

CHANFER - ROD

TOOL ELECTRODE FOR CHAMFERING, GOUGING AND CUTTING; TO PREPARE JOINTS BEFORE WELDING.
THIS ELECTRODE WORKS ON ALL KINDS OF METAL

CLASSIFICATION A.W.S: N/A

IDENTIFICATION: REDDISH BROWN COATING

APPLICATIONS: Chanfer, is the right electrode for gouging and chamfering all kinds of metals--specially those which cannot be cut with a gas torch as cast iron, stainless steel, some kinds of hard claddings and non ferrous metals. It is widely used for these operations since it makes the work easier and the resulting surface is perfectly clean and ready to accept weld metal.

CHARACTERISTICS: This electrode has been specially designed with a flux thicker than the usual standard found in cutting electrodes. The flux is useful for the following:

- 1.- It protects the electrode core wire from excess heat due to the high amperage used.
- 2.- It releases a greater gas volume which helps to remove more material per electrode.
- 3.- Any standard DC or AC cutting unit with enough capacity for this kind of work can handle this electrode. As a result you need not use expensive gases or compressed air to do the work.

PROCEDURE: By using reverse polarity DC you can get cleaner and faster gouging. It is possible to use AC cutting units, too. Keep the electrode at an angle between 7 and 15 degrees to the work area.

Point the electrode in the direction you are cutting. Let the electrode contact the part to be cut and move on as fast as possible. When a deeper cut is necessary, repeat the procedure until the desired depth is achieved.

POSITIONS:	ALL
CURRENT:	DC REVERSE POLARITY or AC

FILLER METAL CHEMICAL ANALYSIS %	SIZES	AMPERAGE
NOT APPLICABLE	3.25 MM - 1/8"	150-200
	4.0 mm - 5/32"	200-280
	5.0 mm - 3/16"	275-350