



M-90 Arc Force

FEATURES

*CHAMFER ROD FOR GOUGING AND CUTTING IS GREAT FOR GOUGING OUR WELDS, REMOVING UNWANTED METALS, AND VEEING OUT CRACKS IN CATINGS (STEEL, CAST IRON,ETC.) WORKS ON BOTH FERROUS APPLICATION. FAST GOUGING AND PIERCING.

APPLICATION

- *HOLD ELECTRODE IN THE DIRECTION OF THE DESIRED GROOVE
- *USE THE SHORTEST ARC POSSIBLE
- *POSITION ELECTRODE AT A LOW ANGLE TO THE WORK PIECE (10° TO 15°)

CLASSIFICATION

*GOUGING-PIERCING-BEVELING

CHEMICAL COMPOSITIONS

C	Si	Mn	P	S	CR	Ni	MO
0.10	0.37	0.49	0.017	0.009	0.89		

WELDING PARAMETERS

DIAMETER (mm)	3.2
LENGTH (mm)	350
CURRENT (amps)	100-150

CURRENT

*AC or DC

WELDING POSITIONS

