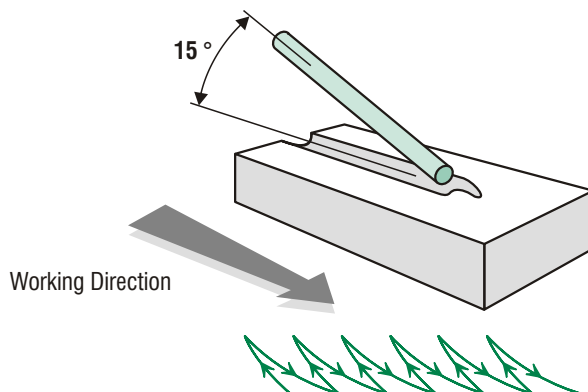


## Coated Electrode for Cutting and Gouging

### General Description

AS Oluk Açma is an ideal electrode for gouging in and joint preparation of all types of steel, cast iron and non-ferrous metal. It is a general purpose electrode especially used before repair and maintenance welding applications.



### Approvals

GOST, SEPRO, TSEK

### Applications

The special coating performs several functions:

- 1 - To form a concentrated powerful arc,
- 2 - To form a stable arc and to reduce the fast melting of the electrode,
- 3 - To produce a strong gas jet to blow away the melted material.

The angle between the electrode and the work piece should be 15°.

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 70 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	350	190 - 220	3560	4.1 / 115	4
4.00	350	220 - 280	5170	4.4 / 85	4
5.00	350	260 - 350	8080	3.6 / 45	4

