



Quality Management System
in accordance with
ISO 9001:2000
Cert # 05-R0925

USA 6022 Coated Electrode

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



ALLOY DESCRIPTION AND APPLICATION;

USA 6022 are 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 higher. It is designed for welding roof decking to support beans and applications where burn-through spot welds are required. May also be used on poor or hard to clean steels such as painted, greasy and galvanized/ plated steels and square edge butt joints.

TYPICAL WELDING PROCEDURES; DCEN & AC

Diameter	Amps (Flat)	Volts
1/8"	110-150	23-27
5/32"	150-190	24-30

Use a short arc – dragging with 10-15% from 90°

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

TYPICAL WELD METAL CHEMISTRY (%) & PROPERTIES

Carbon	0.13		
Manganese	1.14	Elongation in 2"(%)	24-26
Silicon	0.34	Yield Strength (psi)	56-64,000
Phosphorus	0.027	Tensile Strength (psi)	69-79,000
Sulphur	0.012	(Transverse)	

AVAILABLE SIZES: TE 6022 = 1/8", 5/32"

SPECIFICATIONS; ANSI/AWS A5.1 E6022
ASME SFA 5.1 E6022

EAST COAST
7010-G Reames Rd
Charlotte, NC 28216
Tel (888) 522-8296
Fax (704)598-6673

GULF COAST
4855 Alpine Drive #190
Stafford, TX 77477
Tel (877) 711-9274
Fax (281)313-6332

WEST COAST
8535 Utica Ave
Rancho Cucamonga, CA 91730
Tel(800)830-9033
Fax (909)291-4586



5-2007 DC

Washington Alloy Company believes that all information and data given is correct. Use this information to assist in making your own evaluations or decisions and this information should not be mistaken as an expressed or implied warranty. U.S. ALLOY CO. assumes no liability for results or damages incurred from the use of any information contained herein, in whole or in part.