DURAMAX®
Inspiring the future generations of welders

Product Data Sheet

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 grove 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.

Typical 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

All Weld Mechanical Properties

UTS (N/mm²)	YS (N/mm²)	EL % (1=4d)	CVN Impacts (J) @ -30°C
430 min	380 min	20% min	≥ 47 J

Sizes available and recommended currents (DC -) or AC

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

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The above information is to be use as a guideline and is taken directly from the manufacturers Technical Data Sheet. If additional information is needed please contact (800) 692-5930