

### ELECTRODE PART NUMBER CHART

Rod Size	1lb Box	5lb Box	10lb Box	50lb Box
<b>TYPE 6011 STICK ELECTRODE</b>				
3/32"	1440-0115	1440-0116	1440-0117	1440-0118
1/8"	1440-0105	1440-0106	1440-0107	1440-0108
5/32"	1440-0095	1440-0096	1440-0097	1440-0098
<b>TYPE 6013 STICK ELECTRODE</b>				
3/32"	1440-0145	1440-0146	1440-0147	1440-0148
1/8"	1440-0134	1440-0135	1440-0136	1440-0137
5/32"	1440-0124	1440-0125	1440-0126	1440-0127
<b>TYPE 7014 STICK ELECTRODE</b>				
3/32"	1440-0205	1440-0206	1440-0207	1440-0208
1/8"	1440-0200	1440-0201	1440-0202	1440-0203
5/32"	1440-0150	1440-0151	1440-0152	1440-0153
<b>TYPE 7018 STICK ELECTRODE</b>				
3/32"	1440-0195	1440-0196	1440-0197	1440-0198
1/8"	1440-0185	1440-0186	1440-0187	1440-0188
5/32"	1440-0180	1440-0181	1440-0182	1440-0183
Rod Size	1lb Box	5lb Box	Job Pack†	
<b>E6024 QUICK START ELECTRODE</b>				
1/16"	1440-0412	1440-0413		
<b>308 STAINLESS STEEL ELECTRODE</b>				
3/32"	1440-0165			
1/8"	1440-0155	1440-0156		
<b>E-309L STAINLESS STEEL ELECTRODE</b>				
3/32"	1440-0496			
1/8"	1440-0497			
<b>NICKEL 55 CAST IRON</b>				
3/32"			1440-0440	
1/8"	1440-0083			
<b>NICKEL 99 CAST IRON</b>				
3/32"			1440-0423	
1/8"	1440-0425	1440-0374	1440-0424	
<b>E4043 ALUMINUM ARC ELECTRODE</b>				
1/8"	1440-0419	1440-0420		

† See Page 59 for Job Packs Available  
‡ For 230V Operation Only



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### ELECTRODE DESCRIPTIONS

#### TYPE 6011 Mild Steel Current: AC/DC

All position electrode. Use when you are unable to prepare a welding surface. Its deep penetration allows welds through rust, scale, oil and dirt.



#### TYPE 6013 Mild Steel Current: AC/DC

All position electrode. Best used with clean or prepared welding surface. Excellent for low heat applications designed for general purpose.



#### TYPE 7014 Iron Powder Current: AC/DC

All position electrode. Best used with clean or prepared welding surface with Medium to Low penetration. Designed for high deposition and high electrode travel speed.



#### TYPE 7018 Low Hydrogen Current: AC/DC

All position electrode. Best used with clean or prepared welding surface with Medium penetration. Designed to produce X-ray quality welds.



#### E6024 Quick Start Mild Steel Current: AC/DC

Best used with clean or prepared welding surface and excellent for low heat applications. Flat & horizontal fillet only.



#### 308 Stainless Steel Current: AC/DC

Used for all 200 and 300 series stainless up to and including 308. Provides equal or better corrosion resistance than base metal and can also be used to fabricate and repair austenitic manganese steel.



#### E-309L Current: AC/DC

Used for welding/joining of 300 series stainless to mild steel. Provides equal or better corrosion resistance than base metal.



#### Nickel 55 Cast Iron Current: AC/DC\*

Best used for repairing cast iron/ heavy cast iron selections. Repairs cylinder blocks, exhaust manifold, and machines bases. Smooth arc characteristics produce strong welds at low amps.



#### Nickel 99 Cast Iron Current: AC/DC\*

All position electrode. Best used on cast iron parts that are subject to heating and cooling, such as engine blocks, cylinder heads, exhaust manifolds.



#### E4043 Aluminum Arc Current: DC

Best used for weld with strength ductility and corrosion resistance equal to parent metal. Applications include aluminum, sheet metal, plates, castings, tanks and piping.



\*DC Recommended

ELECTRODES	MST 140i	MST 180i	MST 220i	TIG 140 ACDC	TIG 200 ACDC	TIG 160S
	Up to 3/32"	Up to 5/32"	Up to 5/32"	Up to 3/32"	Up to 5/32"	Up to 5/32"
Type 6011 Mild Steel	NO	EXPERT	EXPERT	NO	EXPERT	EXPERT
Type 6013 Mild Steel	NOVICE	NOVICE	NOVICE	NOVICE	NOVICE	NOVICE
Type 7014 Iron Powder	NOVICE	NOVICE	NOVICE	NOVICE	NOVICE	NOVICE
Type 7018 Low Hydrogen	SKILLED	SKILLED	SKILLED	SKILLED	SKILLED	SKILLED
E6024 Quick Start	NOVICE	NOVICE	NOVICE	NOVICE	NOVICE	NOVICE
308 Stainless Steel	NOVICE	NOVICE	NOVICE	NOVICE	NOVICE	NOVICE
E-309L Stainless Steel	NOVICE	NOVICE	NOVICE	NOVICE	NOVICE	NOVICE
Nickel 55 Cast Iron	NOVICE	NOVICE	NOVICE	NOVICE	NOVICE	NOVICE
Nickel 99 Cast Iron	NOVICE	NOVICE	NOVICE	NOVICE	NOVICE	NOVICE
E4043 Aluminum Arc	EXPERT	EXPERT	EXPERT	EXPERT	EXPERT	EXPERT

Each electrode is unique and when working with different materials (Steel, Stainless Steel, Cast Iron, etc.) they require different preparations. We recommended researching the proper welding preparation guidelines for the materials before welding.



These easy-to-use electrodes are multi-position electrodes and are simple to use when welding. Little preparation time, forgivable arc lengths, and wide range of techniques are possible with these electrodes.



Using the intermediate electrodes will require some skill. The electrodes and metals you're working with will require more preparation before welding and require you to maintain the Arc Length.



Professional welding skills are needed to use these electrodes. These electrodes require precision while welding, as there is minimal leeway for operator error, and unique techniques maybe required.