



Gouging Die Holder

An excellent electrode for gouging and beveling and removable of weld defects for ferrous or non-ferrous metal

Typical Applications:

Gouging cast iron & other metals, removal of old welds and rivets.

Outstanding Features:

- No oxygen, other gas or special electrode holder.
- Exothermic coating that concentrates arc force.
- Further finishing not necessary.

Recommendation:

Where chamfering, grooving or gouging is necessary, without supplementary gases and extensive equipment. For preparing sections prior to welding, gouging out old or defective weld metal, removing flash and risers. Ideal to remove most unwanted metal prior to final machining. Can be used for ferrous or non-ferrous metals. A highly heat resisting electrode whose special exothermic coating concentrates the force of the arc right at the point of application. A finishing operation is rarely necessary.

Procedure:

Insert Eutec-ChamferTrode electrode into a conventional electrode holder. Use ac or dc reverse polarity. Point electrode in direction of travel, at an angle of not more than 30° with the plane of the work. Strike arc. Push electrode along the line of cut, quickly for a shallow chamfer, more slowly, or with a weaving motion for a deeper groove. Utilizing the heat and force of the highly concentrated arc, push the molten metal ahead and away. If deeper gouge is needed, repeat procedure.

Recommended Amperages:

Size (mm)	Amperage
3.15	250 - 325
4.00	300 - 400
5.00	350 - 450