

Gouging or groove preparation use



Product Features:

- High heat concentrated arc and strong spraying gas produced between electrode rod and workpiece to get good groove appearance.
- Easy manuability by using ordinary power source and welding torch.
- No cementation occurred.

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.

Size(mm) & recommended welding parameters (A)[AC]

Diameter / Length	3.2/350	4.0/400	5.0/450
Flat position	150~180	230~280	280~330

- © Note: 1. Keep the angle between work and gouging electrode about at 10°.
2. The arc (produced by the tip of gouging electrode to touch the work groove) heat and melt the base metal.
3. The melting metal is blown out by gas produced from electrode to form a gouged groove.
4. Baking temperature range is 70~100°C for 30~60 minutes before use.

GOUGING CARBON

GOUGING CARBON

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.

Size(mm) & recommended welding parameters (A)[AC]

Diameter / Length	4.0/305	5.0/305	6.5/305	8.0/305
Flat position	150~250	200~300	200~350	300~450
Groove Width	6~8	7~9	9~11	10~12
Groove Depth	3~4	3~5	4~6	5~7
Metal removed volume (g/cm)	6	10	15	24

- © 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.