Gouging or groove preparation use

GOUGING CARBON

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Product Features:

 High heat arc produced between gouging carbon rod and workpiece to melt metal and blown off by high pressure air to get good gouging groove or cutting surface.

Applications:

 Back gouging of first side root pass(es) when welding with double sided joint. To remove inside defects for welding repair. Suitable for cutting of cast iron, high carbon steel, stainless steel, high alloy steel and non metallic materials when those workpieces are difficult cut by ordinary oxyacetylene cutting process.

GOUGING CARBONS [DC] (For gouging, cutting and boring)								
	Size		Current	Metal	Groove		Cutting	Boring
Nodel No.	(m/m)	(inch)	Range (amp)	Removal (g/cm)	Width(m m)	Depth(mm)	Width (m/m)	Dia.(m/m)
40GSS	4.0x 305	5/32x12	150~200	Approx 10	6~8	3 ~ 4	Approx 7	Approx 8
50GSS	5.0x305	3/16x12	150~200	Approx 12	7~9	3 ~ 5	Approx 8	Approx 8
65GSS	6.5x305	1/4x12	200~250	Approx 18	9~11	4 ~ 6	Approx 9	Approx 10
80GSS	8.0x305	5/16x12	250~350	Approx 33	11~13	6~9	Approx 11	Approx 12
95GSS	9.5x305	3/8x12	350~450	Approx 49	13~15	8 ~ 12	Approx 13	Approx 14
110GSS	11.0x305	7/16x12	450~600	Approx 65	14~16	10 ~13	Approx 14	Approx 15



Note:

- 1. Keep the angle between work and gouging rod about at 10°.
- 2. The arc (produced by the tip of gouging rod to touch the work groove) heat and melt the base metal.
- 3. The melting metal is blown out by pressurized air to form a gouged groove.

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