0.013	B
> 0.500–0.750	0.016	B
> 0.750–1.000	0.020	B
> 1.000–2.000	0.025	B