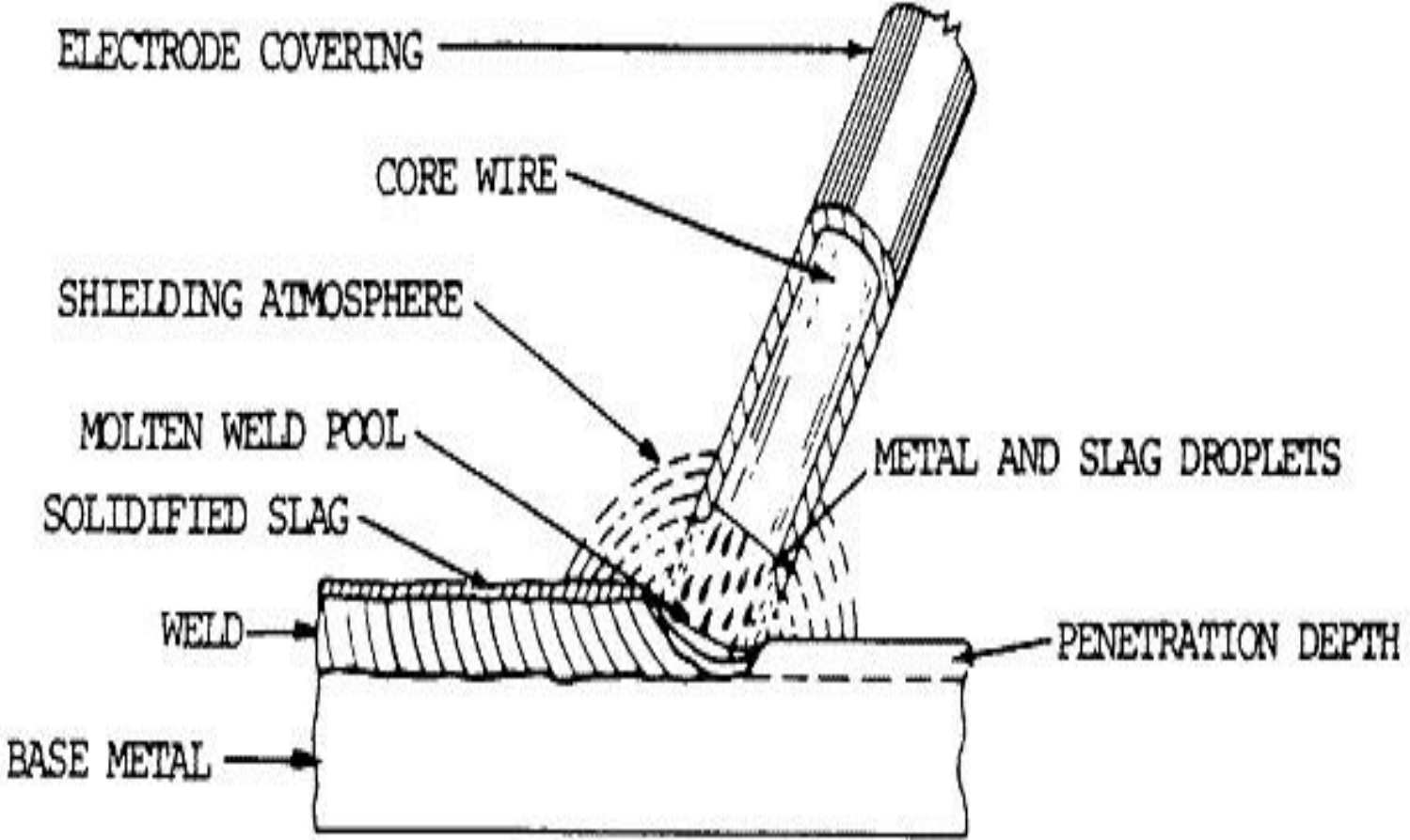


ELECTRODE CODING

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Electrode Classifications

E = Arc welding electrode

Positions of welding:

1 = all positions (flat, horizontal, vertical and overhead)

2 = horizontal and flat positions only

3 = flat position only

E6013

Tensile strength
first two (or three)
numbers x 1000 or
60 X 1000 = 60,000 psi

power supply
type of coating
polarity
type of arc penetration

ELECTRODE CODING

Electrode	Coating	Position	Current	Penetration	Tensile Strength
E-6010	High Cellulose Sodium	All Positions	DCEP	Deep	60,000 PSI
E-6011	High Cellulose Potassium	All Positions	DCEP AC	Deep	60,000 PSI
E-6012	High Titania Sodium	All Positions	DCEP AC	Medium	60,000 PSI
E-6013	High Titania Potassium	All Positions	DCEP DCEN AC	Shallow	60,000 PSI
E-7018	Iron Powder Low hydrogen	All Positions	DCEP AC	Shallow to Medium	70,000 PSI
E-7028	Iron Powder Low hydrogen	Flat Horizontal Fillets	DCEP AC	Shallow to Medium	70,000 PSI