Arc Welding Rod Chart

by WcWelding.com

Type	AWS Class	Current Type	Welding Position	Weld Results
Mild Steel	E6010 E6011	DCR DCR, AC	F, V, OH, H F, V, OH, H	Fast freeze, deep penetrating, flat beads, all- purpose welding
	E6012 E6013 E6014	DCS,AC DCR,DCS,AC DCS,AC	F, V, OH, H F, V, OH, H F, V, OH, H	Fill-freeze, low penetration, for poor fit-up, good bead contour, minimum spatter
	E6020 E6024	DCR,DCS,AC DCR,DCS,AC	F, H F, H	Fast-fill, high deposition, deep groove welds, single pass
	E6027	DCR,DCS,AC	F, H	Iron powder, high deposition, deep penetration
	57014	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 E6016 E6018 E7016 E7018 E7028	DCR DCR,AC DCR,AC DCR,AC DCR,AC DCR,AC	F, V, OH, H F, V, OH, H F, V, OH, H F, V, OH, H F, V, OH, H F, H	Welding of high-sulphur and high-carbon steels that tend to develop porosity and crack under weld deposit
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 E7020-A1	DCR, AC DCR, DCS, AC	F, V, OH, H F 2	For welding carbon moly steels
	E8018-C3	DCR, AC	F, V, OH, H	For low alley, 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	