

# K-6022

AWS E6022

FOR CARBON STEEL

## Typical applications

Flat and horizontal fillet welding of sheet metal.

## Coating

High iron oxide type.

## Characteristics on Usage

- ① A high iron oxide type electrode for single pass.
- ② Highly efficient welding.
- ③ Redry the electrode at 70~100°C for 30~60 minutes prior to use.

## Typical chemical composition of all-weld-metal (%)

C	Si	Mn	P	S
0.13	0.09	1.13	0.017	0.011

## Typical mechanical properties of all-weld-metal

Y · P N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	EI (%)
410 {42}	450 {46}	26

## Sizes available and recommended currents (AC or DC ⊕, ⊖)

Dia. (mm)	2.6	3.2	4.0	5.0	6.0
Length (mm)	350	350	400	400	450
Amp.	F V&OH				
	60~110	80~140	160~200	180~240	260~320

## Welding positions



Approved by