

SUNALLOY 009

Special electrode for gouging all conducting metals



DESCRIPTION

Special electrode with high blowing effect and producing hot exothermic penetrating arc. The molten metal is blown away quickly and provides good visibility. The cut is smooth and molten and blown away material can be removed easily. Does not damage the metal structure.

ELECTRODE FOR GROOVING WITHOUT OXYGEN.

APPLICATIONS

For chamfering, gouging and making grooves in all industrial metals. For removing defective welds and rivets without using oxy-acetylene and compressed air: Removing flashers and risers in foundry castings. For bevelling cracks in machine frames without dismantling. A prerequisite for welding. Cutting of metal parts on building sites.

PROCEDURE

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

TECHNICAL DATA & WELDING PARAMETERS

Size (diameter)/length (mm)	: 2.50 x 350	3.15 x 350	4.00 x 350	5.00 x 350
Current (amps)	: 150 - 200	200 -350	250 - 400	300-500
Current	: AC/DC (+)			