

**Standard designation as per:** AWS  
EN  
DIN  
Werkstoffnr.

American Welding Society  
European standard (issued by CEN)  
German standard for industries  
DIN-EN identification for materials

**Coating type, wire type or flux type** (depending on the process):

Identifies the characteristics of the product concerned by means of either the chemical composition of the covering or core. In case of wire type the specific welding process concerned.

**Arc voltage:**

Typical starting voltage for stick electrodes. 42V means electrode is suitable for lighting current transformers (in Europe 220V) and transformers with 42V or S marking.

**Current:**

Identifies the current and polarity recommended. For DC current the sequence identifies our recommendations



AC current  
= AC



DC current /  
electrode connected  
to positive pole  
= DCEP



DC current /  
electrode connected  
to negative pole  
= DCEN



DC current /  
negative pole with a  
remark  
= DCEN

**Welding positions:**

Identifies the welding position we recommend the consumable to be used in



All positions



All positions,  
except vertical  
downwards



All positions,  
specifically in  
vertical down  
position



Flat butt and  
fillet welds only



Flat butt and  
fillet welds,  
limited vertical  
upwards

**Approvals:** consumable is yearly tested and approved by international institutes

ABS	American Bureau of Shipping
BV	Bureau Veritas
DB+Ü	Deutsche Bundesbahn (German Railways) + Überwachungsvertrag (U-sign)
DNV	Det Norske Veritas
GL	Germanischer Lloyds
LR	Lloyds Register of Shipping
TüV	Technische überwachungs Verein
Force	Force Institute - Danish standard

**Tip colour:** (if applicable) colour code for identification of stick electrodes, to be found on grip end of the electrode

**Printing:** Brandname / EN classification / AWS specification (or parts of this sequence) printed on the electrodes' coating for example: HILCO Red Extra / E42 0 RC / E 6013

**Equivalent product in alternative welding process:**

Indicates the first choice for a consumable in another welding process, process identification acc. to ASME:

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
Shielded metal arc welding - stick electrodes - Manual metal arc welding - 111	Gas metal arc welding - MIG/MAG - 131/135	Flux cored arc welding - MAG welding - 136	Gas tungsten arc welding - TIG welding - 141	Submerged arc welding with wire electrode - 121	OAW - Oxy-acetylene welding - 311 / Brazing, soldering and braze welding - 9XX