

Type	AWS Class	Current Type	Welding Position	Weld Results
Mild Steel	E6010	DCR	F, V, OH, H	Fast freeze, deep penetrating, flat beads, all- purpose welding
	E6011	DCR, AC	F, V, OH, H	
	E6012	DCS, AC	F, V, OH, H	Fill-freeze, low penetration, for poor fit-up, good bead contour, minimum spatter
	E6013	DCR, DCS, AC	F, V, OH, H	
	E6014	DCS, AC	F, V, OH, H	
	E6020	DCR, DCS, AC	F, H	Fast-fill, high deposition, deep groove welds, single pass
	E6024	DCR, DCS, AC	F, H	
	E6027	DCR, DCS, AC	F, H	Iron powder, high deposition, deep penetration
	S7014	DCR, DCS, AC	F, V, OH, H	Iron powder, low penetration, high speed
	E7024	DCR, DCS, AC	F, H	Iron powder, high deposition, single and multiple pass
Low Hydrogen	E6015	DCR	F, V, OH, H	Welding of high-sulphur and high-carbon steels that tend to develop porosity and crack under weld deposit
	E6016	DCR, AC	F, V, OH, H	
	E6018	DCR, AC	F, V, OH, H	
	E7016	DCR, AC	F, V, OH, H	
	E7018	DCR, AC	F, V, OH, H	
	E7028	DCR, AC	F, H	
Stainless Steel	E308-15,16	DC, AC	F, V, OH, H	Welding stainless steel 301, 302, 303 304, 308
	E309-15,16	DC, AC	F, V, OH, H	Welding 309 alloy at elevated temperature application and dissimilar metals
	E310-15,16	DC, AC	F, V, OH, H	Welding type 310 and 314 stainless steel where high corrosion and elevated temperatures are required
	E316-15,16	DC, AC	F, V, OH, H	Welding type 316 stainless steel and welds of highest quality. Contains less carbon to minimize carbon transfer in the weld. Type 316 reduces pitting corrosion
	E347-15,16	DC, AC	F, V, OH, H	For welding all grades of stainless steels
Low Alloy	E7011-A1	DCR, AC	F, V, OH, H	For welding carbon moly steels
	E7020-A1	DCR, DCS, AC	F 2	
	E8018-C3	DCR, AC	F, V, OH, H	For low alloy, high-tensile strength
	E10013-G	DCS, AC	F, V, OH, H	For low alloy, high-tensile steels
DCR – Direct Current Reverse Polarity DCS – Direct Current Straight Polarity			AC – Alternating Current F – flat, V-vertical, OH – overhead, H-horizontal	

Welding Rod Guide

K. R. Rao



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