HILCO Electrodes

MMA Range & Ordering Guide

Manual metal arc electrodes for fabrication, pipe welding and repair.



Choose Your Electrode

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Special Order · Full Cartons Only

Minimum order is one full carton per stock code. Please quote the stock code and the number of cartons required.

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Mild Steel & Production Fillets

Red Extra E6013

EN ISO 2560-A · E 42 0 RC 11



A smooth-running rutile electrode with easy slag release. Runs on AC or DC and suits transformers with a minimum 42V open-circuit voltage.

Use for Mild-steel assembly, workshop repairs and general fabrication where the joint position changes.

Position All positions, including vertical down

Stock Code	Diameter	Rod length	Carton contents	Net carton	Current
WER3503	2.0mm	300mm	4 boxes × 4.1kg	16.4kg	40–60A
WER3504	2.5mm	350mm	4 boxes × 5kg	20kg	60–100A
WER3505	3.25mm	350mm	4 boxes × 5kg	20kg	90–140A
WER3506	4.0mm	350mm	4 boxes × 5kg	20kg	150–190A
WER3507	5.0mm	350mm	4 boxes × 5kg	20kg	180–240A

Velora E6013

EN ISO 2560-A · E 42 0 RR 12



The slower-freezing rutile slag supports fast downhand welding and a smooth finish on thin sheet. Runs on AC or DC.

Use for Downhand seams on mild-steel sheet and light fabrications.

Position All positions except vertical down

Stock Code	Diameter	Rod length	Carton contents	Net carton	Current
WER3526	2.5mm	350mm	4 boxes × 4.1kg	16.4kg	60–100A
WER3527	3.25mm	350mm	4 boxes × 4.3kg	17.2kg	100–140A
WER3528	4.0mm	450mm	4 boxes × 5.6kg	22.4kg	150–190A

Regina 160 E7024-1

EN ISO 2560-A · E 42 0 RR 53



The 160% recovery electrode deposits metal quickly on long, accessible seams. A quiet arc and easy slag release suit repetitive fillet work.

Use for Production fillets on compatible mild or low-alloy structural steel. AC or DC.

Position Flat and horizontal fillets

Stock Code	Diameter	Rod length	Carton contents	Net carton	Current
WER3514	3.25mm	450mm	4 boxes × 5.9kg	23.6kg	120–160A
WER3515	4.0mm	450mm	4 boxes × 5.7kg	22.8kg	160–230A
WER3516	5.0mm	450mm	4 boxes × 5.4kg	21.6kg	250–340A

Special order · Sold in full cartons · Minimum 1 carton per stock code

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Low-Hydrogen Structural Welding

Basic 55 E7016

EN ISO 2560-A · E 38 3 B 12 H10



A double-coated basic-rutile electrode with a controllable arc and good root penetration. Runs on AC or DC.

Use for Structural root passes and positional work where an E7016 electrode is specified.

Position All positions except vertical down

Stock Code	Diameter	Rod length	Carton contents	Net carton	Current
WER3508	2.5mm	350mm	3 boxes × 3.9kg	11.7kg	55–95A
WER3509	3.25mm	450mm	3 boxes × 5.3kg	15.9kg	95–150A
WER3510	4.0mm	450mm	3 boxes × 5.2kg	15.6kg	120–190A

Basic E7018-1

EN ISO 2560-A · E 42 5 B 32 H5



A low-hydrogen, DC electrode-positive grade for fine-grain steels. The quiet arc, low spatter and easy slag release suit multi-pass work.

Use for Structural and marine fabrication where a DC+ E7018-1 is specified.

Position All positions except vertical down

Stock Code	Diameter	Rod length	Carton contents	Net carton	Current
WER3522	2.5mm	350mm	4 boxes × 4.2kg	16.8kg	65–110A
WER3523	3.25mm	350mm	4 boxes × 4.3kg	17.2kg	100–145A
WER3524	4.0mm	450mm	4 boxes × 5.8kg	23.2kg	135–200A

Basic Super E7018-1

EN ISO 2560-A · E 42 5 B 32 H5



An AC/DC low-hydrogen grade with a smooth arc and good slag release. Use it for structural welding where access calls for positional work.

Use for Structural steelwork, shipbuilding and offshore fabrication to the applicable procedure.

Position All positions except vertical down

Stock Code	Diameter	Rod length	Carton contents	Net carton	Current
WER3517	2.5mm	350mm	4 boxes × 4.1kg	16.4kg	65–90A
WER3518	3.25mm	350mm	4 boxes × 4.1kg	16.4kg	100–140A
WER3519	4.0mm	450mm	4 boxes × 5.8kg	23.2kg	140–190A
WER3520	5.0mm	450mm	4 boxes × 5.9kg	23.6kg	180–250A

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Pipe & Creep-Resistant Steel

Pipeweld 7010 E7010-P1

EN ISO 2560-A · E 42 3 C 25



A cellulosic pipe electrode with a forceful arc and deep penetration. The light slag clears readily between runs.

Use for Vertical-down pipe butt joints, including suitable API 5L X52 applications under a qualified procedure.

Position Primarily vertical-down pipe welding

Stock Code	Diameter	Rod length	Carton contents	Net carton	Current
WER3511	3.25mm	350mm	3 tins × 5.1kg	15.3kg	80–130A
WER3512	4.0mm	350mm	3 tins × 5.1kg	15.3kg	120–180A

B12Mo E7018-A1 H4R

EN ISO 3580-A · E Mo B 32 H5



A basic low-hydrogen molybdenum electrode for specified creep-resistant steels, including 16Mo3. Hilco generally recommends DC.

Use for Compatible boiler, pressure-vessel and process-pipe steels. Match the filler and polarity to the qualified procedure.

Position Position and polarity to the procedure

Stock Code	Diameter	Rod length	Carton contents	Net carton	Current
WER3501	3.25mm	350mm	3 boxes × 4.5kg	13.5kg	120–130A
WER3502	4.0mm	350mm	3 boxes × 4.7kg	14.1kg	140–150A

Two Different Pipe Applications

Pipeweld 7010 is a cellulosic electrode for qualified downhill pipe welding. B12Mo is a low-hydrogen molybdenum grade for specified creep-resistant steels such as 16Mo3. Select by base material and procedure.

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Dissimilar Steel & Maintenance

Hilchrome 309R E309L-17

EN ISO 3581-A · E 23 12 L R 3 2



A rutile stainless electrode for dissimilar joining and buffer layers. Its weld-metal composition helps tolerate dilution from the parent steel.

Use for Suitable stainless-to-carbon steel joints, clad steel and specified buffer passes. AC or DC.

Position All positions except vertical down

Stock Code	Diameter	Rod length	Carton contents	Net carton	Current
WER3538	2.5mm	300mm	3 tins × 3.6kg	10.8kg	60–80A
WER3539	3.25mm	350mm	3 tins × 4.4kg	13.2kg	80–110A

Hilchrome 312R ~E312-17

EN ISO 3581-A · E 29 9 R 3 2



The maintenance option for difficult-to-weld steels. A high-ferrite deposit gives good resistance to weld-metal cracking.

Use for Tool and spring steels, compatible dissimilar repairs and buffer layers before hardfacing. AC or DC.

Position All positions except vertical down

Stock Code	Diameter	Rod length	Carton contents	Net carton	Current
WER3543	2.5mm	300mm	3 tins × 3.5kg	10.5kg	60–80A
WER3544	3.25mm	350mm	3 tins × 4.2kg	12.6kg	80–110A

309R or 312R?

Use 309R for specified stainless-to-steel joints and buffer layers. Choose 312R for difficult repairs on compatible hardenable steels where the procedure calls for its higher-ferrite deposit.

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316 Stainless Steel

Hilchrome 316R E316L-17

EN ISO 3581-A · E 19 12 3 L R 3 2



A molybdenum-bearing rutile stainless electrode for corrosion-resistant deposits on compatible 316 and 316L grades.

Use for 316 and 316L fabrication and repair in process equipment and pipework. AC or DC.

Position All positions except vertical down

Stock Code	Diameter	Rod length	Carton contents	Net carton	Current
WER3533	2.5mm	300mm	3 tins × 3.5kg	10.5kg	50–90A

Buying for a Specified Procedure

Give the parent material, welding position and exact classification. For coded work, request the current approval certificate and check that its scope covers the required grade and diameter.

What the Order Table Shows

The tables show Hilco’s standard carton contents and net electrode weight. Stock codes shown at 3.25mm correspond to Hilco’s nominal 3.2mm size.

Hilchrome 312R is described by Hilco as approximately AWS E312-17. Use the stated EN ISO classification for selection where it is specified.

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