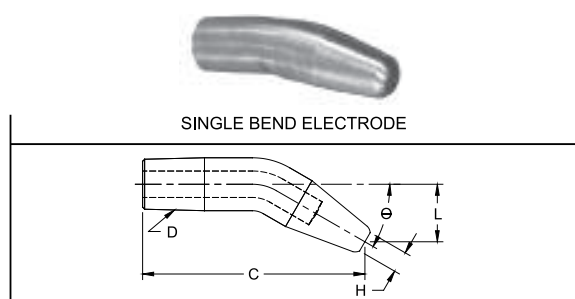


SINGLE BEND ELECTRODES

RWMA CLASS 2 single bend electrodes are cold formed from full hard straight electrodes, and have properties superior to those obtained by casting or hot forging methods. Cooling tubes are bent in place, if requested, to provide water flow as near to the welding face as in the case of straight electrodes. These extra values assure you a more efficient, less costly electrode for gun welders and special offset welding applications.

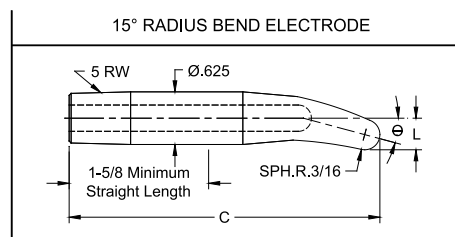
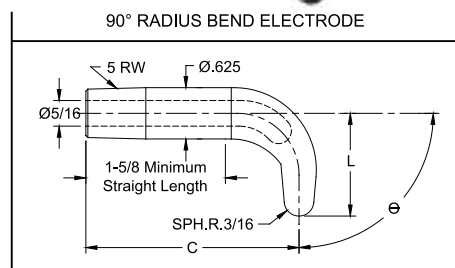
Furnished with water tubes as specials to your order. Other nose types available to order. For dimensions not shown here see straight electrode (round water hole) measurements on page 14, 15, & 16. RWMA CLASS 1 material available on special order.

SINGLE BEND ELECTRODES



PART No.	Reference Length to \bar{C} of Face C	Taper D	Offset \bar{C} of Taper to \bar{C} of Face L	Bend Angle Θ	Bend Weld Face Dia. H
3214-04-15	1-11/16	4 RW	1/4	15°	3/16
3219-04-15	2-15/16		1/4		
32118-13-15	3-7/8		13/16		
3225-04-15	1-7/8	5 RW	1/4	15°	1/4
3229-04-15	2-7/8		1/4		
32218-10-15	3-13/16		5/8		
3215-07-30	1-7/8	4 RW	7/16	30°	3/16
3219-07-30	2-7/8		7/16		
32118-23-30	3-5/8		1-7/16		
3226-09-30	2-1/16	5 RW	9/16	30°	1/4
32212-09-30	3-1/16		9/16		
32220-24-30	3-13/16		1-1/2		
3215-10-45	1-11/16	4 RW	5/8	45°	3/16
32112-12-45	2-7/8		3/4		
32118-33-45	3-1/8		2-1/16		
3228-17-45	2-1/4	5 RW	1-1/16	45°	1/4
32214-17-45	3		1-1/16		
32220-33-45	3-3/8		2-1/16		
3218-23-60	2	4 RW	1-7/16	60°	3/16
32116-23-60	3		1-7/16		
32118-40-60	2-5/8		2-1/2		
32212-25-60	2-3/8	5 RW	1-9/16	60°	1/4
32218-25-60	3-1/8		1-9/16		
32220-38-60	3		2-3/8		
32216-35-75	2-5/16	5 RW	2-3/16	75°	1/4
32220-37-75	2-11/16		2-5/16		
32220-43-75	2-3/8		2-11/16		

Bend dimensions are for reference only



PART No.	O.A.L. C	Offset \bar{C} of Taper to Top of Radius L	Bend Angle Θ
16-26015	3-11/16	3/8	15°
16-26030	3-5/8	33/64	30°
16-26045	3-1/2	43/64	45°
16-26060	3-3/8	27/32	60°
16-26075	3-7/64	1-1/32	75°
16-26090	2-13/16	1-1/4	90°

Radius bend electrodes are designed for use with 18-768 & 18-784 straight universal adapters shown on page 46.

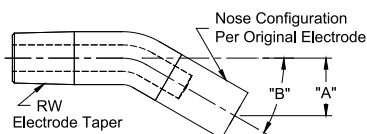
- See page 6 for Metric Conversion
- See page 7 for Taper Dimensions

Original Electrode	"A" Offset 1/16 Increments	"B" Bend In Degrees
XXXXX	XX	XX
04 = 1/4	26 = 1-5/8	15 = 15° Bend
06 = 3/8	28 = 1-3/4	30 = 30° Bend
08 = 1/2	30 = 1-7/8	45 = 45° Bend
10 = 5/8	32 = 2	60 = 60° Bend
12 = 3/4	34 = 2-1/8	75 = 75° Bend
14 = 7/8	36 = 2-1/4	90 = 90° Bend
16 = 1	38 = 2-3/8	
18 = 1-1/8	40 = 2-1/2	
20 = 1-1/4	42 = 2-5/8	
22 = 1-3/8	44 = 2-3/4	
24 = 1-1/2	46 = 2-7/8	

Example:
3319-08-15
= 1/2 Offset
= 15° Bend

SINGLE BEND ELECTRODE CODING SYSTEM

For electrodes not listed



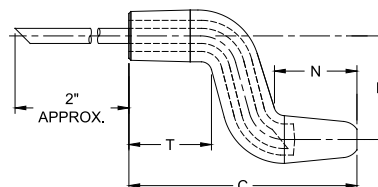
DOUBLE BEND ELECTRODES

Offset D	Taper Size	Nose End N	Taper End T	Dome, Pointed & Flat, O.A.L. C	Pointed Nose Part No.
1/2	4 RW	3/4	7/8	2	321-0832-23
		3/4	7/8	2-1/2	321-0840-23
		2	7/8	3-1/4	321-0852-93
	5 RW	1	1	2-1/2	322-0840-44
		1	1	2-3/4	322-0844-44
3/4	4 RW	1	1	3-1/4	322-0852-44
		2	1	3-1/2	322-0856-94
	5 RW	3/4	7/8	2	321-1232-23
		3/4	7/8	2-1/2	321-1240-23
1	4 RW	2	7/8	3-1/2	321-1256-93
		1	1	2-3/4	322-1244-44
	5 RW	1	1	3	322-1248-44
		2	1	3-1/2	322-1256-94
1-1/4	4 RW	3/4	7/8	2-1/4	321-1636-23
		3/4	7/8	2-3/4	321-1644-23
	5 RW	1-3/4	7/8	3-1/4	321-1652-83
		3/4	7/8	3-1/2	321-1656-23
1-1/2	4 RW	1	1	2-3/4	322-1644-44
		1	1	3	322-1648-44
	5 RW	1	1	3-1/2	322-1656-44
		1-3/4	1	3-1/2	322-1656-84
1-3/4	4 RW	3/4	7/8	2-1/2	321-2040-23
		3/4	7/8	3	321-2048-23
	5 RW	1-1/2	7/8	3	321-2048-73
		1	1	2-3/4	322-2044-44
1-1/2	4 RW	1	1	3-1/4	322-2052-44
		1	1	3-1/2	322-2056-44
	5 RW	1-1/2	1	3-1/2	322-2056-74
		1-3/4	1	3-1/2	322-2056-84
1-3/4	4 RW	1	1	2-3/4	322-2444-44
		1-1/4	1	3	322-2448-64
	5 RW	1	1	2-3/4	322-2844-44
		1-1/4	1	3	322-2848-64

DOUBLE BEND ELECTRODES

CMW double bend electrodes are cold formed from full hard straight electrodes, and have properties superior to those obtainable by casting or hot forging methods. Cooling tubes, unless otherwise specified are bent in place to provide coolant flow near the welding face as in the case of straight electrodes. These extra values assure you of longer electrode life, longer runs between dressings, and highest weld quality. RWMA CLASS 2 material is standard for these electrodes. RWMA CLASS 1 or CLASS 3, available on special order.

DOUBLE BEND POINTED NOSE

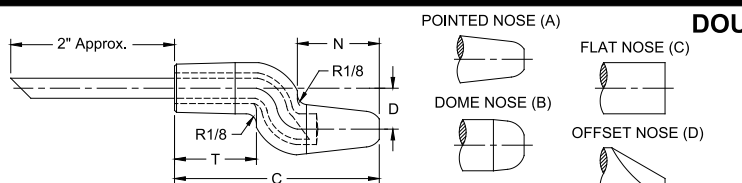


Bent dimensions are for reference only



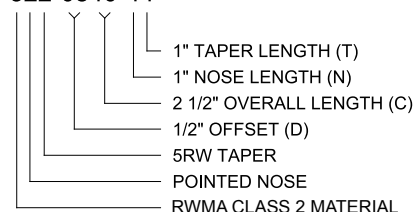
Water Tube Sizes:
4RW = .182 O.D.
5RW = .245 O.D.

DOUBLE BEND ELECTRODE CODING SYSTEM



EXAMPLE:

322-0840-44



Taper
Nose
Material

Offset (D)
Overall Length (C)
Nose Length (N)
Taper Length (T)
Optional Without Water Tube

1= CLASS 1	1= DOME	1= 4RW 1MT
3= CLASS 2	2= *POINTED	2= 5RW 2MT
5= CLASS 3	3= FLAT	
*Standard	4= OFFSET	

08= 1/2"	32= 2"	2= 3/4"
12= 3/4"	36= 2 1/4"	3= 7/8"
16= 1"	40= 2 1/2"	4= 1"
20= 1 1/4"	44= 2 3/4"	** 5= 1 1/8"
24= 1 1/2"	48= 3"	** 6= 1 1/4"
28= 1 3/4"	52= 3 1/4"	** 7= 1 1/2"
	56= 3 1/2"	** 8= 1 3/4"
	60= 3 3/4"	** 9= 2"

Water Tube Sizes:
4RW = .182 O.D.
5RW = .245 O.D.

**May not be a stock item

Standard 4RW nose length = 3/4"

Standard 4RW taper length = 7/8"

Standard 5RW nose & taper length = 1"

- See Page 6 for Metric Conversion
- See Page 7 for Taper Dimensions