

CAG 9905

HIGH EFFICIENCY CUTTING AND GOUGING ELECTRODE

KEY FEATURES:

- Forceful penetrating arc with low smoke
- Retains arc force till the end of electrode
- Narrow kerfs, smooth & clean cuts
- Molten and blown away material can be removed easily
- Being SMAW electrode, compressed air is not relevant

TYPICAL APPLICATIONS:

- Cutting and piercing of mild & low alloyed steels, cast iron
- Excellent for burning rivets
- Dismantling work at sites, Removal of defective welds and rivets
- For cutting out flashers, risers and unwanted metal in foundry castings
- Back gouging of root runs
- For chamfering, gouging and making grooves in all conductive metals
- For bevelling cracks in machine frames without dismantling
- Cutting of metal parts on building sites

PROCEDURE:


For Cutting:

After striking the arc, swing the arc back and forth as in sawing. Maintain the motion and at the same time dig the arc deeper and deeper into the metal. For piercing holes, push the arc in and out until the metal is pierced.

For Gouging:

The electrode is inclined to the surface at a 35° angle. The arc is pushed deeper and forward to drive the molten metal onwards. For deeper groove, repeat procedure in stages until the required depth is reached.

PARAMETERS - PACKING DATA:

Ø x L, mm	Cutting Amperage, A	Gouging Amperage, A	
4.0 x 450	160-250	140-220	 AC/DCEP/DCEN
5.0 x 450	170-300	150-280	

Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kg each.