

# Mild Steel Electrode Selection Chart

AWS Class	Type	Application	Diameter		Product code	Packaging
			mm	in.		
<b>E 6010</b>	Cellulose AC/DC +	Most commonly used for out-of-position welding such as field construction, ship yards, water towers pressure vessels, pressure pipes, steel castings, plain and galvanized steel storage tanks, etc. Flat, horizontal, vertical or overhead welding positions.	2.5	3/32	6178 2400	4.5-22.5 kg
			3.2	1/8	6178 3200	4.5-22.5 kg
			4	5/32	6178 4000	4.5-22.5 kg
			5	3/16	6178 5000	4.5-22.5 kg
<b>E 6011</b>	Cellulose AC/DC +	Commonly used as an all purpose electrode for automobile body shops and mild steel farm equipment. Other uses would include shipbuilding, bridges, boilers, barges, railroad cars, pipes, truck frames, pressure vessels, storage tanks and galvanized steel. Flat, horizontal, vertical or overhead welding positions.	2.5	3/32	6180 2400	4.5-22.5 kg
			3.2	1/8	6180 3200	4.5-22.5 kg
			4	5/32	6180 4000	4.5-22.5 kg
			5	3/16	6180 5000	4.5-22.5 kg
<b>E 6013</b>	Titania AC/DC +	Commonly used for automobile bodies, truck frames and bodies, ornamental iron, metal furniture, farm implementations, machinery guards, storage tanks, or wherever appearance is important or desirable. Flat, horizontal, vertical or overhead welding positions.	2.5	3/32	6182 2400	4.5-22.5 kg
			3.2	1/8	6182 3200	4.5-22.5 kg
			4	5/32	6182 4000	4.5-22.5 kg
			5	3/16	6182 5000	4.5-22.5 kg
<b>E 7014</b>	Titania AC/DC +	Typical application would include: ship structures, bridges, structural steel for buildings, sheet metal, ornamental iron, auto bodies and fenders, machine parts, storage tanks, etc. High efficiency in single and multiple pass welding. Flat, horizontal, vertical or overhead welding positions.	2.5	3/32	6184 2400	4.5-22.5 kg
			3.2	1/8	6184 3200	4.5-22.5 kg
			4	5/32	6184 4000	4.5-22.5 kg
			5	3/16	6184 5000	4.5-22.5 kg
<b>E 7018</b>	Basic AC/DC +	The most efficient general purpose, user friendly iron powder-low hydrogen electrode used for welding carbon steels free-machining steels, and low alloy steels with a minimum yield strength of 50,000 psi. Flat, horizontal, vertical or overhead welding positions.	2.5	3/32	6188 2400	4.5-22.5 kg
			3.2	1/8	6188 3200	4.5-22.5 kg
			4	5/32	6188 4000	4.5-22.5 kg
			5	3/16	6188 5000	4.5-22.5 kg
<b>E 7018-1</b>	Basic AC/DC +	A general purpose, low hydrogen electrode for industrial use. Welding of nuclear reactor vessels, pressure vessels, LPG tankers, LNG storage tanks and similar installations at low temperature with a minimum yield strength of 60,000 psi. Flat, horizontal, vertical or overhead welding positions.	2.5	3/32	6189 2400	4.5-22.5 kg
			3.2	1/8	6189 3200	4.5-22.5 kg
			4	5/32	6189 4000	4.5-22.5 kg
			5	3/16	6189 5000	4.5-22.5 kg
<b>E 7024</b>	Titania AC/DC +	For high speed, single pass horizontal and flat fillet welding of mild steel. 7024 offers a quiet stable arc and produces weld deposits with low spatter, free of undercuts and a "self-removing" slag. Bead appearance is superb. Horizontal and flat welding of ship structures, bridges, structural steels for buildings and general structures	2.5	3/32	6190 2400	4.5-22.5 kg
			3.2	1/8	6190 3200	4.5-22.5 kg
			4	5/32	6190 4000	4.5-22.5 kg
			5	3/16	6190 5000	4.5-22.5 kg

# Mild Steel Wire Selection Chart

AWS Class	Gas	Application	Diameter		Product code	Packaging
			mm	in.		
<b>E 70 S 6 495-6</b>	CO <sub>2</sub> Ar+20%CO <sub>2</sub>	Butt and fillet welding of vehicles, buildings, ships, machinery and bridges in all positions. Suitable for high speed welding of steel sheets by short circuiting transfer in all positions.	0.06	0.023	6910 2006	1-5-15 kg
			0.08	0.030	6910 2008	1-5-20-300 kg
			0.09	0.035	6910 2009	1-5-20-300 kg
			1.20	0.045	6910 2012	1-5-20-300 kg
			1.60	0.062	6910 2016	1-5-20 kg
<b>E 70C-6M</b>	Ar+20%CO <sub>2</sub>	Butt and fillet welding of steel structures such as construction machines, industrial machinery and buildings, etc. 70C-6M is a metal cored wire for use with 75-80% Ar+Co <sub>2</sub> mixture gas.	1.20	0.045	6915 2012	20 kg
			1.40	0.052	6915 2014	20 kg
			1.60	0.062	6915 2016	20 kg
<b>E 70 T1</b>	CO <sub>2</sub>	Flat and fillet welding of medium and heavy thick plate with higher deposition rate for shipbuilding, steel structures and bridges, etc.	0.09	0.035	6949 2009	20 kg
			1.20	0.045	6949 2012	20 kg
			1.60	0.062	6949 2016	20 kg
<b>E 71 T1/9</b>	CO <sub>2</sub>	Butt and fillet welding of mild steel and 490N/mm <sup>2</sup> class high tensile strength steel for machinery, cars, shipbuilding, steel structures and bridges, etc. Good usability for all position.	0.09	0.035	6950 2009	1-5 kg
			1.20	0.045	6950 2012	1-5-20 kg
			1.60	0.062	6950 2016	1-5-20 kg
<b>E 71T-GS</b>	NONE	Lap and fillet welding of thin gauge galvanized and mild steel in all position welding. A self-shielding flux cored wire for single-pass applications.	0.08	0.030	6952 0108	1-5 kg
			0.09	0.035	6952 0109	1-5 kg
			1.20	0.045	6952 0112	1-5 kg

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