

# Info – WELd no. 19 - a



## WELDAMAX WELDING INFORMATION BULLETIN

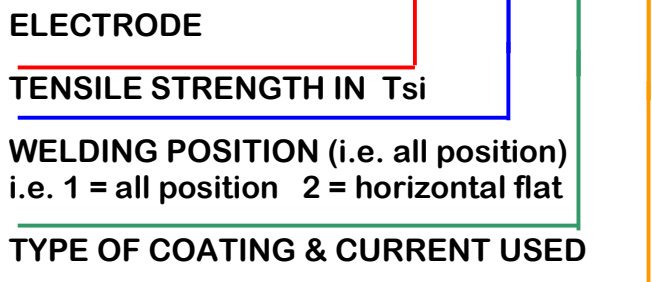
### AMERICAN WELDING SOCIETY (AWS)

### MILD & LOW ALLOY STEEL WELDING CONSUMABLE CLASIFICATIONS

#### ARC WELDING ELECTRODES

AWS A5.1 – 91

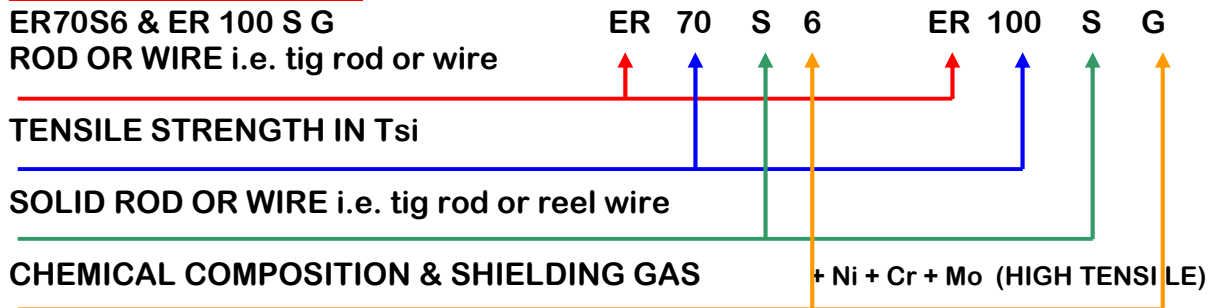
(E6013)	E	60	1	3
(E7018)	E	70	1	8
(E7024)	E	70	2	4
(E11018)	E	110	1	8



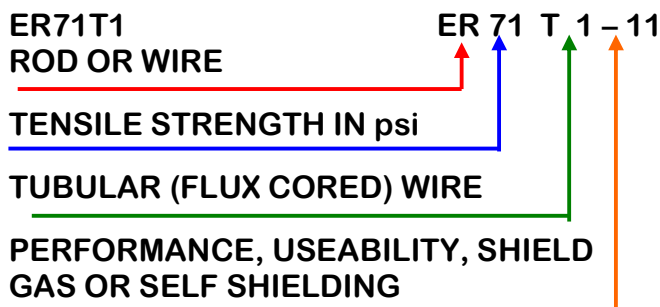
#### ELECTRODE DESIGNATIONS FOR COVERED ARC WELDING ELECTRODES

DESIGNATION	CURRENT	COVERING TYPE
E XX10	DC(+) ONLY	ORGANIC
E XX13	AC/DC + -	RUTILE
E XX18	AC/DC +	LOW HYDROGEN + IRON POWDER
E XX18 -1	AC/DC + -	LOW HYDROGEN + IRON POWDER + IMPACT TOUGHNESS
E XXX18	AC/DC + -	LOW HYDROGEN + IRON POWDER
E XX24	AC/DC + -	RUTILE + IRON POWDER HIGH DEPOSTION

#### T.I.G. RODS & WIRE AWS A5.18 - 79



#### FLUX CORED WIRES AWS A5.20 – 79



AWS CLASSIFICATION	SHIELDING GAS	CURRENT/ POLARITY
E 70 T 1	CO <sup>2</sup> or ARGON/CO <sup>2</sup>	DC +
E 70 T 2	CO <sup>2</sup> or ARGON/CO <sup>2</sup>	DC +
E 70 T 3	SELF SHIELDING	DC +
E 70 T 4	SELF SHIELDING	DC +
E 70 T 5	CO <sup>2</sup> or ARGON/CO <sup>2</sup>	DC +
E 70 T 6	SELF SHIELDING	DC +
E 70 T 7	SELF SHIELDING	DC -
E 70 T 8	SELF SHIELDING	DC -
E 70 T 10	SELF SHIELDING	DC -
E 70 T 11	SELF SHIELDING	DC -