

#### Processing information

Polarity:



A light reciprocating movement will help to drive the molten metal out of the kerf. The easiest way by horizontal pieces is to hold on an angle of 45° in cutting direction. At vertical pieces an angle of 60° downwards inclined is recommend. Moistured electrodes should be re-dried up to 70°C for about 30 minutes. In enclosed rooms it is necessary to suction the welding fumes.

#### Application

Electrode for cutting all unalloyed and alloyed steel grades as well as nonferrous metal, cast steel and cast iron.

#### Field



use

### Electrode for Cutting

#### Materials

Metallic Materials

#### Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.990.404	4,00/450	160 - 210	6,0	93	64,5
00.990.504	5,00/450	200 - 250	6,0	58	103,4
00.990.604	6,00/450	250 - 320	6,0	41	146,3



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