

# SINGLE BEND ELECTRODES



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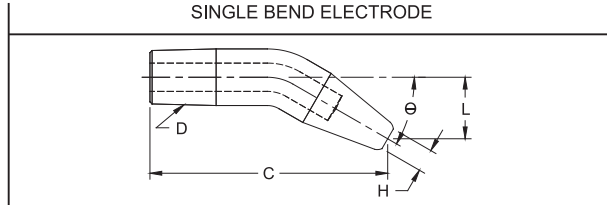
RWMA CLASS 2 single bend electrodes are cold formed from full hard straight electrodes, and have properties superior to those obtained by casting or hot forging methods. Cooling tubes are bent in place, if requested, to provide water flow as near to the welding face as in the case of straight electrodes. 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



SINGLE BEND ELECTRODE

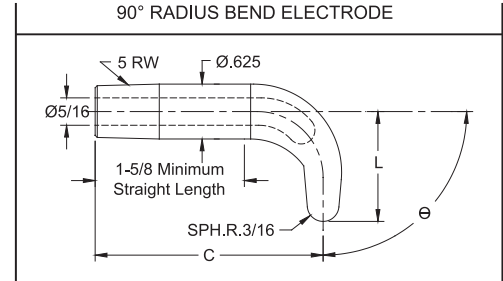


PART No.	Reference Length to $\phi$ of Face C	Taper D	Offset $\phi$ of Taper to $\phi$ of Face L	Bend Angle $\theta$	Bend Weld Face Dia. H
3214-04-15	1-11/16	4 RW	1/4	15°	3/16
3219-04-15	2-15/16		1/4		
32118-13-15	3-7/8		13/16		
3225-04-15	1-7/8	5 RW	1/4	30°	1/4
3229-04-15	2-7/8		1/4		
32218-10-15	3-13/16		5/8		
3215-07-30	1-7/8	4 RW	7/16	45°	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	60°	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	75°	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	90°	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		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		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		
32220-37-75	2-11/16		2-5/16		
32220-43-75	2-3/8		2-11/16		

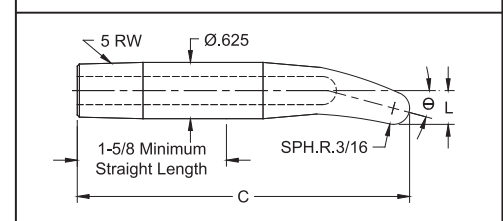
Bend dimensions are for reference only



90° RADIUS BEND ELECTRODE



15° RADIUS BEND ELECTRODE



PART No.	O.A.L. C	Offset $\phi$ of Taper to Top of Radius L	Bend Angle $\theta$
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

