

STICK ELECTRODE

PAK BRIDGE J-421



SMAW

KEY FEATURES

1. EXCELLENT ARC STABILITY
2. FAST-FREEZE
3. SLAG REMOVES EASILY
4. WELDING ACCURACY AND EFFICIENCY
5. EXCELLENT FOR POOR FIT-UP
6. QUICK CLEAN UP
7. WELDS IN FLAT, HORIZONTAL AND VERTICAL POSITIONS
8. DIRECT CURRENT ELECTRODE POSITIVE (DCEP), AC, OR DIRECT CURRENT ELECTRODE NEGATIVE (DCEN)
9. DIAMETERS: 3/32", 1/8", 5/32", 3/16"

CLASSIFICATION

AWS A5.1 : E6013 ISO : E432 R11, DIN : E4322 R (C) 3

GENERAL DESCRIPTION

Pak Bridge (J-421) is a kind of carbon steel electrode with Titanium type coating. AC/DC. It has excellent welding performance; operates with quiet arc and smooth bead with fine ripples, gives medium penetration, least spatter, lower smoke and easily detachable slag. Easy arc strike and re-strike with superior mechanical properties.

APPLICATIONS

Excellent general purpose electrode for welding low-carbon steel structures, especially suitable for welding on the plates and cosmetic welding which requires the weld beads to be beautiful and glossy. Suitable for welding structures of steel, vehicles, truck frames and bodies, ships, storage tanks, boiler tubes, railway coaches, bridges, buildings steel furniture, window frames, grills, machinery-manufacture, vessels and various structures of low carbon steel

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD META L

C	Mn	Si	S	P
≤0.12	0.3-0.6	≤0.35	≤0.035	≤0.040

MECHANICAL PROPERTIES, OF DEPOSITED METAL

Item	Tensile Strength	Yield Strength	Elongation	*CVNAT-20°C
Units	Rm(MPa)	ReL(MPa)	A%	KV2(J)
General Result	460-540	>340	18-26	>47

ELECTRODE SIZE / CURRENT CONDITION / PACKAGING INFORMATION

Electrode Dia (mm)	2.5mm	3.2mm	4.0mm	5.0mm
Electrode length (mm)	300	350	400	400
Current Range	Min.	50A	90A	140A
	Max.	90A	130A	190A
Packing Information Inner Box Weight (No of PKT) Per Carton	2.5kg(8)	5kg(4)	5kg(4)	5kg(4)
Approx. Electrodes Per Pkt.	146	155	90	60

STORAGE AND RE-BAKING

It is recommended that the Pak Bridge J-241 electrodes are stored in a dry heated store at a minimum temperature of 180°C, and a maximum relative humidity of 60%. Not more than 6 Cartons should be stacked on top of one another to avoid damage to the coatings.

Re-drying

If these electrodes become excessively damp re-drying@ 100°C for 1 hour.

WELDING POSITIONS

