

LOW CARBON STEEL WELDING ELECTRODE

PAK BRIDGE J-422



KEY FEATURES

1. LOW CARBON STEEL ELECTRODE
2. GOOD ARC STABILITY
3. LESS SPATTER
4. EASY SLAG REMOVAL
5. WELDING ACCURACY AND EFFICIENCY
6. EXCELLENT FOR POOR FIT-UP
7. QUICK CLEAN UP AND RE-IGNITION OF ARC
8. WELDS IN FLAT, HORIZONTAL AND VERTICAL POSITIONS
9. DIRECT CURRENT ELECTRODE POSITIVE (DCEP), AC, OR DIRECT CURRENT ELECTRODE NEGATIVE (DCEN)
10. DIAMETERS: 3/32", 1/8", 5/32", 3/16"

SMW

CLASSIFICATION

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

GENERAL DESCRIPTION

Fastest growing brand in Pakistan. Provides best value for money for the welders. Used mainly in light to medium fabrication. Pak Bridge J-422 is a kind of low-carbon steel electrode. AC/DC. All Position welding. It gives excellent arc stability, fine ripples and very easy slag removal. It has exception all-positional operating characteristics.

APPLICATIONS

Smooth weld, least spatter, lower fumes and smooth beads with fine ripples. Fully positional general purpose electrode for welding low carbon steel surface. Easy arc strike and re-strike with superior mechanical properties. Safer for welders and reduces the risk associated with welding.

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

| 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-0°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. | 55A | 90A | 140A | 180A |
| | Max. | 90A | 130A | 190A | 240A |
| 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-422 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

