



Oven Storage & Reconditioning of SMAW

Stick electrodes (SMAW) can be damaged by atmospheric moisture. The table below provides recommendation of proper storage conditions, temperature and time for reconditioning stick electrodes that have taken in excess moisture.

Notes for table: Pallets and unopened cartons of electrodes should be stored away from exposure to water in its various forms, such as rain, snow, spray, or humidity.

Damaged cartons allow entry of damp air which may be absorbed by the product, causing to lower the quality and performance of the product. Humidity below 50% should be avoided for **blume**[®] E6013 electrodes. At no time should these electrodes be stored in and oven above 55°C (131°F).

The Instruction, “Dry at Room Temperature” in the table below, represents that the humidity should be below 70% and the temperature should be within limits 4°C (39°F) to 50°C (122°F).

Item Designation	Storage of Contents of Open Cartons*	Reconditioning*
Mild Steel & Low Alloy Cellulosic	Dry at room temperature	Not recommended
Mild Steel - blume [®] E6013	40°C (104°F) - 55°C (131°F)	120°C (248°F) - 150°C (302°F) for 1 Hour
Mild Steel & Low Alloy Low Hydrogen - blume [®] E7018	120°C (248°F) - 150°C (302°F)	260°C (500°F) - 425°C (797°F), for 1-2 Hours
Stainless Steel Stick Electrodes - blume [®] E308L-16 & blume [®] E316L-16	108°C (227°F) - 125°C (257°F)	260°C (500°F) - 315°C (600°F), for 1 Hour
Hard Surfacing Electrode	108°C (227°F) - 125°C (257°F)	235°C (455°F) - 315°C (600°F)

*Remove any packaging that maybe damaged from oven storage or reconditioning.

