

Classifications

Characteristics and typical fields of application

Phoenix Nut K is a copper coated graphite electrode; for preparing and gouging out weld grooves, and also for deburring and cutting of castings. This electrode can be used on metals of all types. It requires a special electrode holder with a combined current and compressed air supply and a heavy-duty converter or rectifier.

The compressor should be designed to provide a compressed air pressure of 6 to 8 bar. The electrode is guided forwards at high amperage at an angle of 25° to 45°. High alloy steels are gouged with reverse polarity, depending on the alloy composition.

Base materials

Operating data

	Polarity: DC (+)	∅ (mm)	L mm	Amps A
		6.3	305	250 – 400
		8.0	305	350 – 500
		10.0	305	450 – 600