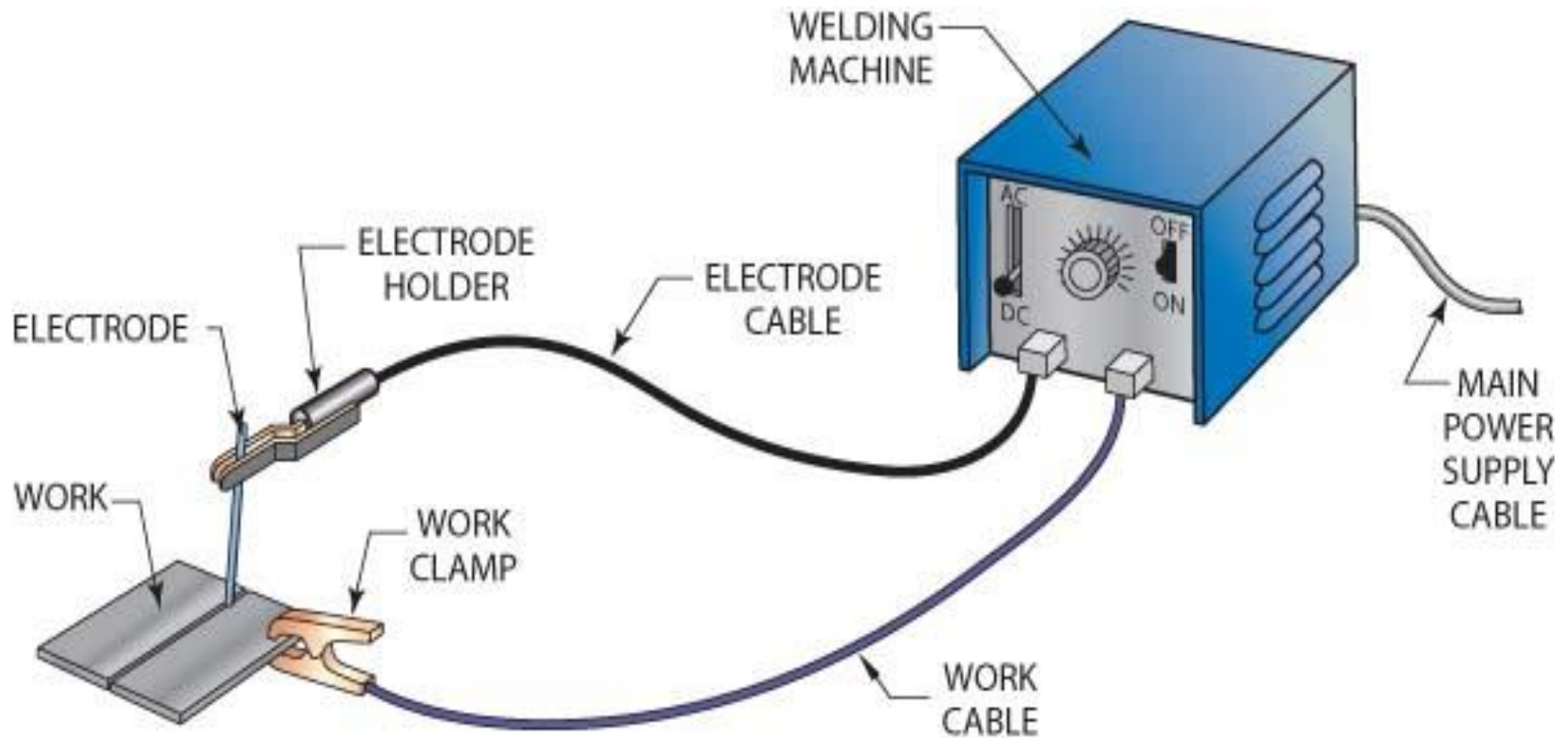


Shielded Metal Arc Welding



Direct Current Electrode Positive

- DCEP
- DC+
- Reverse
- Electrode +

Current flows from
WORK to ELECTRODE

Direct Current Electrode Negative

- DCEN
- DC-
- Straight
- Electrode -

Current flows from
ELECTRODE to WORK