

U.S. ALLOY CO.
 dba Washington Alloy
 7010-G Reames Rd.
 Charlotte, NC 28216
www.weldingwire.com

MILD STEEL ELECTRODE SELECTION RATING



CLASSIFICATION (E)	6010	6011	6012	6013	7014	7016	7018	6020	7024	6027	7028
	DC+	AC DC+	DC- AC	AC DC±	DC± AC	DC+ AC	DC+ AC	DC± AC	DC± AC	AC DC±	DC+
Current											
Welders Appeal	7	6	8	9	10	6	8	9	10	10	9
Slag Removal	9	8	6	8	8	4	7	9	9	9	8
Poor fit up	6	7	10	8	9	4	4	0	8	0	4
Low Spatter Loss	1	2	6	7	9	6	8	9	10	10	9
Low Temp impact	8	8	4	5	8	10	10	8	9	9	10
Ductility	6	7	4	5	6	10	10	10	5	10	10
Soundness	6	6	3	5	7	10	9	9	8	9	9
Undercut / Appearance	6	6	8	9	9	7	10	9	10	10	10
Penetration Depth	10	9	6	5	6	7	7	8	4	8	7
Deposition Rate	4	4	5	5	6	4	6	6	10	10	8
Poor -analysis - High Sulfur	0	0	5	3	3	9	9	0	5	0	9
High Retrained Joint / Heavy Plate	8	8	8	8	8	10	9	8	7	8	9
Thin Materials 1/4"	5	7	8	9	8	2	2	0	7	0	0
Fillet Welds All Position	10	9	6	7	7	8	6	0	0	0	0
Fillet Welds Flat or Horizontal	2	3	8	7	9	5	9	10	10	9	9
Groove Butt Weld All Position <1/4"	10	9	5	8	6	7	6	0	0	0	0
Groove Butt Weld Flat < 1/4"	5	5	3	8	9	7	9	10	9	10	10
TOTAL	103	104	103	116	128	116	129	105	121	112	121
Average Rating of all	6.06	6.12	6.06	6.82	7.53	6.82	7.59	6.18	7.12	6.59	7.12

Rating are based on the same size electrodes (1/8") with 10 as the best rating
 Rating may change with the size

0 = Not Recommended
DC- is electrode NEGATIVE or straight

DC+ is electrode POSITIVE or reverse
AC is for Alternating current

Always store electrodes in a cool dry place to ensure the coating cannot pick up moisture or get damaged
 Use Correct type of electrode for the welding done
 Select diameter about half the base metal plate thickness
 Use the electrode until the stub is 1½ -2" long
 Ensure correct current is being used

WASHINGTON ALLOY COMPANY

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