



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

HI-ALLOY METAL MOVER

FOR AIRLESS CUTTING, PIERCING, AND GOUGING

DESCRIPTION: Hi-Alloy Metal Mover was designed to provide the ultimate in airless cutting, piercing, and gouging on all metals including stainless steels, aluminums, and copper alloys. Its special elemental coating allows for use on small AC machines, excellent restrike capability, greater arc force, and less smoke than many other gouging electrodes.

TYPICAL APPLICATIONS: Removal of cracked welds, removal of frozen nuts, preparing cast irons for welding, and piercing holes, cutting and gouging of all metals.

PROCEDURES: Make sure there are no other workers or combustible materials in the areas where dropping or blowing molten metal might land. Set the machine at the appropriate amperage for the selected electrode. When piercing holes, hold the electrode perpendicular to the work surface and apply slight downward pressure. Selection of electrode diameter and amperage range will control hole size. When gouging, position the electrode pointing straight out the end of the holder so you so you can push it forward. Strike the arc and quickly lower the electrode to nearly parallel with the work surface (a 10° - 15° angle), maintain slight downward pressure on the electrode tip and push forward rapidly or use a slight back and forth motion. Make a series of shallow gouges rather than one deep gouge. To cut, adjust the work piece and the electrode position for use similar to that of a hand wood cutting saw. Strike the arc on the edge of the work piece, maintain light contact and work the electrode up and down through the metal with a sawing motion.

AVAILABLE SIZES:	3/32	1/8	5/32	3/16
AMPERAGE RANGES:	100-170	170-250	220-330	300-450
POLARITY:	DC Straight or AC			