

STORAGE AND HANDLING

RECOMMENDATIONS FOR THE STORAGE, REDRYING AND HANDLING OF ESAB COVERED ELECTRODES.

General Information

All covered electrodes are sensitive to moisture re-absorption to a greater or lesser degree. Care must be taken during storage and handling to prevent moisture being re-absorbed.

Storage

Covered electrodes of any type will pick up moisture only very slowly if they are stored under the following climatic conditions:

At Temperatures

During winter, it is possible to have low relative humidity by keeping the temperature in the storeroom at least 10°C above the outdoor temperature. During certain periods in the summer and in a tropical climate, sufficiently low relative humidity can be maintained by air dehumidification.

Redrying

Low-hydrogen basic electrodes should be redried before use whenever there are application requirements relating to weldmetal hydrogen content and / or radiographic soundness (not needed for VacPac®).

Acid rutile stainless electrodes and all types of basic electrodes may produce pores in the weld if they have not been stored in sufficiently dry conditions. Redrying the electrode will restore their usability.

Mild steel rutile and acid electrodes normally need no redrying.

Cellulose electrodes must not be redried.

Electrodes which are seriously damaged by moisture can normally not be redried. These electrodes should be scrapped.

Redrying Conditions

Redrying temperatures and holding times are specified on the label and in the product specification.

The redrying temperature is the temperature in the bulk of the electrodes.

The redrying time is measured from the point at which the redrying temperature has been reached.

Do not stack more than four layers of electrodes in the redrying oven.

It is recommended not to redry covered electrodes more than three times.

Holding Oven

The holding oven is used for intermediate storage to avoid moisture pick-up in the coating of low - hydrogen electrodes and acid rutile stainless electrodes. The electrodes which should be stored in the holding oven are:

1. Electrodes that have been redried.
2. Electrodes that have been removed from their hermetically - sealed container.
3. Electrodes that are considered to be in good condition and are transferred directly from the store room after unpacking.

Holding oven temperature : 120 - 150°C

Precautions on Site

Keep the electrodes in electrically - heated quivers at a minimum temperature of 70°C. After work return the remaining electrodes to the holding oven.

Damaged Coating

Mechanically damaged electrodes on which parts of the coating are missing will not perform correctly and should be scrapped.

VacPac®

Electrodes in VacPac® will not pick up any moisture during storage. They require no redrying before use, provided the package is undamaged. This is indicated by a vacuum in the package.

Handling VacPac® Electrodes

Protect VacPac® from damage at all times.

The outer board packaging offers extra protection from mechanical damage to the metal foil. Handle the single inner, metal foil, VacPac® with special care.

Do not use a knife or any other sharp object to open the outer board packaging.

Before using VacPac® Electrodes

Check if the protective foil still contains a vacuum. If the vacuum has been lost, redry the electrodes before use.

Cut open the protective foil at one end.

Do not take out more than one electrode at a time, thereby, ensuring that the remaining electrodes are still protected inside the package. Put the top back on the plastic capsule.

Discard or redry electrodes that have been exposed to the atmosphere in an opened VacPac® for more than

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Zhe Xu



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Crossbow CNC with Open Source SW and FastCAM J. Burton Browning, 2016-11-11 This text will teach you how to use open source software with the ESAB Crossbow CNC plasma cutter

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International Turnaround Management B. Arpi, 2016-04-13 The role of a Turnaround Manager is to save companies from a seriously unprofitable situation This may follow a merger take over restructure or as a result of adverse market conditions or mismanagement A first class Turnaround Manager is more than a short term company doctor he or she redefines the company's business mission and restructures it for long term survival This book shows how to do this It includes practical advice from experienced Turnaround Managers real life examples of best practice and an objective guide to the principles involved in this increasingly important role

Welding Handbook American Welding Society, 2001

Thomas Regional Industrial Buying Guide, 2003

Robotics Products Database, 1990

Handbook of Industrial Robotics Shimon Y. Nof, 1992 120 leading experts from twelve countries have participated in creating this Second Edition of the Handbook of Industrial Robotics Of its 66 chapters 33 are new covering important new topics in the theory design control and applications of robotics Other key features include a larger glossary of robotics terminology with over 800 terms and a CD ROM that vividly conveys the colorful motions and intelligence of robotics With contributions from the most prominent names in robotics worldwide the Handbook remains the essential resource on all aspects of this complex subject

The Price Waterhouse European Companies Handbook, 1992

Wire and Wire Products Buyers' Guide, 1973

The Engineer, 1979

Welding and Metal Fabrication, 1992

Moody's Industrial Manual, 1989 Covering New York American regional stock exchanges international companies

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A Manual of the Mechanics of Engineering and of the Construction of Machines Julius Ludwig Weisbach, 1870

Commerce Business Daily, 2000-06

Welding Design & Fabrication, 1976

The Complete Twin Plant Guide, 2008

Industrial Engineering, 1987

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