



Available in select sizes only

AWS Spec. Alloys: Mild Steel, A5.1

E6010 A deep-penetrating mild steel electrode designed for all-position welding. Use on DC+ (electrode positive). Characterized by friable slag covering and active deep penetrating arc, E6010 is excellent for open root welds.

Code #	Size	Type & Specification	Amperage	Tensile	Yield	Elongation
120-2-6010	3/16"	AWS A5.1, E6010	150-210	60,000 psi	48,000 psi	22%
120-3-6010	5/32"	ABS-AWS A5.1	110-170	414 MPa	331 MPa	
120-4-6010	1/8"	ASME-SFA5.1	75-125			
120-5-6010	3/32"		40-80			

E6011 A similar electrode to E6010 designed to operate on AC welding current. While capable for use on DC+, (electrode positive) some loss in joint penetration will occur when compared to E6010.

Code #	Size	Type & Specification	Amperage	Tensile	Yield	Elongation
120-3-6011	5/32"	ASME SFA 5.1 (A-1, F-3)	110-170	60,000 psi	48,000 psi	22%
120-4-6011	1/8"	ABS-AWS A5.1	75-125	414 MPa	331 MPa	
120-5-6011	3/32"	-	40-80			

E6013 A smooth-running, low penetration mild steel electrode designed for all-position welding. Its lower penetration and high fill rate make it suitable for thin metal. Characterized by a smooth arc and easy slag removal, E6013 is an excellent general-purpose mild steel electrode. Use AC or DC current.

Code #	Size	Type & Specification	Amperage	Tensile	Yield	Elongation
120-3-6013	5/32"	AWS A5.1, ASME SFA 5.1	105-180	60,000 psi	48,000 psi	22%
120-4-6013	1/8"		80-130	414 MPa	331 MPa	
120-5-6013	3/32"		45-90			

E7014 While similar to E6013, the E7014 electrode is designed for higher strength and greater desposition. E7014 can be used in all positions but the high fill rate lends it to be used in poor fit-up situations. E7014 is characterized by flat smooth beads with easy slag removal. Use AC or DC current.

Code #	Size	Type & Specification	Amperage	Tensile	Yield	Elongation
120-3-7014	5/32"	ASME SFA 5.1 (A-1, F-2)	150-210	70,000 psi	58,000 psi	17%
120-4-7014	1/8"	ABS-AWS A5.1	110-160	483 MPa	400 MPa	
120-5-7014	3/32"		80-125			

X-Ergon E7018 This low-hydrogen electrode is designed with an inorganic covering to reduce the presence of diffusible hydrogen. Hydrogen is detrimental to the physical properties of many steels. E7018 is an all-position, mild steel, low-hydrogen coated electrode that reduces the need for preheat on heavy sections and can be used on high strength, high carbon and some low alloy steels. E7018 electrodes are characterized by a smooth quiet arc, low spatter and medium penetration. Store dry and sealed or in a rod oven. Use DCEP.

Code #	Size	Type & Specification	Amperage	Tensile	Yield	Elongation
120-2-7018	3/16"	-	200-300	78,000 psi	58,000 psi	30%
120-3-7018	5/32"	ABS-AWS A5.1, 2Y	130-220	538 MPa	400 MPa	
120-4-7018	1/8"		90-160			
120-5-7018	3/32"		70-100			

E7024 This electrode is designed for high deposition and is well suited for flat and horizontal fillet welds. The weld face is flat or slightly convex with a smooth surface and a very fine ripple. It is commonly used with a "drag" technique, and is commonly called "jet rod" because of the spray-arc characteristics. Use DCEP.

Code #	Size	Type & Specification	Amperage	Tensile	Yield	Elongation
120-2-7024	3/16"	AWS A5.1, ASME SFA 5.1 (A-1, F-1)	230-305	70,000 psi	58,000 psi	17%
120-3-7024	5/32"	ABS Filler Grade 2-2Y	180-250	483 MPa	400 MPa	
120-4-7024	1/8"		140-190			