



212 SP AC/DC-

CUTTING

DESCRIPTION

Electrode specially designed for easy **gouging, cutting and piercing** of any ferrous and non-ferrous metals.

CHARACTERISTICS

- **Less noise and smoke than compressed air processes**
- No adherence between the molten metal and the base metal
- Excellent on AC power supply due to the presence of oxides in the coating
- Easy striking and restriking (OCV = 60 V)
- Superior efficiency, speed and use in position
- Non-conductive coating

TYPICAL APPLICATIONS

Ideal for removing defective or old weld beads, preparing workpieces, opening grooves prior to welding, gouging cracks, piercing holes, eliminating irregularities on all metals, including cast irons, stainless steels, copper, brass, aluminum, etc.

PROCEDURE

Place electrode tip on metal and push rapidly back and forth in a sawing motion while holding almost flat and in direct contact with the work-piece. For deeper grooves, repeat the procedure.

WELDING PARAMETERS

Diameter:	5.0 mm (3/16")	4.0 mm (5/32")	3.2 mm (1/8")
Amperage:	290 – 400 A	235 – 305 A	165 – 245 A

Rév.: 21_08

Specialized welding alloys and technology. For technical assistance or for ordering :