



S. R. Industries

STAR ARC E6022

E6022, also known as "decking rod" is a very fluid electrode that is designed for welding roof decking to support beams with burn-through weld spots. It is also excellent for rapid downhill welding when joining light gauge materials.

Typical Applications : roof decking, sheet metal, spot welding floor decking to beams.

AWS Class : E6022	Classification : AWS A5.1/A5.1M:2004
Alloy : E6022	
Welding Position : F, H-fillet	Current : AC-DCEN
Tensile Strength, kpsi:	60 min
Yield Strength, kpsi:	56-64
Elongation in 2" (%) :	24-26

Typical Wire Chemistry as per AWS A5.1 (single values are maximum)

C	Mn	Si	P	S
0.13	1.14	0.34	0.027	0.012

Typical Welding Parameters

Diameter		Process	Volt	Amps (Flat)
in	(mm)			
1/8	(3.2)	SMAW	23-27	110-150
5/32	(4.0)	SMAW	24-30	150-190

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