

Oven Storage & Reconditioning of Stick Electrodes

Welding electrodes may be damaged by atmospheric moisture. The following table recommends proper storage conditions, and time and temperature for reconditioning electrodes that have absorbed excess moisture.

Notes for table: Pallets and unopened cartons of electrodes should be stored away from exposure to water in the form of rain, snow, spray, or humidity. Only hermetically sealed cans are sealed against these conditions.

Damaged cartons permit entry of damp air which may be picked up by the product and lower its quality. Humidity below 50% should be avoided for 6010, 6011, 6012 and 6013 electrodes. At no time should these classes of electrodes be stored in an oven above 130°F (55°C).

The instruction, "Dry at Room Temperature" in the table signifies that the humidity should be below 70% and the temperature should be within the limits 40°F to 120°F (4°C to 50°C).

Item Designation	Storage of Contents of Open Cartons*	Reconditioning*
Mild Steel & Low Alloy Cellulosic – 6010, 6011, 7010, 8010	Dry at room temperature	Not recommended
Mild Steel – 6013, 6022, 7014, 7024	100° – 130°F (40° – 55°C)	250°F – 300°F, 1 hour (120° – 150°C)
Mild Steel & Low Alloy Low Hydrogen – 7018, 8018, 9018, 11018	250°F – 300°F (120° – 150°C)	500°F – 800°F, 1-2 hours (260° – 425°C)
Stainless Steel Stick Electrodes Sterling AP & AC/DC (AWS-16) Sterling (AWS-17)	225°F – 260°F (108° – 125°C)	500°F – 600°F, 1 hour (260° – 315°C)
Hardalloy® Surfacing	225°F – 260°F (108° – 125°C)	450°F – 600°F, 1 hour (235° – 315°C)

*Remove any packaging that may be damaged from oven storage or reconditioning.