WELDWIRE	DATA SHEET MILD STEEL ELECTRODES	Page: 1 of 1 Date: 11/6/2013 Product: E6022 Class: AWS A5.1-04

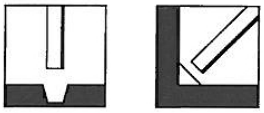
Classifications

AWS A5.1-04 : E6022
EN ISO 2560-A:2006 : E 38 0 A 23

Description

*Covering high iron oxide type welding of flat and horizontal fillet welding of sheet metal
*Highly efficient welding.
*Welding under excessive amperage conditions can cause the deterioration of radiographic soundness.
*Redry the electrode at 70~100°C for 30~60 minutes prior to use.

Welding positions



Typical chemical composition of all-weld metal

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

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S. (MPa)	El. (%)	IV (J) RT	IV (J) 0°C	Remarks
AWS A5.1		min. 430				
EN ISO 2560-A	min. 380	470~600	min. 20		≥ 47	
Example	450	480	26	75	55	AW

*AW: As-Welded

Sizes available and recommended currents (AC or DC-)

Dia.	inches	3/32	1/8	5/32	3/16	1/4
Amp.	F	60~110	80~140	160~200	180~240	260~320
(A)	V * OH					

Approvals

JIS, CE