



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE

1364

**Grey Low Smoke Chamfering/
Cutting**

INTERNATIONAL CLASSIFICATIONS

**NONE APPLICABLE TO THIS
PROPRIETARY PRODUCT**

FEATURES & APPLICATIONS

Can gouge, bevel or cut all metals including stainless steels, aluminums and copper. Excellent for the removal of stainless steel joints and overlays. No oxygen is required.

Chamfering/cutting electrode with 25% more arc blast force

- A grey flux coated electrode for extra-low smoke and piercing.
- Special coating elements form an electrically conductive "cup" for ease of restrike.
- Designed specifically for small AC welding machines.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Color: Grey

These electrodes do not make deposits

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Straight (-) or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	100	170	220	300
Maximum Amperage	170	250	330	450

Welding Techniques: Hold electrode at a 10° angle above workpiece. Initiate arc and move forward in a straight or back and forth motion. For cutting use a "sawing action" technique.

Welding Positions: Flat, Vertical up, Vertical down, Horizontal, Overhead

Gouging Rates:

Diameter (mm)	Length (mm)	Arc Time of Gouging SEC/in (mm)	Weight of Gouged Metal g/min	Amperage Setting
3/32 (2.5)	14" (350)	1.6 (.064)	35	160
1/8 (3.2)	14" (350)	1.2 (.048)	100	230
5/32 (4.0)	14" (350)	1.0 (.04)	120	310
3/16 (5.0)	14" (350)	.8 (.032)	180	420

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Length (mm)	14" (350)	14" (350)	14" (350)	14" (350)
Electrodes / lb	24	14	9	8

Electrodes / kg	53	31	20	18
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