



a quality welding alloy

ARCtec® DC ARC GOUGING ELECTRODES

APPLICATION:

Copper coated gouging carbon electrodes are designed for use in the air arc cutting process with the use of a DC power source. Permits rapid removal and cutting of various metals, such as carbon, low alloy and stainless steel, cast iron, copper and nickel alloys. Also suitable for welding joint preparation.

WELDING PROCEDURE:

The electrode should be gripped so that a maximum of 6" (150mm) extends from the electrode holder. In air gouging it is important that the air stream be directed at the arc in a manner that effectively blows the molten metal away from the kerf. The arc must be maintained at a length sufficient to permit this action.

RECOMMENDED OPERATING PARAMETERS:

Welding Process: AAC DC Reverse Polarity Air Pressure: 80-100 psi (560-700kPa)			
DIAMETER		AMPERAGE:	
MM	INCH	MIN.	MAX.
4.0	5/32	90	150
5.0	3/16	150	200
6.0	1/4	200	400
8.0	5/16	250	450
10.0	3/8	350	600
12.7	1/2	600	1000
16.0	5/8	800	1200
19.0	3/4	1200	1600
5.0 X 16.0	3/16 X 5/8		500 Max.

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Subject to change without notice

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