

## ELECTRODE POLARITY CHART

ELECTRODE	DC*	AC	POSITION	PENETRATION	USAGE
6010	EP	—	ALL	DEEP	MIN. PREP, ROUGH, HIGH SPATTER
6011	EP	✓	ALL	DEEP	
6013	EP, EN	✓	ALL	LOW	GENERAL
7014	EP, EN	✓	ALL	MED.	SMOOTH, EASY, FAST
7018	EP	✓	ALL	LOW	LOW HYDROGEN, STRONG
7024	EP, EN	✓	FLAT HORIZ. FILLET	LOW	SMOOTH, EASY, FASTER
Ni-CI	EP	✓	ALL	LOW	CAST IRON
308L	EP	✓	ALL	LOW	STAINLESS

\*EP = ELECTRODE POSITIVE (REVERSE POLARITY)  
EN = ELECTRODE NEGATIVE (STRAIGHT POLARITY)

## ELECTRODE/AMPERAGE CHART

ELECTRODE	DIAMETER		MIN. 50A	AMPERAGE RANGE			
	IN	MM		100A	150A	200A	MAX.
6010 & 6011	3/32	2.4	█	█	█	█	█
	1/8	3.2					
	5/32	4.0					
6013	3/16	4.8	█	█	█	█	█
	1/16	1.6					
	5/64	2.0					
7014	3/32	2.4	█	█	█	█	█
	1/8	3.2					
	5/32	4.0					
7018	3/32	2.4	█	█	█	█	█
	1/8	3.2					
	5/32	4.0					
7024	3/32	2.4	█	█	█	█	█
	1/8	3.2					
	5/32	4.0					
Ni-CI	3/32	2.4	█	█	█	█	█
	1/8	3.2					
	5/32	4.0					
308L	3/16	4.8	█	█	█	█	█
	3/32	2.4					
	1/8	3.2					