



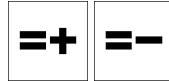
HILCO Carbon gouging rods

Air carbon arc cutting (CAC-A) rods - cutting & gouging

Coating type:

Copper coated

Current:



Arc voltage: 35-55V - power source needs OCV \geq 60V

Carbon gouging rods are copper-coated air carbon arc cutting rods made from a mixture of graphite and pure carbon. Typical applications can be found in every field of metalworking, in foundries, steel constructions, shipbuilding, repair & maintenance. Carbon gouging rods are used for weld edge preparations, back-gouging in multipass welding, removing unsatisfactory welds, bolt and wire ends, spatter removal, all kinds of cutting.

Base materials to be welded:

- Carbon, low-alloyed steels
- Stainless steels
- Aluminium
- Nickel alloys
- Cast iron
- Copper alloys
- Magnesium

Applications:

- All industries related to welding

Process description, recommendations for usage

Carbon gouging rods remove molten metal with a jet of air. The intense heat of an arc between the carbon-graphite electrode and a workpiece melts a portion of the metal, while simultaneously a jet of air is passed through the arc to blow away the molten metal. The process (Air carbon arc cutting - CAC-A) is used for cutting and gouging, and it can be done manually or mechanized. Carbon steel, stainless steel, copper alloys, cast irons, aluminium, magnesium and nickel alloys can all be cut with Carbon gouging rods. The process requires an electrode holder, cutting electrodes, a power source and an air supply. Manual electrode holders are similar to shielded metal arc electrode holders (stick electrode holders). The electrode is held in a rotatable head containing air orifices. A valve is provided to turn the air on and off. Carbon gouging rods are round, pointed and copper coated. They are intended to use at DC current.

Base material	Electrode	Current	Remarks
Carbon, low-alloyed steels	DC	= +	-
Stainless steels	DC	= +	-
Aluminium	DC	= +	Extend electrode no more than 10 cm.
Nickel alloys	DC	= -	-
Cast iron	DC	= -	At middle of electrode current range
	DC	= +	At maximum current only
Copper alloys	DC	= +	At maximum current only
Magnesium	DC	= +	Clean surface before welding

Packaging and welding data:

Dia. mm.	Length mm.	Current A
6,3	305	200-400
8,0	305	250-450
10,0	305	350-600
12,0	305	450-800