



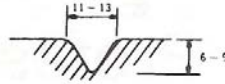
GOUGING CARBONS

Specifications

GOUGING CARBONS [DC]

(For gouging, cutting and boring)

Model	Size		Current Range (amp)	Metal Removal (g/cm)	Groove		Cutting Width (m/m)	Boring Dia. (m/m)
	(m/m)	(inch)			Width (m/m)	Depth (m/m)		
40G	4.0x305	5/32x12	100 ~ 200	Approx. 10	6 ~ 8	3 ~ 4	Approx. 7	Approx. 8
50G	5.0x305	3/16x12	150 ~ 200	" 12	7 ~ 9	3 ~ 5	" 8	" 8
85G	6.5x305	1/4 x12	200 ~ 250	" 18	9 ~ 11	4 ~ 6	" 9	" 10
80G	8.0x305	5/16x12	250 ~ 350	" 33	11 ~ 13	6 ~ 9	" 11	" 12
95G	9.5x305	3/8 x12	350 ~ 450	" 49	13 ~ 15	8 ~ 12	" 13	" 14
110G	11.0x305	7/16x12	450 ~ 600	" 65	14 ~ 16	10 ~ 13	" 14	" 15
80GL	8.0x510	5/16x20	250 ~ 350	" 32	11 ~ 13	6 ~ 9	" 11	" 12
95GL	9.5x510	3/8 x20	350 ~ 450	" 49	12 ~ 15	8 ~ 12	" 13	" 15
110GL	11.0x510	7/16x20	450 ~ 650	" 65	14 ~ 16	10 ~ 13	" 14	" 16



80G
250 ~ 350A

Stable arc and excellent performance efficiency

ELECTRICAL REQUIREMENTS

An ordinary welder is normally used as the power source for Torches. Care should be taken that the welder is of sufficient size to produce the current required. The amperage needed depends upon the diameter of the electrode used (see table below). Minimum-maximum settings are shown. Best results are obtained when maximum amperage is used for each electrode.

Electrode (in.)	5/32	3/16	1/4	5/16	3/8	1/2	5/8	3/4	Flat
Electrode (mm)	4.0	4.8	6.4	7.9	9.5	12.7	15.9	19.0	
Min. Amps.	90	150	200	250	350	600	800	1200	300
Max. Amps.	150	200	400	450	600	1000	1200	1600	500

MATERIALS, ELECTRODES, CURRENT

Material	Electrode	Current	Polarity
Steel or	D.C.	dc	Reverse
Stainless Steel	A.C.	ac	
Iron: Cast, Duc-	D.C.	dc (high amp)	Reverse
tile or Malleable	A.C.	ac or dc	Straight
Copper	A.C.	ac or dc	Straight
Alloys	D.C.	dc	Reverse
Nickel Alloys	A.C.	ac or dc	Straight

AIR REQUIREMENTS

Ordinary Compressed air as supplied by a shop air line or compressor is suitable. Most applications require 80-100 psi air pressure.

Torch Model	AIR				Compressor			
	psi	(kg/cm ²)	CFM	(m ³ /min)	Intermittent		Continuous	
					HP	(kw)	HP	(kw)
UA-3	80	5.6	27	0.76	5	3.73	7½	5.60
UA-5	80	5.6	33	0.93	5	3.73	7½	5.60
UA-15	80	5.6	26	0.74	5	3.73	7½	5.60

METAL REMOVED PER ELECTRODE

Electrode (in.)	5/32	3/16	1/4	5/16	3/8	1/2	5/8	3/4
Electrode (mm)	4.0	4.8	6.4	7.9	9.5	12.7	15.9	19.0
Lbs. Metal/12" Elect.	0.25	0.5	1.0	1.5	2.0	5.0	8.5	12.0
Kg Metal/(305mm) Elect.	0.11	0.23	0.45	0.68	9.1	2.27	3.86	5.44