

AWS E6022 (E4322*)

Deckmaster™ 1139**DESCRIPTION:**

Deckmaster 1139 is designed for welding roof decking to support beams and other similar applications where burn-through spot welds with full penetration are required. Deckmaster 1139 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		AWS Spec (max)
Carbon (C)	0.18	not required
Manganese (Mn)	0.25	not required
Silicon (Si)	0.15	not required
Phosphorus (P)	0.015	not required
Sulphur (S)	0.017	not required

TYPICAL MECHANICAL PROPERTIES(AW):**

		AWS Spec (min)
Transverse tensile strength exceeds	60,000 psi (414 MPa)	60,000 psi
Yield Strength	not required	not required
Elongation % in 2"	not required	not required
Reduction of Area	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

* Metric AWS classification

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers Company expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with 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 Company.

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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.

AVAILABLE DIAMETERS AND PACKAGES:

Diameter		Length		50-Lb. Carton
Inches	mm	Inches	mm	
1/8	3.2	14"	355	S113244-031
5/32	4.0	14"	355	S113251-031

Material Safety Data Sheets on any Hobart Brothers Company product may be obtained from Hobart Customer Service.

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

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