

GOUGING CARBON

JOINT TYPE

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.

JOINT-TYPE CARBONS [DC] (For uses of cleaning surface of casting)

Model No.	Size (m/m)	(inch)	Current Range(amp)	Metal Removal (g/cm)
130J	13.0 x 355	½ x 14	700 ~ 900	Approx. 89
130JL	13.0 x 430	½ x 17	700 ~ 900	Approx. 89
160J	16.0 x 355	5/8 x 14	1000 ~ 1200	Approx. 105
160JL	16.0 x 430	5/8 x 17	1000 ~ 1200	Approx. 105
190J	19.0 x 355	¾ x 14	1200 ~ 1400	Approx. 148
190JL	19.0 x 430	¾ x 17	1200 ~ 1400	Approx. 148

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.