

## STORAGE RECOMMENDATIONS FOR WELDING CONSUMABLES

### COATED ELECTRODES

Store electrodes always in original (re)closable cans and reclose the can after taking out the electrodes. Ultra Dry III vacuum packed electrodes can be used for approximately 6 hours after opening the packaging without re-drying, the atmospheric conditions must be  $\leq 35^{\circ}\text{C}$  and  $\leq 90\% \text{RH}$ . When electrodes out of the original packaging are exposed for more than 10 hours to an atmosphere with relative humidity of  $\geq 60\%$ , re-drying is recommended. For electrodes with a yield  $\geq 460 \text{MPa}$  the recommendation is a maximum of 3 times re-drying.

### SOLID-, SEAMLESS FLUX-CORED WIRE AND STRIP

Store wire always in the undamaged original packaging. We recommend especially for aluminum wires to acclimatize them for 24 hours in the workshop. Solid-, seamless flux-cored wires and strip don't need re-drying. A large temperature difference should be avoided in order to prevent condensation.

### FOLDED FLUX-CORED WIRE

Store wire always in the undamaged original packaging. When there are big temperature differences between night and day, recommendation is to keep the spool not on the machine at night, but to store the spool in a room where the temperature is above the dew point.

#### Re-drying:

Steel spools: At least 4 hours at  $150^{\circ}\text{C}$

Plastic spools: At least 48 hours at  $50^{\circ}\text{C}$

### SAW AND ESW FLUXES

Store fluxes always in undamaged and unopened original steel can or bag. Keep fluxes away from water, oil and grease products. Unprotected fluxes must, after 12 hours use, be re-dried in a drying oven.

#### Recycling:

Moisture, oil and grease must be removed from the compressed air used for the recycling system.

Addition of new flux must be done with the proportion of at least one part new flux on three parts recycled flux.

#### Re-drying:

Agglomerated fluxes 2-4 hours at  $300^{\circ}\text{C} \pm 25^{\circ}\text{C}$

Fused fluxes 2-4 hours at  $200^{\circ}\text{C} \pm 50^{\circ}\text{C}$

#### Keeping and storage of welding consumables

In general, all products that are stored in unopened original packaging can be kept with observance of the following: Electrodes, welding wires and fluxes must be protected against atmospheric influences such as rain, snow and condensation. In order to be sure that no condensation takes place in these products it is recommended to store the products in an environment which is above the dew point. This temperature is dependent on the prevailing relative humidity of air at that place.

**AVOID CONTACT WITH WATER, OIL AND GREASE. IN GENERAL, A MAXIMUM STORAGE PERIOD OF 3 YEARS APPLIES TO ALL WELDING CONSUMABLES AND FLUXES.**

