



ISO 9001:2015 REGISTERED
Certificate No.: 50040 & 50415

E6022 DATA SHEET

Pinnacle Alloys E6022

AWS CLASS E6022

CODE AND SPECIFICATION DATA:

AWS A5.1 ASME SFA 5.1 (2004)

DESCRIPTION:

Pinnacle Alloys E6022 is recommended for single-pass, high-speed, high-current welding of groove welds in the flat welding position, lap joints in the horizontal welding position, and fillet welds on sheet metal. The weld face tends to be more convex and less uniform, especially since the welding speeds are high. The covering is high iron oxide.

TYPE OF CURRENT: AC or Direct Current Electrode Negative (DCEN)

DIAMETERS: 1/8", 5/32"

STORAGE & RECONDITIONING: After opening, store at 60°F to 100°F and below 50% relative humidity or in a holding oven at 100°F to 120°F. Reconditioning should be for one hour at 150°F to 220°F.

WELDING POSITIONS: Flat and horizontal positions only



TYPICAL DEPOSIT COMPOSITION:

	AWS Spec	Weld Metal Analysis (%)
Carbon (C)	N.S.	0.14
Chromium (Cr)	N.S.	0.03
Manganese (Mn)	N.S.	1.20
Molybdenum (Mo)	N.S.	0.01
Nickel (Ni)	N.S.	0.02
Phosphorus (P)	N.S.	0.025
Silicon (Si)	N.S.	0.28
Sulfur (S)	N.S.	0.012
Vanadium (V)	N.S.	0.01

*N.S. means Not Specified.

NOTE: Single values are maximums.

www.pinnaclealloys.com

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TYPICAL MECHANICAL PROPERTIES:

Plastic Packaging (5# & 10#)	AWS Spec (min)	As Welded
Ultimate Tensile Strength	60,000 psi (430 MPa)	70,000 psi (480 MPa)
Yield Strength	Not required	65,000 psi (450 MPa)
Percent Elongation in 2"	Not required	26%
CVN @ 32°F (0°C)	Not required	40 ft•lb _f (55 Joules)

TYPICAL WELDING PARAMETERS:

Diameter	Type of Current	Amperage	Amperage Range	Voltage Range
1/8"	DCEP	100	80-140	25-28
5/32"	DCEP	140	160-200	26-29

NOTE: Optimum conditions are in boldface type. For out of position welding, decrease amperage by 15%. These values were calculated using optimum parameters and AC polarity. Allowance made for 2" stub loss. Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of steel being welded.

NOTICE: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for the use in the field. The manufacturer disclaims any warranty of merchantability of fitness for any particular purpose with respect to its products.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126; OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.

Pinnacle Alloys SDS sheets may be obtained on the website below.

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