



UNIBRAZE 6022 (E6022)

DESCRIPTION:

UNIBRAZE 6022 is designed for welding roof decking to support beams and other similar applications where burn-through spot welds with full penetration are required. **UNIBRAZE 6022** is also designed to weld through galvanized or painted roof decking and can be used on plated and dirty decking as well. It is also excellent for rapid downhill welding when joining light gauge materials.

APPLICATIONS:

Burn-through spot welds for roof decking and sheet metal, rapid downhill welding on light gauge materials.

FEATURES:

- Smooth, easy to control arc
- Excellent strike and re-strike
- Penetrating arc
- Low spatter level
- Light slag

BENEFITS:

- Better control of spot nugget
- Reliable starts and restarts, no rework
- Strong, reliable welds
- Less clean-up, good bead appearance
- Faster clean-up

TYPICAL WELD METAL PROPERTIES (Chem Pad):

Weld Metal Analysis

Carbon (C)	0.18
Manganese (Mn)	0.25
Phosphorus (P)	0.015
Sulphur (S)	0.017
Silicon (Si)	0.15

AWS Spec (max)

not required
not required
not required
not required
not required

TYPICAL MECHANICAL PROPERTIES (AW):

Tensile Strength	60,000 psi (414 MPa)
Yield Strength	not required
Elongation % in 2"	not required
Reduction of Area	not required

AWS Spec (min)

60,000 psi
not required
not required
not required

TYPICAL CHARPY-V-NOTCH IMPACT VALUES (AW):

Not Applicable

TYPE OF CURRENT: DCEN, DCEP or AC

CONFORMANCES AND APPROVALS:

- AWS A5.1, E6022

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 use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its product.



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RECOMMENDED WELDING PROCEDURES:

- GENERAL:** Electrode negative, work positive (DCEN), or electrode positive, work negative (DCEP) or AC
- ARC LENGTH:** Short arc or drag technique
- FLAT:** Using dragging technique, hold electrode angle 10-15° from 90°
- VERTICAL-UP:** Not recommended
- VERTICAL-DOWN:** Use dragging technique, hold electrode 10-15° from 90°
- OVERHEAD:** Not recommended
- STORAGE:** 60°F to 100°F, (20° to 40°C) and below 50% relative humidity or holding oven @ 100° to 120°F (38° to 49°C)
- RECONDITIONING:** 250°F to 300°F, (121° to 149°C) for one hour @ temperature

RECOMMENDED OPERATING PARAMETERS:

Diameter		Type of Power	Minimum Amps	Optimum* Amps	Maximum Amps
Inches	mm				
1/8	3.2	DCEN, DCEP or AC	110	130	150
5/32	4.0	DCEN, DCEP or AC	150	165	180

*For out-of-position welding, reduce amperage shown by 15%.

TYPICAL DEPOSITION DATA (at optimum):

Diameter		Type of Power	Amps	Volts	Deposition Rate lbs/hr	Deposition Efficiency*%
Inches	mm					
1/8	3.2	DCEN	150	24	2.89	56.0
5/32	4.0	DCEN	180	25.5	3.09	58.8

*Allowance made for 2" stub loss included.

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