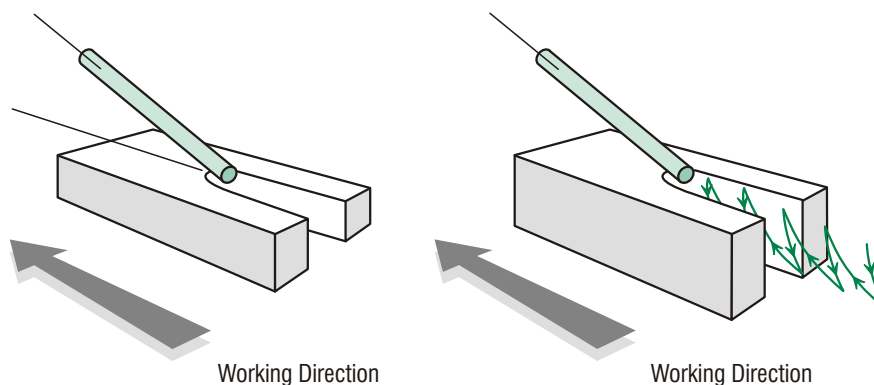


Coated Electrode for Cutting and Gouging

General Description

AS Kesme is an ideal electrode for cutting and piercing of all types of steel, cast iron and non-ferrous metal. It is a general purpose electrode especially used before and during repair and maintenance welding applications.



Approvals

GOST, SEPRO, TSEK

Applications

Due to the physical properties of the coating material, core wire has a higher melting rate than the coating material. Therefore, 3 to 5 mm crater formation occurs at the tip of the electrode. Particularly in cutting and piercing applications, this crater formation enables the operation of the electrode penetrating into the melting piece without short circuit.

Pieces up to a thickness of 10 mm can be easily cut with this electrode. For thicker pieces (10 mm), electrode should be moved up and down in the direction of material being cut to move away the melted material. In piercing applications, electrode should be perpendicular to the work piece.

It is used for beveling, weld preparation of cracks and for gouging of armour steels, air hardenable steels, stainless steels, cast irons, hard metals, work hardenable and difficult to machine materials. The surface is clean and seldom requires further dressing. Metal removal speed depends on the electrode diameter, ampere selected and to the thickness of the piece. It is recommended to work with a quality power source for best results.

Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : DC (-) ; AC min 50 V

Diameter [mm]	Length [mm]	Current [A]	Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export Box Box Weight [kg]
3.25	450	180 - 210	4750	5.2 / 110	5
3.25	350	180 - 210	3542	4.1 / 115	4
4.00	450	210 - 275	6810	4.8 / 70	5
4.00	350	210 - 275	5196	4.5 / 85	4
5.00	450	250 - 300	9860	5.9 / 60	5
5.00	350	250 - 300	8224	3.7 / 45	4

