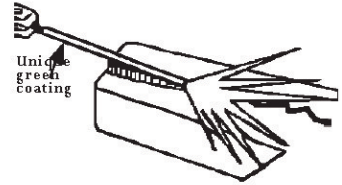


**Chamfering/cutting electrode
with 25% more arc blast force**



- ❑ **Reactionary black colored coating creates the highest levels of arc blast.**
- ❑ **Special coating elements form an electrically conductive "cup" for ease of restrike.**
- ❑ **Designed specifically for small AC welding machines.**

**INTERNATIONAL
SPECIFICATIONS**

**NONE APPLICABLE TO THIS
PROPRIETARY PRODUCT**

APPLICATIONS:

Can gouge, bevel or cut all metals including stainless steels, aluminums and copper. Excellent for the removal of stainless steel joints and overlays. No oxygen is required.

ALL WELD METAL ANALYSIS (Typical Weight %):

These electrodes do not make deposits

FLUX COLOR:

Black

RECOMMENDED CURRENT: DC Straight (-) or AC

RECOMMENDED AMPERAGE SETTINGS:

Diameter (mm)	3/32 (2.5)	1/8(3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	100	170	220	300
Maximum Amperage	170	250	330	450

WELDING POSITIONS: Flat, Vertical up, Vertical down, Horizontal, Overhead

GOUGING RATES:

Diameter (mm)	Length (mm)	Arc Time of Gouging SEC/in (mm)	Weight of Gouged Metal g/min	Amperage Setting
3/32 (2.5)	14" (350)	1.6 (.064)	35	160
1/8 (3.2)	14" (350)	1.2 (.048)	100	230
5/32 (4.0)	14" (350)	1. (.04)	120	310
3/16 (5.0)	14" (350)	.8 (.032)	180	420

WELDING TECHNIQUES:

Hold electrode at a 10° angle above workpiece. Initiate arc and move forward in a straight or back and forth motion. For cutting use a "sawing action" technique.