WELDCOTE E6022

Carbon Steel Electrode

Description/Application: Weldcote 6022 electrode is designed for deep penetration welding where burn-through spot welding such as roof decking to support beams and similar applications are required. 6022 electrodes are typically used where single pass with high speed and current welding of groove welds in the flat welding position, lap joints in the horizontal welding position and fillet welds on sheet metal. The weld bead may be more convex and less uniform while welding at higher speeds. Used on moderate to poor or hard to clean steels such as painted, greasy and galvanized or plated steels as well as square edge butt joints. Welding position shall be flat or horizontal.

Specifications/Classification: AWS A5.1 & ASME SFA-5.1 / E6022

Typical Chemical Composition

Carbon	0.200%
Silicon	0.054%
Phosphorus	0.011%
Copper	0.017%
Chromium	0.010%
Vanadium	0.003%
Manganese	0.890%
Iron	Balance
Sulfer	0.032%
Nickel	0.028%
Molybdenum	0.003%
Aluminum	0.001%

Typical Mechanical Properties of Weld Metal:

Tensile Strength (psi)	64-79,000
Yield Strength (psi)	55-63,700
Elongation % in 2"	24 - 26

Transverse tension test and a longitudinal guided bend test passed as required per AWS

Recommended Welding Parameters

DC- & AC	Use a dragging short arc with 10-15% from 90°	
	1/8" x 14"	5/32" x 14"
Amps	110-150	150-180
Volts	22-27	24-30

Available sizes: 1/8” & 5/32” in 10 lb. containers

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