

TYPE (AWS)	Air Conditioned Storage Before Opening RH= Relative Humidity	Dry Rod Oven Holding Temperature. after opening	After exposure to moisture a sufficient amount of time to affect weld quality	
			Recondition Step #1	Rebake Step #2
Cellulose EXX10 EXX11 EXX20	70-110°F (21-43°C) 50% max. RH	100-120°F (38-49°C)	Not Recommended	
Titania EXX12 EXX13 EXX14	70-110°F (21-43°C) 50% max. RH	100-120°F (38-49°C)	180-230°F (82-110°C) 1/2 hour	250-300°F (121-149°C) 1 hour
Iron Powder M.S. EXX24 EXX27	70-110°F (21-43°C) 50% max. RH	100-120°F (38-49°C)	180-230°F (82-110°C) 1/2 hour	400-500°F (204-260°C) 1/2 hour
Iron Powder Low Hydrogen EXX18 EXX28 Low Hydrogen EXX15 EXX16 Low Hydrogen High Tensile EXXX15 EXXX16 EXXX18	70-110°F (21-43°C) 50% max. RH	250-300°F (121-149°C)	180-220°F (82-104°C) 1- 1/2 hours	650-750°F (343-399°C) 1 hour
Stainless EXXX-15 EXXX-16	40-120°F (4.5-49°C) 60% (+/- 10%) RH	250-300°F (121-149°C)	180-220°F (82-104°C) 1- 1/2 hours	500-600°F (260-316°C) 1 hour
Inconel Monel Nickel Hard Surfacing	40-120°F (4.5-49°C) 60% (+/- 10%) RH	150-200°F (66-93°C)	180-230°F (82-110°C) 1/2 hour	Not Recommended
Brasses Bronzes	40-120°F (4.5-49°C) 60% (+/- 10%) RH	150-200°F (66-93°C)	Not Recommended	
Granulated or Agglomerated Flux	40-120°F (4.5-49°C) 60% (+/- 10%) RH	100-200°F (38-93°C)	Contact Manufacturer for Specific Temperatures	
Flux Cored Wire EXXT-1 EXXT-2 EXXT-5 EXXT-G	40-120°F (4.5-49°C) 60% (+/- 10%) RH	200-300°F (93-149°C)	Contact Manufacturer for Specific Temperatures	