

Applications

All steels (particularly for stainless and manganese steels which cannot be cut by the oxy-acetylene process), also for cast iron, copper and its alloys, etc.

Characteristics

YAWATA CHAMFERTRODE electrodes are specially designed for powerfully effective cutting and grooving which can also be used for gouging and hole piercing. It gives a concentrated, forceful arc capable of penetrating plates up to 2.5 mm in thickness.

Typical Data

Cutting on AC supply (min. OCV 75)

Plate : Material (mm)	ϕ (mm)	I (A)	Cutting speed (cm/min)
12 mild steel	2.6	130	7.0
12 mild steel	3.2	190	10.5
20 mild steel	4.0	280	8.5
25 mild steel	5.0	350	8.5

Grooving on DC (pole +) Supply

Depth (mm)	ϕ (mm)	I (A)	Cutting speed (cm/min)
3	2.6	150	26
3	3.2	200	36
3	4.0	280	39
3	5.0	350	49

Piercing on AC Supply

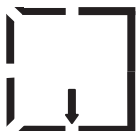
OCV (V)	Depth (mm)	ϕ (mm)	I (A)	Seconds to pierce	Hole size (mm)
75	6 mild steel	2.6	150	4	4
75	10 mild steel	3.2	200	5	7
75	20 mild steel	4.0	280	16	8
94	25 mild steel	5.0	350	11	10

Sizes & Recommended Current Range (AC or DC +)

AC (min, OCV 75) or DC (pole +)

Diameter/ Length (mm)	2.6/300	3.2/350	4.0/350	5.0/350
Flat butt (A)	120~150	160~200	200~280	280~350

Welding Positions



Flat butt welds only