

GEMET 603

COPPER COATED AIR ARC GOUGING CARBON RODS

Gemet 603 is copper coated, air arc gouging carbon rod.

SCOPE : Gemet 603 can be used for gouging, cutting, beveling, flushing, back-grooving of weld joints. It can be used on all ferrous and non-ferrous metals like carbon steels and low alloy steels, stainless steels including ELC grades, copper, brass, gun-metal, cast-iron, cast-steel, aluminum, etc.

INDUSTRIAL APPLICATIONS: In foundries, boilers workshops, fabrication shops, heavy machinery manufacturing plants, shipyards, welding shops, repair workshops, refineries, fertilizer plants, sugar mills, etc.,

SALIENT FEATURES: Superior, copper coated, air arc gouging carbon rod.

- No degenerating effect on base metal as the heat input is low.
- Designed for greater metal removal and low consumption, resulting in maximum economy.
- Designed to withstand optimum currents.
- Excellent electrical conductivity and arc stability.
- Consistent in quality.

EQUIPMENT REQUIRED:

- D.C. Power Source.
- Air Compressor of 3H.P. or more.

RECOMMENDED CURRENT CONDITIONS (DC+):

6.0 mm	7.0 mm	8.0 mm	9.0 mm	10 mm	12 mm	16 mm	18 mm	25 mm
150-350 Amp	175-400 Amp	200-450 Amp	300-600 Amp	350-600 Amp	600-1000 Amp	800-1250 Amp	1200-1500 Amp	1500-2000 Am

Recommendation For Best Results:

1. Hold the gouging carbon at a minimum distance of 75 mm from the starting end.
2. Ensure that air jet is switched on before striking the arc.
3. Adjust air pressure between 5 and 7 kg/cm².
4. Use welding rectifier having capacity 500 Amps/600 Amps up to 8.0 mm size.
5. Always use reverse polarity (electrode positive, ground negative).

PACKING: 50 pieces per carton for all sizes.