

COATED ARC WELDING ELECTRODES - TYPES & STYLES —

A. W. S.
Classification

- E6010** **Direct Current, Reverse polarity, All Positions.**
All purpose. Moderately smooth finish. Good penetration.
This is the electrode used for most carbon steel pipe
welding.
- E6011** **Alternating Current, All Positions.**
All purpose. Moderately smooth finish. Good penetration.
- E6012** **Direct Current, Straight Polarity, All Positions.**
High bead. Smooth. Fast. “Cold rod”.
- E6013** **Alternating Current, All Positions.**
High bead. Smooth. Fast. “Cold rod”.
- E6015** **Direct Current, Reverse polarity, All Positions.**
“Low hydrogen” electrode.
- E6016** **Direct Current or Alternating Current, All Positions**
“Low hydrogen” electrode.
- E6018** **Direct Current, All Positions**
“Low hydrogen” iron powder electrodes
- E6020** **Direct Current, Straight Polarity, Flat Position Only.**
Flat bead. Smooth. Fast. Deep penetration. Can be used
with A.C. also. “Hot rod”.
- E6024** **Direct Current, Straight Polarity or**
and **Alternating and Current, Flat Position Only.**
E6027 **Flat bead. Smooth. Fast. Deep penetration.**
“Iron powder electrodes”.

NOTE: This information also applies to E70, E80, E90, and E100 Series.
The last two numbers (in bold type) designate the types or styles
and the first two numbers the minimum specified tensile strength
in 1,000 psi of the weld deposit as welded.