

MG 570

HIGH SPEED GOUGING AND CHAMFERING ELECTRODE

AC OR DC STRAIGHT (ELECTRODE-)

GENERAL CHARACTERISTICS:

A highly efficient electrode that performs with all types of welding machines with sufficient capacity. The forceful arc-blow is produced by the special coating which eliminates the need for compressed air or oxygen. It also has excellent restrike capability. The size and depth of the groove can be easily controlled. Slag practically falls off; cut is smooth, uniform and can be done in all positions.

APPLICATIONS:

Gouging and chamfering of ferrous and non-ferrous metals. Removing unwanted or defective weld metal, preparing parts prior to welding, removing risers and reducing large areas of metal prior to machining.

TECHNICAL DATA:

Current	AC or DC straight polarity (electrode-)			
Amperage	150-250	210-350	250-400	300-500
(in)	3/32"	1/8"	5/32"	3/16"
(mm)	2.4	3.2	4.0	5.0

PROCEDURE:

For clean high speed cuts use DC straight polarity (electrode-). Hold electrode at a low angle to the workpiece (10° to 15°). Point the electrode in the direction of the desired groove, strike the arc and push the electrode as fast as the metal is removed. Maintain as short an arc as possible. The maximum depth of the groove in a single pass should not be greater than the diameter of the core wire. For deep grooves use multiple passes.