



J421 (J38•12)

Conform to GB/T 5117 E4313
 AWS A5.1 E6013
 ISO 2560-B-E 43 13 A

Instructions: J421 is carbon steel welding rod covered with titanium oxide coating. It can be used under AC and DC and all-position welding is possible. It is characterized by excellent welding performance, good operation performance, easy weld restarting, stable arc and beautiful weld joint appearance.

Purpose: It is used for welding of low-carbon steel structures, especially suitable for welding of small thin plates and cosmetic welding which requires beautiful and clean weld joint surface

Chemical composition of deposited metal (%)

Items	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
Measured value	0.079	0.38	0.21	0.018	0.024	0.020	0.032	0.005	0.010

Mechanical properties of deposited metal

Test Items	R _m (MPa)	R _{eL} (MPa)	A(%)	KV ₂ (J) 0°C
Guarantee value	≥ 430	≥ 330	≥ 17	≥ 47
Measured value	485	380	28.5	86

X-ray radiographic inspection requirements: Level II

Reference current (AC.DC)

Welding wire diameter (mm)	Φ2.0	Φ2.5	Φ3.2	Φ4.0	Φ5.0
Welding Current (A)	40 ~ 70	50 ~ 90	90 ~ 130	130 ~ 210	170 ~ 230

Welding position:

