

Standard designation --- Chamfering electrode

Approvals ---

Typical applications and characteristics Special-coated electrode for chamfering, grooving and gouging all metals, including all types of ferritic and austenitic steels as well as Cu-alloys, cast steel and grey cast iron.
The electrode produces a high-energy arc which rapidly melts the base material.
CARBO NUT is used for seam preparing, gouging, cutting, piercing holes, eliminating screws, rivets or old seams, chamfering foundry defects or cracks before repair welding, and removing all unserviceable material from oil containing cast iron or corroded metal layers..

Operating temperature ---

Welding instructions CARBO NUT requires a higher amperage than other electrodes of same diameter and coating thickness. Hold the electrode at an angle of abt. 20°, push in direction of travel using a saw-like (forward and back) motion. Incline the work piece, if possible, to enable easy flow-off of the molten metal. Keep uniform contact with the base metal.
CARBO NUT produces a clean and smooth groove. If there is any excess material on the joint it can be easily removed with a deslagging hammer.

Current = - / ~ 50 V

Rebaking 1 h, 120 °C +/- 10 °C (if required)

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg / 1000	kg / packet	kg / carton
2,5 x 350	100 - 120	181	724	22,1	4.0	16.0
3,2 x 350	130 - 180	107	428	37,4	4.0	16.0
4,0 x 350	170 - 230	71	282	56,7	4.0	16.0
5,0 x 450	230 - 300	44	176	113,9	5.0	20.0

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