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Welding Electrode
Materials and Shape of Electrode

■ Materials of Electrode

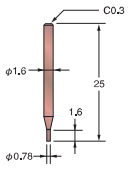
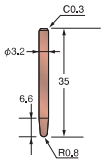
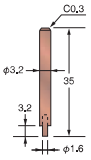
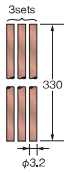
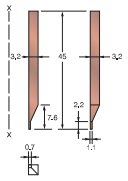
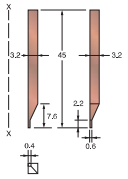
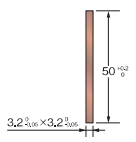
The list below shows rough standards to choose materials for an electrode, though it may be changed according to its surface treatment or dimensions.

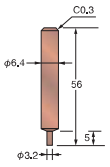
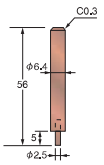
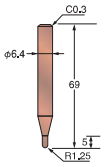
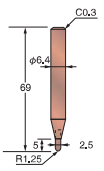
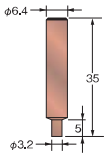
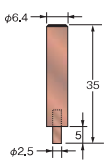
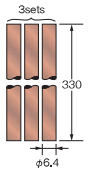
Electrode Number	Alloy Components	Electric Conductivity (IACS%)	Applicable Metal
02 (equivalent to RWMA-2)	Cu-Cr-Zr	around 80%	iron, nickel, chrome and their alloys
03 (equivalent to RWMA-3)	Cu-Ni-Be	around 50%	phosphor bronze, brass
00	pure Mo	around 31%	tinned copper wire, solder plating copper wire
11 (equivalent to RWMA-11)	Cu (30%)-W (70%)	around 46%	noble metal
13 (equivalent to RWMA-13)	pure W	around 32%	copper
20	Cu-Al2O3	around 80%	Battery Tab

RWMA stands for The Resistance Welding Manufacturing Alliance. IACS stands for International Annealed Copper Standard.

Example : EH - 250 - 02
Shape Dimension Material

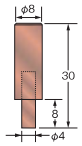
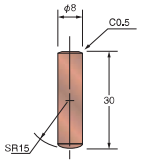
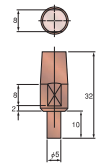
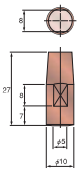
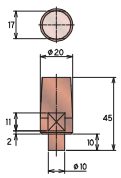
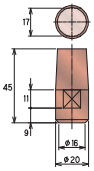
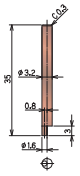
■ Shape of Electrode

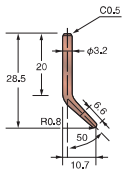
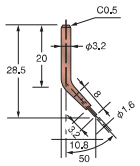
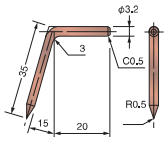
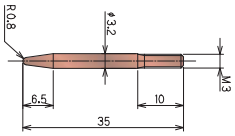
Electrode Number	Shape	Applicable Weld Head
EH-062-02A		NA-121 NA-141
EH-125-02A EH-125-03 EH-125-20		NA-121 NA-122 NA-123 NA-141 NA-142 NA-143 NA-60A
EH-125-00C EH-125-11A EH-125-13C		
CC Alloy (3.2ϕ)		
EP-711-00F EP-711-02F		NA-131 NA-132 NA-141 NA-142
EP-406-00F EP-406-02FA		
Molybdenum Square Bar		

Electrode Number	Shape	Applicable Weld Head
EH-250-02A EH-250-03		NA-122 NA-123 NA-124 NA-142 NA-143 NA-60A NA-43
EH-250-00C EH-250-11A EH-250-13C		
EO-250-02A EO-250-03		
EO-250-00B EO-250-11A EO-250-13C		
EH-250-02S		
EO-250-00SB EH-250-13S		
CC Alloy (6.4ϕ)		

Example : EH - 250 - 02
Shape Dimension Material

■ Shape of Electrode

Electrode Number	Shape	Applicable Weld Head
EH-80-00		NA-124
EH-60C		
EH-F-00		NA-125
EH-F-02		
EH-200-00A		NA-126
EH-200-02A		
EH-125-02E EH-125-20E		NA-141 NA-142 NA-143

Electrode Number	Shape	Applicable Weld Head
EL-125-02A EL-125-03		NA-54A
EL-125-00B EL-125-11A EL-125-13A		
EL-54LA		NA-54LA
EH-57A-02A		NA-57A

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