

CHAMFERTRODE

CUTTING, HEATING, BEVELING, AND PIERCING ELECTRODES FOR ALL METALS

AC OR DC STRAIGHT (ELECTRODE-)

GENERAL CHARACTERISTICS:

High speed cutting electrode for use with all standard arc welding equipment. No special skills, oxygen tanks, or air compressors are required. The special coating protects the electrode from overheating.

APPLICATIONS:

For cutting, beveling, and piercing of cast iron, stainless steel, manganese steel, carbon steel, malleable iron, aluminum, copper, bronze, nickel and nickel alloys. Ideal for cleaning out defects and removing rivets. Heat metals in seconds.

TECHNICAL DATA:

Current AC or DC straight polarity (electrode-)

Metal Thickness Recommended Electrode Size

1/8" to 1" (3.25 to 25mm) 1/8" (3.25 mm)

1/4" to 1 1/2" (6.0 to 38mm) 5/32" (4.0 mm)

Amperage 140-350 175-400

(in) 1/8" 5/32"

(mm) 3.25 4.0

PROCEDURE:

For the fastest and cleanest cuts use DC straight polarity (electrode -). When piercing, hold electrode vertical to work, strike arc, and push in and out until hole has been formed. When cutting sheets or plates, start at the edge, strike arc, and use electrode like a saw; push and pull with the electrode at a 45° angle to the work piece. When using to heat with maintain long arc length and use rapid whipping motion.

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