

Gouging Carbons

COPPER COATED ARC AIR CUTTING ELECTRODES

DESCRIPTION

Air carbon arc cutting, previously known as arc air cutting is an arc cutting process where metal is cut and melted by the heat of a carbon arc. Molten metal is then removed by a blast of compressed air. A sharpened **WELDARC® Gouging Carbon DC** electrode is drawn along the metal as an arc forms which melts the metal. A compressed air jet is then used to blow away the molten material. This process can be dangerous as the molten material can be blown substantial distances while also producing excessive noise levels (see Safety Note below).

FEATURES

- General purpose cutting and gouging of most ferrous & non-ferrous metals
- High quality copper casing ensures consistent conductivity while preventing side burn through of electrode
- Made of premium compacted carbon/graphite
- For use with K4000 style gouging torches
- 305mm electrode length

APPLICATIONS

This process is useful for cutting a variety of materials, but it is most often used for cutting and gouging aluminium, copper, iron, magnesium, and carbon/stainless steels. Because the metal is blown away by the air jet, it does not need to be oxidised. This process differs from plasma cutting operations because in air carbon cutting, an open, or un-constricted, arc is used, and the arc operates separately from the air jet. Air pressures for the jet usually vary from 60 to 100 psi. The carbon electrode can be worn away by oxidation from heat build-up. This can be reduced by coating the carbon electrodes in copper.

OPERATING DATA

Polarity: Carbon DC

Electrode Diameter	4.8mm	6.5mm	8.0mm	9.5mm
Current Range (Amps)	200-250	200-350	350-450	450-600

SAFETY NOTE:

Ensure proper personal protective gear from high heat and molten metal in addition to Shade Level 14 eye protection and high quality ear protection.