Arcair ELECTRODE TYPES

A THERMADYNE Company

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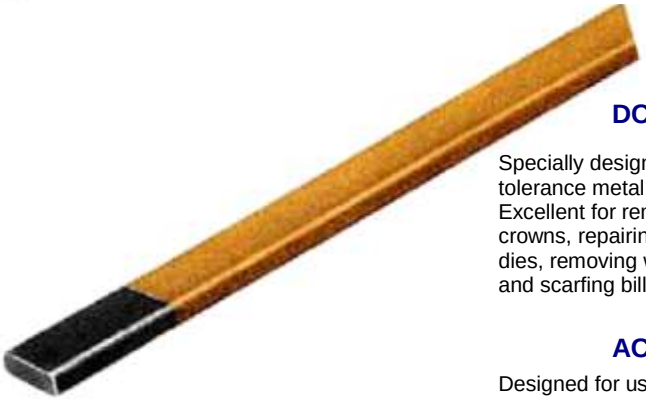
DC COPPERCLAD POINTED ELECTRODES

A standard all purpose gouging electrode. Controlled copper coating improves conductivity providing more efficient, cooler, operation and helps maintain electrode diameter at the point of the arc.

Electrode Size (inches)	Part Number	UNIT PRICE
1/8 X 12	22-023-003	$60.00 PER PK OF 100
5/32 X 12	22-983-003	$30.00 PER PK OF 50
3/16 X 12	22-033-003	$30.00 PER PK OF 50
1/4 X 12	22-043-003	30.50 PER PK OF 50
5/16 X 12	22-053-003	$31.50 PER PK OF 50
3/8 X 12	22-063-003	$42.00 PER PK OF 50
1/2 X 14	22-082-003	$94.50 PER PK OF 50



DC COPPERCLAD FLAT ELECTRODES

Specially designed for close tolerance metal removal. Excellent for removing weld crowns, repairing or making dies, removing welded dogs and scarfing billets.

Electrode Size (inches)	Part Number	UNIT PRICE
3/8 X 5/32 X 12	35-099-003	$88.00 PER PK OF 50
5/8 X 3/16 X 12	35-033-003	$141.00 PER PK OF 50

AC POINTED COPPERCLAD ELECTRODES

Designed for use with an AC power supply
Rare earth material is added to stabilize the arc, improving the operating characteristics.

ELECTRICAL REQUIREMENTS

Electrode Size Inch	mm	Minimum Amperage	Maximum Amperage	Electrode size Inch	mm	Minimum Amperage	Maximum Amperage
1/8	3	60	90	3/8	10	450	600
5/32	4	90	150	1/2	13	800	1000
3/16	5	200	250	5/8	16	1000	1250
1/4	6	300	400	3/4	1 9	1250	1600
5/16	8	350	450	1	2 5	1600	2200

ELECTRODES MATCHED TO TORCHES

The table below shows what electrode diameter will work in each torch

Dia. (inches)	K4000	K2000
1/8		X
5/32	X	X
3/16	X	X
1/4	X	X
5/16	X	
3/8	X	
1/2	X	
5/8		
3/4		
1		
3/8 Flat	X	X
5/8 Flat	X	

Tri-Arc
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Arcair® gouging electrodes are designed especially for the air carbon-arc metal removal process which melts metal with an electric arc, then blows it away with a jet of ordinary shop compressed air. Arcair electrodes contain a precisely formulated blend of carbon and graphite that produces the most efficient metal removal performance. They offer excellent arc stability, superior metal removal rates, resistance to breakage, heat and oxidation, uniform diameter and clean slag-free grooves.
Available in a number of types and sizes, Arcair electrodes meet a very broad range of application requirements. They are designed for use in an Arcair torch connected to an ordinary welding power supply and compressed air source. The welding power and amperage required is dependent on the electrode diameter being used. Its size should be slightly less than the width and depth of cut or groove desired. Very deep grooves or cuts require multi-pass procedures.
Arcair electrodes enable the user to take complete advantage of the electric arc's unique concentration of heat for fast cutting and gouging of most metals - including carbon and ductile irons, copper, aluminum and other high strength and high temperature alloys.

HELPFUL HINTS

When calculating electrode consumption the following information could be helpful:

For every inch of carbon consumed the user will get 8" of groove when making a gouge that is equal in depth to the diameter of the carbon.

The gouge width will be about 1/8" wider than the diameter of the carbon electrode being used.

When using POINTED gouging carbons, the user will have about 3 inches of stub loss.