

ALL ABOUT WELD - STICK ELECTRODE QUICK REFERENCE

Electrode	Position	Amperage (typical)	Application
E6010	All	75-115 A	Root passes, pipe, dirty steel
E6011	All	75-125 A	AC/DCEP root and fill
E6013	All	80-130 A	Light sheet, cosmetic caps
E7018	All	90-160 A	Structural, low-hydrogen fill/cap
E7024	Flat	120-200 A	High-deposition flat fillets

Store E7018 in a rod oven (120-150 C) once the can is opened.

Low-hydrogen electrodes must stay dry for code work.