



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
		1	1	3-1/4	322-0852-44
2		1	3-1/2	322-0856-94	
3/4	4 RW	3/4	7/8	2	321-1232-23
		3/4	7/8	2-1/2	321-1240-23
		2	7/8	3-1/2	321-1256-93
	5 RW	1	1	2-3/4	322-1244-44
		1	1	3	322-1248-44
		2	1	3-1/2	322-1256-94
1	4 RW	3/4	7/8	2-1/4	321-1636-23
		3/4	7/8	2-3/4	321-1644-23
		1-3/4	7/8	3-1/4	321-1652-83
		3/4	7/8	3-1/2	321-1656-23
	5 RW	1	1	2-3/4	322-1644-44
		1	1	3	322-1648-44
		1	1	3-1/2	322-1656-44
		1-3/4	1	3-1/2	322-1656-84
1-1/4	4 RW	3/4	7/8	2-1/2	321-2040-23
		3/4	7/8	3	321-2048-23
		1-1/2	7/8	3	321-2048-73
	5 RW	1	1	2-3/4	322-2044-44
		1	1	3-1/4	322-2052-44
		1	1	3-1/2	322-2056-44
		1-1/2	1	3-1/2	322-2056-74
		1-3/4	1	3-1/2	322-2056-84
1-1/2	5 RW	1	1	2-3/4	322-2444-44
		1-1/4	1	3	322-2448-64
1-3/4	5 RW	1	1	2-3/4	322-2844-44
		1-1/4	1	3	322-2848-64

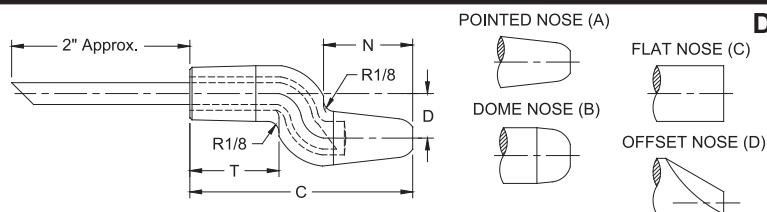
CMW double bend electrodes are cold formed from full hard straight electrodes, and have properties superior to those obtainable by casting or hot forging methods. Cooling tubes, unless otherwise specified are bent in place to provide coolant flow near the welding face as in the case of straight electrodes. 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.

A technical diagram of a 90-degree elbow. The elbow is shown in profile, with dashed lines indicating the internal flow path. The dimensions are labeled as follows:  $T$  is the thickness of the elbow wall;  $N$  is the radius of the elbow; and  $C$  is the center-to-center distance between the two pipe sections. A dimension of 2" APPROX. is shown for the length of the straight section of the pipe before the elbow.

Bent dimensions are for reference only



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

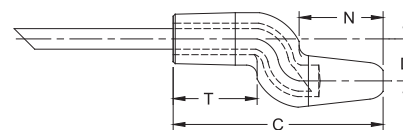


## DOUBLE BEND ELECTRODE CODING SYSTEM

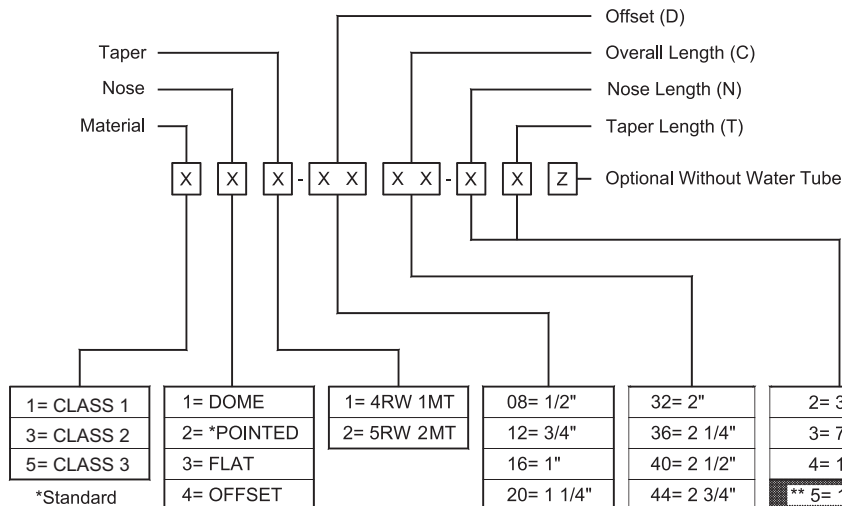
EXAMPLE:

322-0840-44

1" TAPER LENGTH (T)  
1" NOSE LENGTH (N)  
2 1/2" OVERALL LENGTH (C)  
1/2" OFFSET (D)  
5RW TAPER  
POINTED NOSE  
RWMA CLASS 2 MATERIAL



BENT DIMENSIONS REFERENCE ONLY



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

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

32= 2"	2= 3/4"
36= 2 1/4"	3= 7/8"
40= 2 1/2"	4= 1"
44= 2 3/4"	5= 1 1/8"
48= 3"	6= 1 1/4"
52= 3 1/4"	7= 1 1/2"
56= 3 1/2"	8= 1 3/4"
60= 3 3/4"	9= 2"

\*\*May not be a stock item

Standard 4RW nose  
length = 3/4"

Standard 4RW taper  
length = 7/8"

Standard 5RW nose  
& taper length = 1"