



Perfect Pass

Welding Products

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**Blow
Out**

Data Sheet

DESCRIPTION:

All position AC/DC CHAMFERING AND CUTTING ELECTRODE, DESIGNED TO BLAST AWAY UNWANTED METAL. Used with a conventional electrode holder, this electrode does not require compressed air or any other gases.

APPLICATIONS:

- Used to open cracks prior to welding in all metals, including cast iron and stainless steel.
- Remove old welds and dismantle or redesign. Blast effect ensures minimum removal while providing chamfered edges for subsequent re-welding.
- To blow-out rivets, blow holes in all metals for plug welding or for removing defects in castings.
- For removing old, worn and fatigued overlays prior to rebuilding.
- For cutting off, severing and trimming all metals.

HOW TO USE:

Equipment: Any constant current AC transformer or DC generator/rectifier providing minimum 65 volts open circuit.

Procedure: Adjust welding power source within prescribed amperage range and initiate the arc, holding the electrode at a very low (approximately 20°) angle to work. Push forward slowly ensuring that molten metal is blown away in the path of the arc. For deeper grooves, repeat the first operation. Any slag that remains can easily be removed by light chipping and wire brushing.

TYPICAL PROPERTIES: Clean ready-to-weld chamfers in all metals. No carbon is added in the process.

RECOMMENDED AMPERAGES:

ELECTRODE SIZE	RECOMMENDED AMPERAGE RANGE
3/32"	130 - 200 amps
1/8"	160 - 300 amps
5/32"	180 - 400 amps
3/16"	210 - 500 amps