



Oven Storage and 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:

All covered electrodes in unopened and undamaged hermetically sealed containers can be stored in a dry environment for extended periods of time without having to be kept in oven storage. After the containers have been opened the electrodes should be stored as shown in the following table. Damaged cartons permit entry of damp air which may be picked up by the product and lower its quality and performance.

Item Designation	Storage of Contents of opened Cartons*	Reconditioning
Mild Steel -6010, 6011	Dry at room temperature	Not recommended
Mild Steel Low Alloy – 7010, 8010	Dry at room temperature	Not recommended
Mild Steel – 6012, 6013, 6022, 7014, 7024	100°F - 130°F	250°F - 300°F, 1 hr
Mild Steel Low Hydrogen – 7018, 8018, 9018, 10018, 11018, 12018	250°F - 300°F	500°F - 800°F, 1-2 hrs.
Stainless Steel – AWS -15, AWS -16 AWS -17	225°F - 260°F	500°F - 600°F, 1 hr.
Hard Surfacing	225°F - 260°F	450°F - 600°F, 1 hr.
Special Maintenance Electrodes	225°F - 260°F	500°F - 550°F, 1 hr.
Cast Iron Electrodes	225°F - 260°F	250°F - 300°F, 1 hr.

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