



Pump casing

Special electrode for all position cutting and piercing of all metals

Typical Applications:

Piercing, cutting stainless and cast iron, cleaning castings, removing flash and risers.

Outstanding Features:

- Versatile, cuts through any metal.
- Exothermic coating with concentrate arc.

Recommendation:

For highest speed, all position cutting and piercing of all metals using standard electric arc equipment. Also for chamfering, gouging, cleaning out defects, burning rivets, beveling metal prior to welding. Ideal for cutting and piercing mild carbon steel, stainless steels, cast iron, malleable iron, nickel and nickel alloys, aluminium, copper, bronze. No special skill, supplementary equipment or oxygen tanks are required. Slow burn-off rate leaves little residue, requiring comparably less finishing. Electrode not overheat, can withstand high amperage.

Procedure:

Marks or scribe line where cut is desired. On DC machine, use straight polarity. No special holder or compressed air needed. When applying EWAC Pierce electrode, use both the arc-blow, caused by the exothermic coating, plus pressure with the hand. When arc is struck, push and pull, holding electrode at a 45° angle and using a sawing motion to cut. The closer the arc, the faster, cleaner, cooler the cut. For piercing holes, hold electrode vertically, and push in and out.

Recommended Amperages:

Metal Thickness	CutTrode	Amperages
Upto 25mm	3.15	150-350
6.5mm to 37.5mm	4.00	165-375
12.5mm to 75mm	5.00	175-400