



New Design! New Era!

Meeting the international trend, we made a whole new design, the new design DNA will be planted in every single package, from the big welding wire drum to the small electrode box. The new design of package will show multi-curves, which means all international friends and our company grow together.

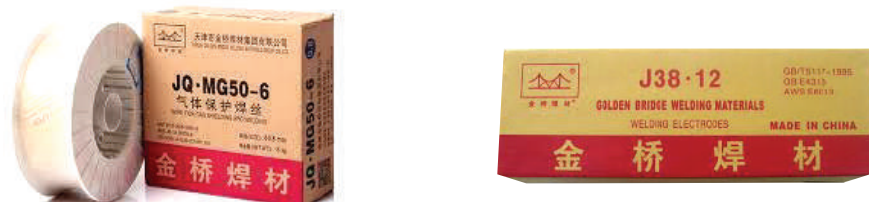
New Release



Golden Bridge Welding Materials Group is the leading professional manufacturer in welding industry. The group offers innovative solutions and qualified products to help customers around the world.

Our products cover all kinds of ferroalloy welding materials, including welding electrode, solid welding wire, flux-cored welding wire, submerged-arc welding wire, argon-arc welding wire, sintered flux.

Old Boxes





J421X



Introduction: J421X is rutile-based carbon steel electrode that is specially designed for downward welding. It has good welding usability that enables it to operate on AC/DC and perform all-position welding, the slag removal is easy and to have a nice bead appearance. Its characteristic of easy operation gives it easy striking and re-striking.

Uses: It is suitable for welding zinc-coated steel plates and carbon steel plates that are used in shipbuilding. It is especially suitable for performing downward welding and intermittent welding on the thin plates. .

Mechanical Properties of Deposited Metal

Test Item	R _m (MPa)	R _{eL} (Mpa)	A(%)	KV ₂ (J) 0°C
Guarantee Value	≥430	≥330	≥16	—
General Result	485	390	27	76

Reference Current (AC/DC)

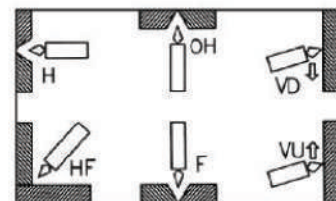
Diameter	Φ2.0	Φ2.5	Φ3.2	Φ4.0	Φ5.0
Amperage	40 ~ 70	50 ~ 90	90 ~ 130	130 ~ 210	170 ~ 230

Chemical Composition (%)

Chemical Composition	C	Mn	Si	S	P	Ni	Cr
Guarantee Value	≤0.20	≤1.20	≤1.00	≤0.035	≤0.040	≤0.30	≤0.20
General Result	0.078	0.39	0.18	0.018	0.023	0.020	0.032

Mo	V
≤0.30	≤0.08
0.008	0.007

Welding Positions:





Carbon Steel Electrode

J422 (J40.50)



Introduction: J422 is calcium-titanium coated carbon steel electrode. It has very good welding usability that enables it to operate on AC/DC, performs all-position welding, has stable arc, removal of slag is easy and has good bead appearance. Its good mechanical properties give it very good low temperature toughness. During the application, its characteristic of easy maneuverability offers easy striking, easy re-striking and good control of welding speed, which enables the welders to have desired weld path and penetration of the arc.

Uses: It is applied in welding the structures made of low-carbon steel and low alloy structures such as Q235, 09MnV, 09Mn2 and etc.

Mechanical Properties of Deposited Metal

Test Item	R _m (MPa)	R _{eL} (Mpa)	A(%)	KV ₂ (J) 0°C	
				0°C	-20°C
Guarantee Value	≥430	≥330	≥20	≥27	≥47
General Result	475	390	29.5	97	73

Reference Current (AC/DC)

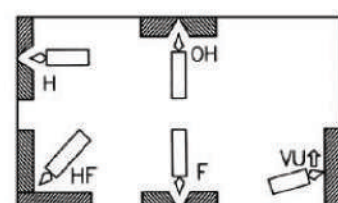
Diameter	Φ2.0	Φ2.5	Φ3.2	Φ4.0	Φ5.0
Amperage	40 ~ 70	60 ~ 100	80 ~ 140	140 ~ 220	180 ~ 240

Chemical Composition (%)

Chemical Composition	C	Mn	Si	S	P	Ni	Cr
Guarantee Value	≤0.20	≤1.20	≤1.00	≤0.035	≤0.040	≤0.30	≤0.20
General Result	0.078	0.39	0.18	0.018	0.023	0.020	0.032

Mo	V
≤0.30	≤0.08
0.008	0.005

Welding Positions:





J506Fe



Introduction: J506Fe is a low-hydrogen-potassium-iron-powder coated carbon steel electrode. The iron powder in the coating increases the deposited rate. It has very good usability that enables it to have stable arc, low-spatter, removal of slag is easy and performs all-position welding. The deposited metal has good mechanical properties that offer very good low temperature toughness.

Uses: It is applied in welding structures made of carbon steel and low-alloy steel such as 16Mn.

Mechanical Properties of Deposited Metal

Test Item	R _m (N/mm ²)	R _{el} (N/mm ²)	A (%)	KV ₂ (J) -30°C
Guarantee Value	≥490	≥400	≥20	≥27
General Result	550	455	32	156

Reference Current (DC)

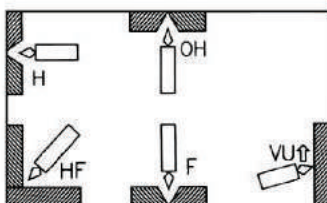
Diameter	Φ2.0	Φ3.2	Φ4.0	Φ5.0
Amperage	60 ~ 100	80 ~ 140	110 ~ 210	160 ~ 230

Chemical Composition (%)

Chemical Composition	C	Mn	Si	S	P	Ni	Cr
Guarantee Value	≤0.15	≤1.60	≤0.90	≤0.035	≤0.035	≤0.30	≤0.20
General Result	0.077	1.07	0.54	0.005	0.014	0.011	0.028

Mo	V
≤0.30	≤0.08
0.007	0.016

Welding Positions:



Notes:

1. The electrode must be preheated at the temperature of 350°C for 1 hour. Preheat the rod whenever it is used.
2. The impurities such as rust, oil stains and moisture must be cleared off of the work piece.
3. Short arc is required to perform welding. Narrow weld path is preferred.



J507 (J48.57)



Introduction: J507 is low-hydrogen sodium coated carbon steel electrode. It must be operated on DCEP. It has very good welding usability that enables it to perform all-position welding, has stable arc, removal of slag is easy and has low spatter. The deposited metal has good mechanical performance and crack-resistance, which offers good low temperature toughness.

Uses: It is applied in welding medium-carbon steel and low-alloy structures such as 16Mn, 09Mn2Si, 09Mn2V and the steels used in shipbuilding such as A, B, D, E. It is also used in thick steel plates and the carbon steel structures that are difficult to weld.

Mechanical Properties of Deposited Metal

Test Item	R _m (N/mm ²)	R _{eL} (N/mm ²)	A (%)	KV2(J)	
				-27°C	-30°C
Guarantee Value	≥490	≥400	≥20	≥47	≥27
General Result	560	450	32	150	142

Reference Current (AC/DC)

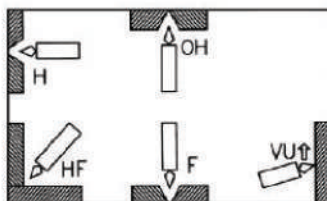
Diameter	Φ2.5	Φ3.2	Φ4.0	Φ5.0
Amperage	60 ~ 100	80 ~ 140	110 ~ 210	160 ~ 230

Chemical Composition (%)

Chemical Composition	C	Mn	Si	S	P	Ni	Cr
Guarantee Value	≤0.15	≤1.60	≤0.90	≤0.035	≤0.035	≤0.30	≤0.20
General Result	0.087	1.12	0.58	0.012	0.021	0.011	0.028

Mo	V
≤0.30	≤0.08
0.007	0.016

Welding Positions:



Notes:

1. The electrode must be preheated at the temperature of 350°C for 1 hour. Preheat the rod whenever it is used.
2. The impurities such as rust, oil stains and moisture must be cleared off of the work piece.
3. Short arc is required to perform welding. Narrow weld path is preferred.