

CS-22

For welding of general mild steel

AWS A5.1 E6022
EN ISO 2560-A E 38 0 A 23

Applications

Roof and floor deck welding
Welding of ship hulls, vehicles and bridges.

Characteristics

- (1) CS-22 is high iron oxide type for welding of flat and horizontal fillet welding of sheet metal.
- (2) It allows high speed welding and has excellent re-arc generation.
- (3) It is designed for welding roof decking to support beams and applications where burn-through spot welds are required.

Notes on usage

- (1) Pay attention not to exceed heat-input because excessive heat-input causes a decrease in weldability.
- (2) Redry the electrodes at 70-100°C for 30~60 minutes before use.
- (3) Adopt back step method or strike the arc on a small steel plate prepared for this particular Purpose to prevent blowholes at the arc starting.
- (4) Keep the arc as short as possible.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S
0.13	0.81	0.04	0.019	0.009

Typical mechanical properties of weld metal

Welding method	YS N/mm ² (kfg/mm ²)	TS N/mm ² (kfg/mm ²)	EL %	IV (J)
				0°C
T Butt	-	497	-	-
Deposition	531 (54)	582 (59)	29	120

Size & recommended current range (DC- or AC)

Dia. (mm)		2.6	3.2	4.0	5.0
L (mm)		350	350	400	400
Amp.	F, H	100-140	140-190	180-240	250-310

*Approval : -