

# ARCTEC® 88 GOUGING & CHAMFERING



## GENERAL CHARACTERISTICS:

ARCTEC® 88 is a grooving, chamfering, cutting and gouging electrode used without compressed air or oxygen. It is a very fast and efficient metal working tool and can be used on all ferrous and nonferrous metals including: manganese steel, cast iron, stainless steel and aluminum. The electrode performs well on both DC and AC current and can be used in all positions. Surfaces are left clean and free of scale ready for welding and ordinarily require no further grinding or other preparation.

## APPLICATIONS:

ARCTEC® 88 is designed for use in joint preparation on cast iron or to vee out cracks, remove old and broken welds, hard surfacing deposits, frozen bushings and for cutting metals that cannot be flame cut.

## PROCEDURE:

Pointing the electrode in the direction of travel at an angle of approximately 10° to 20° off the work piece, proceed in a sawing motion, pushing the molten metal ahead of the groove. It is recommended that the groove be no deeper than 1/2 the diameter of the electrode and no wider than the outside diameter of the electrode. If a wider groove is required use a series of grooves.

## OPERATING PARAMETERS:

WELDING PROCESS: SMAW

POLARITY: DC Straight or AC

## Recommended Amperage:

Diameter	2.50mm 3/32"	3.25mm 1/8"	4.0mm 5/32"	5.0mm 3/16"
Amperage	150-250	250-350	300-400	350-450

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