

# SUNALLOY 109

Electrode for cutting without oxygen



## DESCRIPTION

Coated electrode for cutting, gouging and grooving metals and alloys, including mild steels, stainless steels, cast iron, nickel, copper and aluminum alloys. A high efficiency electrode that performs with all types of welding machines. The forceful arc-blow is produced by the special coating which eliminates the need for compressed air or oxygen. The size and depth of the groove can be easily controlled. Slag practically falls off, cut is smooth, uniform and can be done in all positions.

## PROPERTIES

Special electrode with an exothermic coating which gives a stable arc during the cutting or piercing process. The kerfs are clean and narrow. Suitable for all positions and all conducting metals. Produces negligible slag.

## APPLICATIONS

Preparation of weld grooves and plate edges back gouging for welding Removing defective weld and parent metal. Piercing holes, Cutting and piercing of steel, cast iron, copper materials, aluminium. Excellent for burning rivets, dismantling work at site and for cutting out unwanted metal in foundry castings. Oxyacetylene or compressed air need not be used.

## PROCEDURE

Mark areas to be grooved clearly. Select highest suitable amperage. Hold electrode at a low angle to the work piece (approx.20°). Point the electrode in the direction of the desired groove, strike the arc and push the electrode as fast as the metal is removed. Maintain as short arc as possible. The maximum depth of the groove in a single pass should not be greater than the diameter of the core wire. For deep grooves use multiple passes. For hole cutting, strike arc with electrode at right angle to work and pump up and down until work is pierced.

## TECHNICAL DATA & WELDING PARAMETERS

Size (diameter)/length (mm)	: 3.15 x 350	4.00 x 350	5.00 x 350
Current (amps)	: 140 - 300	250 - 300	250 - 300
Current	: AC/DC (+)		