



Manual of Storing and Re-drying of Stick Electrodes

For Low Hydrogen

Baking conditions:

Low hydrogen electrodes should always be dried to perform properly. Electrodes in unopened hermetically sealed containers get excellent protection when stored in good conditions. Electrodes are available in hermetically sealed containers within 2 years from the date of manufacturing. It is always recommended that electrodes should be dried before use. Electrodes after drying should be stored in a cabinet immediately at 100°C to 150°C for preventing coating from moisture pick up or decay.

When containers are opened, low hydrogen electrodes may pick up moisture immediately. Re-drying can restore the electrodes' ability to deposit with good operating characteristics and high quality weld. Proper re-drying temperature and time are shown as below.

Electrodes' Condition	Pre-Drying Temperature and Time	Final Re-drying Temperature and Time
1. Electrodes are not exposed to high humidity.	--	300°C~350°C (1hr)
2. Electrodes contact with water directly or expose to high humidity.	80°C~100°C (1~2hr)	300°C~350°C (1hr)

Do not dry electrodes beyond the recommendation temperature.

Electrodes should not be re-dried over 3 times in the 300°C~350°C. Any electrode should be discarded if excessive re-drying causes the different operating characteristic or weld quality.

Storage conditions:

Electrodes shall be stored under properly maintained and controlled storage conditions as follows:

- Temperature should be between 5°C and 50°C
- Relative Humidity as low as possible, not exceeding 70%

Hermetically sealed can & vacuum packaging are moisture proof and do not require any special storage instructions. Any punctured or damaged hermetically sealed can & vacuum packaging should be baked as per above instructions.

No electrodes shall be left lying about site or in workshops. Electrodes so left shall be scrapped. The pile-up of pallets shall be no more than 2 stacks to prevent damaging flux coating. Packages shall not put on the floor directly. There are always wooden pallets existing between packages and floor to remain ventilation.