



TECHNIWELD USA

ARC STAR

— G O U G I N G —
CARBONS

Techniweld USA's Arc Star gouging carbon electrodes are designed for use in the air carbon-arc metal removal process which melts metal with an electric arc, then blows it away with compressed air. When it's important to save the metal pieces that have been welded together, carbon-arc gouging is an absolute lifesaver!

All our gouging carbons come with a thick layer of copper shell surrounding the high density carbon. This results in strengthened arc stability and more efficient current transfer to get the job done quicker!

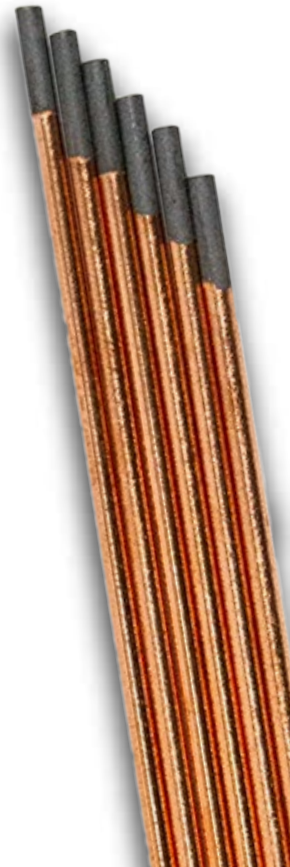
We know projects come in all shapes and sizes, so we offer a full range of gouging carbon electrodes. Based on the type of angle or joint you need to get into, or how important slag cleanup is to you, you can pick from our assortment of carbons below.



DC GOUGING CARBONS

Our standard, all-purpose gouging carbon electrodes all come with copper coating to help improve electrical conductivity for cooler operating conditions. It also makes the carbon more resistant to breakage, heat, and oxidation.

Part #	Diameter	Length	# Per Pack
CCC12512	1/8"	12"	100
CCC15612	5/32"	12"	100
CCC18712	3/16"	12"	50
CCC25012	1/4"	12"	50
CCC31212	5/16"	12"	50
CCC37512	3/8"	12"	50
CCC50012	1/2"	12"	50



HOLLOW DC GOUGING CARBONS

Hollow core gouging carbons can carry **15-20% increased current**, which offers excellent arc stability while allowing for **40% faster** removal than solid rods.

The hollow core design prevents fingernailing, or formation of a fragile pointed tip which occurs when using solid rods. When this tip falls into the gouge, it has to be cleaned up and redone.

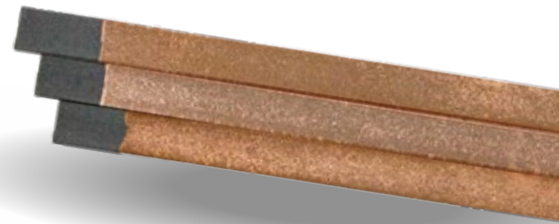
Hollow carbons create a smooth U-groove instead of a V-groove, and don't drop unnecessary carbon, making the job faster. These carbons function more silently, burn cleaner and produce much less smoke than standard rods.



Part #	Diameter	Length	# Per Pack
CCC18712H	3/16"	12"	50
CCC25012H	1/4"	12"	50
CCC31212H	5/16"	12"	50
CCC37512H	3/8"	12"	50
CCC50012H-	1/2"	12"	50

FLAT DC GOUGING CARBONS

Our flat gouging carbons were specifically tailored for close quarters - when you have to remove metal with a real close tolerance. They're also great to use for general applications, repairing or making dies, scarfing billets, removing weld crowns, and more.



Part #	Width	Height	Length	# Per Pack
CCC37515612	3/8"	5/32"	12"	50
CCC62518712	5/8"	3/16"	12"	50

JOINTED DC GOUGING CARBONS

If you need a continuous feed for quicker operation, especially in production operations, or machine-fed operations, jointed gouging carbon solutions are perfect!

Our gouging carbons allow machines to work fast and efficiently by operating in a smooth forward motion rather than being wasteful by going back and forth.

The joints fit tightly together and allow for more efficient current transfer. Loose fitting rods have a tendency to heat up and prematurely break off during gouging.



Part #	Diameter	Length	# Per Pack
CCCJ37517	3/8"	17"	50
CCCJ50017	1/2"	17"	50
CCCJ62517	5/8"	17"	25
CCCJ75017-	3/4"	17"	50

GOUGING CARBON CONSUMPTION AND ELECTRICAL REQUIREMENTS

Electrode Size

<i>Inch</i> <i>MM</i>	<i>Min. Amp</i>	<i>Max. Amp</i>
1/8" 3	60	90
5/32" 4	90	150
3/16" 5	200	250
1/4" 6	300	400
5/16" 8	350	450

Electrode Size

<i>Inch</i> <i>MM</i>	<i>Min. Amp</i>	<i>Max. Amp</i>
3/8" 10	450	600
1/2" 13	800	1000
5/8" 16	1000	1250
3/4" 19	1250	1600
1" 25	1600	2200

When calculating gouging carbon consumption, the following approximations could be helpful:

- For every inch of carbon consumed, you will get 8" of groove when making a gouge that is equal in depth to the diameter of the carbon.
- The gouge width will be about 1/8" wider than the diameter of the carbon being used.
- The welding power and amperage required is dependent on the carbon diameter being used.
- Very deep grooves or cuts require multi-pass procedures.