

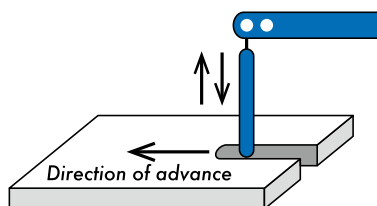
## FOR SLOT NAD CUTOFF USES

### DESCRIPTION & APPLICATIONS :

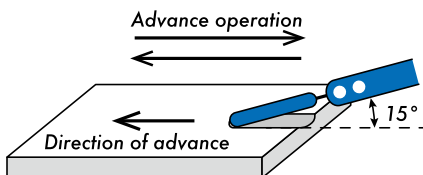
- SGCP is suitable for steel structure gouging use. Because of the strong arc spray and gas jet to displace molten metal.
- It can melt and cut various metals, such as stainless steel, cast iron, copper and its alloys. It provides as more safe way for gouging than the general gas.

### NOTE ON USAGE :

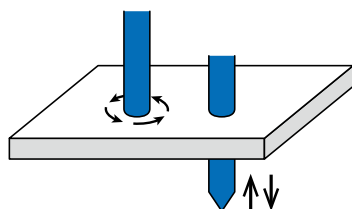
- When cut-off: The arc is truck with an electrode which is held at a 60-80 degrees from the vertical plane in line with proposed direction of gouging.(ref. chart A)
- When perforate : Take the weaving motion method and keep the gouging in the required direction for penetrate. (ref. chart B)
- When slot: Manipulate the electrode at the degree of 10 –30 with work piece. This forward and backward motion is repeated as the electrode is guided along the line to complete the gouge. (ref. chart C)



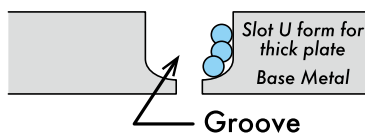
When cut-off(A)



When slot(C)



When perforate(B)



When slot(C)

### SIZE AND RECOMMENDED CURRENT RANGE : AC or DC(+)

Diameter (mm)	3.2	4.0	5.0
Amp.	160-180	200-240	250-350