

RATNA 6022

Medium heavy coated, Iron oxide type welding Electrode for high speed welding

CLASSIFICATION : AWS/SFA-5.1: E 6022

CHARACTERISTICS : Medium heavy coated, iron oxide type electrodes for single pass, high speed high current welding of groove welds in the flat position. Smooth and Easy control Arc, Excellent strike and Re-strike, low spatter.

APPLICATION :

- 1) Welding suitable for roof decking to support beams and others similar application.
- 2) Lap joints in the horizontal welding position.
- 3) Fillet welds on sheet metal.
- 4) Can be also used on plated and dirty decking.

RE-DRY CONDITION : Re-Dry the electrode at 135°C for one hour, for best results.

ALL WELD CHEMICAL COMPOSITION % (AWS not specified)

C	Mn	Si	S	P
0.10 max.	0.50-1.20	0.50 Max	0.030 Max	0.030 Max

ALL WELD MECHANICAL PROPERTIES: (AWS not specified)

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
350 Min.	430 Min.	20 Min.	0°C : 40-80 J

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC-/AC)	Weight./pkt.	Weight /Case
3.15/3.20	1/ 8"	110-160	5	20
4.00	5/ 32"	140-190	5	20
5.00	3/ 16"	170-250	5	20

Customer packing on request.