

## 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

# Esab User Manual

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## **Table of Contents Esab User Manual**

1. Understanding the eBook Esab User Manual
  - The Rise of Digital Reading Esab User Manual
  - Advantages of eBooks Over Traditional Books
2. Identifying Esab User Manual
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Esab User Manual
  - User-Friendly Interface
4. Exploring eBook Recommendations from Esab User Manual
  - Personalized Recommendations

- Esab User Manual User Reviews and Ratings
- Esab User Manual and Bestseller Lists
- 5. Accessing Esab User Manual Free and Paid eBooks
  - Esab User Manual Public Domain eBooks
  - Esab User Manual eBook Subscription Services
  - Esab User Manual Budget-Friendly Options
- 6. Navigating Esab User Manual eBook Formats
  - ePub, PDF, MOBI, and More
  - Esab User Manual Compatibility with Devices
  - Esab User Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Esab User Manual
  - Highlighting and Note-Taking Esab User Manual
  - Interactive Elements Esab User Manual
- 8. Staying Engaged with Esab User Manual
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Esab User Manual
- 9. Balancing eBooks and Physical Books Esab User Manual
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Esab User Manual
- 10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
- 11. Cultivating a Reading Routine Esab User Manual
  - Setting Reading Goals Esab User Manual
  - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Esab User Manual
  - Fact-Checking eBook Content of Esab User Manual

- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
  - Utilizing eBooks for Skill Development
  - Exploring Educational eBooks
- 14. Embracing eBook Trends
  - Integration of Multimedia Elements
  - Interactive and Gamified eBooks

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