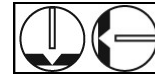


Deckmaster™ 1139



AWS E6022 (E4322*)

WELDING POSITIONS:



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

APPLICATIONS:

- Roof decking
- Sheet metal
- Light gauge materials

TYPE OF CURRENT: 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° 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° to 300°F, (121° to 149°C) for one hour @ temperature

TYPICAL WELD METAL CHEMISTRY* (Chem Pad):

Weld Metal Analysis (%)		AWS Spec (max)
Carbon (C)	0.04	Not required
Manganese (Mn)	1.17	Not required
Silicon (Si)	0.15	Not required
Phosphorus (P)	0.013	Not required
Sulphur (S)	0.013	Not required

Note: AWS specification single values are maximums.

TYPICAL MECHANICAL PROPERTIES* (As Welded):

Mechanical Tests		AWS Spec (min)
Transverse Tensile Strength Exceeds	65,000 psi (450 MPa)	60,000 psi (414 MPa)
Yield Strength	Not required	Not required
Elongation % in 2" (50 mm)	Not required	Not required
Reduction of Area	Not required	Not required

TYPICAL CHARPY V-NOTCH IMPACT VALUES** (As Welded):

Not applicable

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers LLC expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with the AWS A5.1 specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart Brothers LLC.

Deckmaster™ 1139

Diameter		Type of Current	Minimum Amps	Optimum Amps	Maximum Amps
Inches	(mm)				
1/8	(3.2)	DCEN, DCEP or AC	110	140	150
5/32	(4.0)	DCEN, DCEP or AC	150	170	180

Diameter		Type of Current	Amps	Volts	Deposition Rate		Deposition Efficiency %
Inches	(mm)				lbs/hr	(kg/hr)	
1/8	(3.2)	DCEN, DCEP or AC	140	32	2.22	(1.0)	56.3
5/32	(4.0)	DCEN, DCEP or AC	170	34	3.03	(1.4)	62.0

- Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded.

STANDARD DIAMETERS AND PACKAGES: For a complete list of diameters and packaging, please contact Hobart Brothers at (800) 424-1543, or (937) 332-5188 for International Customer Service.

Diameter		50-lb. (22.7kg) Carton
Inches	(mm)	
Net Pallet Weight		3000-lb. (1361 kg)
1/8	(3.2)	S113244-031
5/32	(4.0)	S113251-031

CONFORMANCES AND APPROVALS:

- AWS A5.1, E6022

TECHNICAL QUESTIONS? For technical support of Hobart Filler Metals products, contact the Applications Engineering department by phone toll-free at 1-800-532-2618 or by e-mail at Applications.Engineering@hobartbrothers.com

CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 550 NW LeJune Road, Miami, FL 33126; OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor,

Safety Data Sheets on any Hobart Brothers LLC product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

Because Hobart Brothers LLC is constantly improving products, Hobart reserves the right to change design and/or specifications without notice.

Deckmaster is a registered trademark of Hobart Brothers LLC, Troy, Ohio.

Revision Date: 201105 (Replaces 130809)
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