



J421 (J38.12)

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TIANJIN GOLDEN BRIDGE WELDING MATERIALS GROUP CO.,LTD.

GB/T 5117 E4313 AWS A5.1 E6013

Introduction :

J421 is rutile-based carbon steel electrode. It has very good welding usability that enables it to perform all-position welding, operates on AC/DC, removal of slag is easy, has stable arc and also has very good bead appearance. It is easy to operate, which makes re-striking the arc easy.

Purpose :

It is suitable for welding structures made of low carbon steel, performs very well in welding thin and small size steel plates and also has very good performance in the situation that requires nice and clean bead appearance.

Chemical Composition (%)

Chemical Composition	C	Mn	Si	S	P	Ni	Cr	Mo	V
Guarantee Value	≤0.20	≤1.20	≤1.00	≤0.035	≤0.040	≤0.30	≤0.20	≤0.30	≤0.08
General Result	0.079	0.38	0.21	0.018	0.024	0.020	0.032	0.005	0.010

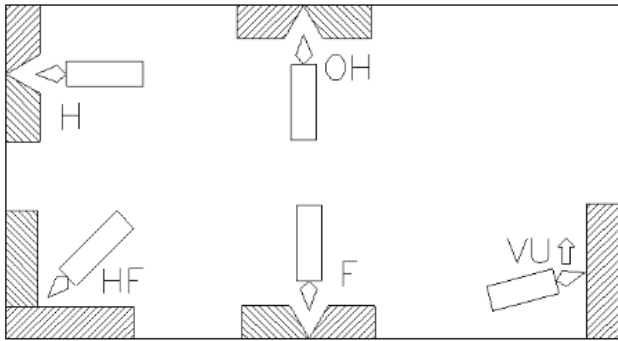
Mechanical Properties of Deposited Metal

Test Item	Rm (N/mm ²)	Rel (N/mm ²)	A (%)	KV ₂ (J) 0°C
Guarantee Value	≥430	≥330	≥16	≥47
General Result	485	380	28.5	86

Reference Current (DC)

Diameter	Φ2.0	Φ2.5	Φ3.2	Φ4.0	Φ5.0
Amperage	40 ~ 70	50 ~ 90	90 ~ 130	130 ~ 210	170 ~ 230

Welding Position:



Certificates



CCS CERTIFICATE



LR CERTIFICATE



BV CERTIFICATE



DNV CERTIFICATE



GL CERTIFICATE



ABS CERTIFICATE



NK CERTIFICATE



BKI CERTIFICATE