



HI-ALLOY CHAMFER ARC

AIRLESS CHAMFERING, VEEING, & BEVELING ELECTRODE

DESCRIPTION: Hi-Alloy Chamfer Arc was designed for all position chamfering, veeing, gouging, and beveling of all metals except magnesium. This product may be used with any welding machine capable of delivering the required amperage. No special electrode holder, oxygen, or compressed air is required for use of this product. A special flux provides the forceful arc drive that quickly and easily pushes away slag and molten metal leaving clean, smooth, gouged or beveled metal ready for finishing or welding. Even though the process is quite different from welding, with a little practice the technique is easily mastered.

TYPICAL APPLICATIONS: Removing old weld metal, removing fatigued base metal prior to making repairs, gouging out cracks in cast iron parts prior to repair welding, removing excess metal prior to machining, removing sharp edges, beveling, gouging, veeing, and chamfering of steels, stainless steels, cast iron, aluminum, and various copper based alloys.

PROCEDURES: Make sure there are no other workers or combustible materials in the area where dropping or blowing molten metal might land. Position the electrode pointing straight out the end of the holder so you can push it forward. Set the machine at appropriate amperage for the selected electrode diameter. Strike the arc and quickly lower the electrode nearly parallel to the work piece (a 10° to 15° angle), maintain slight downward pressure on the electrode tip. Push the electrode rapidly forward for shallow cuts. Slow down or use multiple passes for deeper grooves.

AVAILABLE SIZES: 3/32 1/8 5/32

AMPERAGE RANGES: 100 - 170 170 - 250 220 - 320

POLARITY: DC Straight or AC