



TEXAS * PENNSYLVANIA * NORTH CAROLINA
<http://hi-alloy.com>

HI-ALLOY CUT ARC

AIRLESS METAL CUTTING AND PIERCING ELECTRODE

DESCRIPTION: Hi-Alloy Cut Arc was designed for cutting and piercing holes in metals which are not cuttable by the standard oxy-acetylene method. These metals include stainless steels, cast irons, aluminum, nickel alloys and copper base metals. The special flux coating burns slower than the core wire concentrating the arc at the electrode tip. Using this electrode requires no oxygen, compressed air, or other special equipment, only a standard welding machine capable of delivering the required amperage. Anyone who is familiar with standard stick welding practices can easily adapt to using this product with a little practice.

TYPICAL APPLICATIONS: Cutting up scrap metals, trimming pieces that are a little too big, cutting reinforcing bars, enlarging existing holes, removing rivets and frozen bolts.

PROCEDURES: Make sure there are no combustible materials in the area below the work piece. Set the machine at appropriate amperage for the selected electrode diameter. To cut, adjust the work piece and the electrode position for use similar to using a hand saw. Strike the arc on the edge of the work piece, maintain light contact and work the electrode up and down through the metal using a sawing motion. To pierce holes, hold the electrode at a 90° angle to the work piece, strike the arc and hold light downward pressure on the electrode. Pull it straight back out immediately after penetration. To enlarge the hole, move the electrode in a circular motion.

AVAILABLE SIZES: 1/8 5/32

AMPERAGE RANGES: 150 - 350 190 - 400

POLARITY: DC Straight or AC