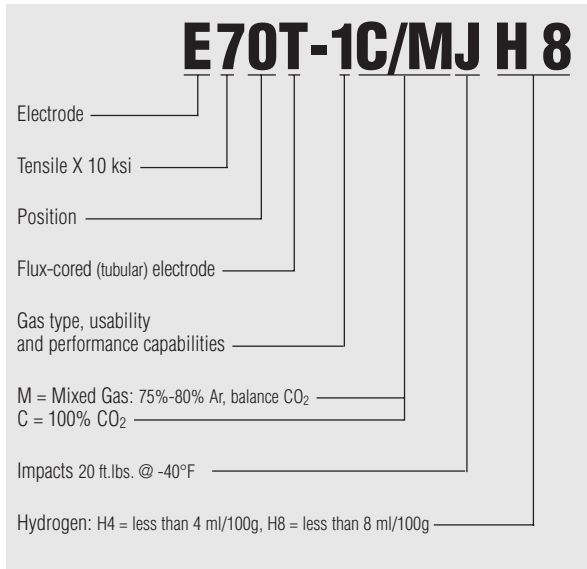
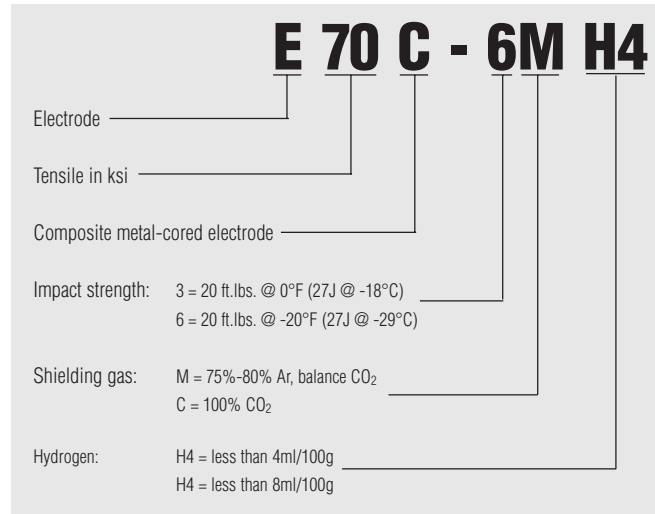


Tubular Wires

How AWS classifies mild steel flux-cored (tubular) wires, FCAW process (AWS A5.20)



How AWS classifies metal-cored wires, GMAW process (AWS A5.18)



c. The term "DCEP" refers to direct current electrode positive (dc, reverse polarity).
The term "DCEN" refers to direct current electrode negative (dc, straight polarity).

HOBART PERFORMANCE WELDING PRODUCTS

Position of Welding, Shielding, Polarity, and Application Requirements

AWS Classification	Welding Position ^a	Shielding ^b	Current ^c	Application ^d	AWS Classification	Welding Position ^a	Shielding ^b	Current ^c	Application ^d
E70T-1C	H and F	CO ₂	DCEP	M	E70T-9C	H and F	CO ₂	DCEP	M
E70T-1M	H and F	75-80% Ar/bal CO ₂	DCEP	M	E70T-9M	H and F	75-80% Ar/bal CO ₂	DCEP	M
E71T-1C	H, F, VU, OH	CO ₂	DCEP	M	E71T-9C	H, F, VU, OH	CO ₂	DCEP	M
E71T-1M	H, F, VU, OH	75-80% Ar/bal CO ₂	DCEP	M	E71T-9M	H, F, VU, OH	75-80% Ar/bal CO ₂	DCEP	M
E70T-2C	H and F	CO ₂	DCEP	S	E70T-10	H and F	None	DCEN	S
E70T-2M	H and F	75-80% Ar/bal CO ₂	DCEP	S	E70T-11	H and F	None	DCEN	M
E71T-2C	H, F, VU, OH	CO ₂	DCEP	S	E71T-11	H, F, VD, OH	None	DCEN	M
E71T-2M	H, F, VU, OH	75-80% Ar/bal CO ₂	DCEP	S	E70T-12C	H and F	CO ₂	DCEP	M
E70T-3	H and F	None	DCEP	S	E70T-12M	H and F	75-80% Ar/bal CO ₂	DCEP	M
E70T-4	H and F	None	DCEP	M	E71T-12C	H, F, VU, OH	CO ₂	DCEP	M
E70T-5C	H and F	CO ₂	DCEP	M	E71T-12M	H, F, VU, OH	75-80% Ar/bal CO ₂	DCEP	M
E70T-5M	H and F	75-80% Ar/bal CO ₂	DCEP	M	E61T-13	H, F, VD, OH	None	DCEN	S
E71T-5C	H, F, VU, OH	CO ₂	DCEP or DCEN ^e	M	E71T-13	H, F, VD, OH	None	DCEN	S
E71T-5M	H, F, VU, OH	75-80% Ar/bal CO ₂	DCEP or DCEN ^e	M	E71T-14	H, F, VD, OH	None	DCEN	S
E70T-6	H and F	None	DCEP	M	EX0T-G	H and F	Not Specified	Not Specified	M
E70T-7	H and F	None	DCEN	M	EX1T-G	H, F, VD or VU, OH	Not Specified	Not Specified	M
E71T-7	H, F, VU, OH	None	DCEN	M	EX0T-GS	H and F	Not Specified	Not Specified	S
E70T-8	H and F	None	DCEN	M	EX1T-GS	H, F, VD or VU, OH	Not Specified	Not Specified	S
E71T-8	H, F, VU, OH	None	DCEN	M					

a. H = horizontal position; F = flat position; OH = overhead position; VD = vertical position with downward progression; VU = vertical position with upward progression
b. Properties of weld metal from electrodes that are used with external gas shielding (EXXT-1C, EXXT-1M, EXXT-2C, EXXT-2M, EXXT-5C, EXXT-5M, EXXT-9C, EXXT-9M, EXXT-12C, and EXXT-12M) vary according to the shielding gas employed. Electrodes classified with the specified shielding gas should not be used with other shielding gases without first consulting the manufacturer of the electrode.

c. The term "DCEP" refers to direct current electrode positive (dc, reverse polarity). The term "DCEN" refers to direct current electrode negative (dc, straight polarity).
d. M = single- or multiple-pass; S = single-pass only
e. Some E71T-5C and E71T-5M electrodes may be recommended for use on DCEN for improved out-of-position welding.