

DM6022 Premium Electrode

Classification: E6022

AWS A 5.1 / ASME SFA 5.1

DuraMax DM6022 is a MEDIUM HEAVY COATED, IRON OXIDE TYPE WELDING ELECTRODE

CHARACTERISTICS, FEATURES & APPLICATIONS

DURAMAX E6022 is a MEDIUM HEAVY COATED, IRON OXIDE TYPE ELECTRODE for single pass, high speed high current welding of groove welds in flat position. Smooth and Easy control Arc. DM6022 has excellent strike and re-strike, with low spatter.

DM6022 is suitable for welding roof decking to support beams. Lap joints in horizontal position and fillet welds on sheet metal. It can also be used on plate and dirty decking.

All Weld Chemical Composition (%)

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.14	1.20	0.28	0.012	0.025	0.02	0.03	0.04	0.01

Typical Mechanical Properties as Welded

Tensile Strength (n/mm ²)	Yield Strength (n/mm ²)	Elongation (%)	Hardness	Ferrite WRC (FN)	CVN Impacts (J)
					@ -30 °C
430	380 min	20% min	-----	-----	≥ 47 J

Sizes available and recommended currents (DC +)

SIZE	3/32	1/8	5/32
AMPS	60 ~ 110	80 ~ 140	160 ~ 200

POLARITY: DCEN or AC

DCEN: DC, Electrode Negative (straight polarity) has the least weld penetration

AC: medium weld penetration (can be more spatter)

WELDING POSITIONS: Flat, Horizontal, Overhead, Vertical-up and Vertical-down positions

USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METALS