



AN ISO 9001:2015 COMPANY
CERTIFICATE NO.: C755336

Storage Recommendation Guidelines for Pinnacle Alloys™ Welding Products

Introduction:

The purpose of this document is to provide guidelines for the storage and care of Pinnacle Alloys™ group of welding products. When followed, these guidelines will help ensure the products perform as intended after the storage period as well as supporting the Pinnacle Alloys™ product warranty. Pinnacle Alloys™ products are warranted from defects in material and workmanship for a period of one (1) year from the time of shipment in its original undamaged and unopened package.

General Storage Recommendations for All Products:

- » Product in its original, unopened package should be stored in a dry, enclosed environment and preferably at a constant temperature.
- » The storage temperature should be between 40°F (4°C) and 110°F (49°C) with a *maximum* of 80% relative humidity. For critical applications this should not exceed 50% relative humidity.
- » Cold product must be allowed to stabilize thermally within 10°F (6°C) of the temperature in the welding environment. Acclimation is particularly important when the product is stored at temperatures well below the welding environment temperature. If not acclimated, condensation can form directly on the product if opened in a warm environment while still cold.
- » Moisture must **NOT** be allowed to come in contact with packages. This includes dripping water, heavy condensation, or standing water regardless of the type of package. Product exposed to moisture voids all manufacturers' warranties.
- » Product that has been removed from its original packaging should be returned to its original packaging when not in use and stored in a dry, enclosed environment and preferably at a constant temperature.

Pinnacle Alloys™ Carbon Steel, Low Alloy, Stainless, Nickel, Copper, and Aluminum Solid Welding Wires:

- » Refer to the General Storage Recommendations to avoid damage to the product and packaging, including rust, oxidation, and moisture pickup. Particular care should be taken to limit exposure of aluminum and copper to avoid unnecessary oxidation.

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Pinnacle Alloys™ Carbon Steel, Low Alloy, Nickel, and Stainless Coated Electrodes:

- » Refer to the General Storage Recommendations to avoid damage to the product and packaging.
- » Refer to Table below for recommended storage and reconditioning of opened coated electrodes:

Item Designation	Storage of Contents of Open Product	Reconditioning
Mild steel 6010, 6011	Dry at room temperature	Not recommended
Mild steel 7010, 8010	Dry at room temperature	Not recommended
Mild Steel 6012, 6013, 6022, 7014, 7024	100°F-130°F	250°F-300°F, 1 hour
Mild Steel, LH 7018, 8018, 9015, 9018, 10018, 11018, 12018	250°F-300°F	500°F-800°F, 1-2 hours
Nickel Electrodes* AWS A5.6, A5.11	225°F-260°F	350°F-400°F, 3 hours
Stainless Steel Electrodes* AWS -15, -16, -17	225°F-260°F	500°F-600°F, 1 hour

*Life span of opened cans is approximately 8 hours. Electrodes are fully baked before packaging and ready to use as received.

Pinnacle Alloys™ Carbon Steel, Low Alloy, and Stainless Tubular Wires:

- » Refer to the General Storage Recommendations to avoid damage to the product and packaging.
- » Product that has been removed from its original packaging may pick up moisture if left exposed to high levels of humidity for a day or more. This moisture pickup will increase weld metal diffusible hydrogen levels. It can also cause the formation of gas trails (AKA 'worm tracks') on the surface of the weld bead.
- » Product that has picked up moisture can be partially reconditioned by baking in an oven. Fiber spools, wire frame spools, and coils without liners should be baked for 8-10 hours at 220°F-250°F. **Product on plastic spools should not be placed in the oven.**

For additional questions on the storage and care of Pinnacle Alloys™ products, please contact customer service at 1-800-856-9353.

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