



AUSTARC C & G

▶ Heavy Coated Manual Electrode for Cutting, Gouging or Piercing Steels

Identification

Coating - Black **End Tip** - Plain

Description & Applications

AUSTARC C & G is a heavy coated electrode providing a highly mobile means of cutting, gouging and piercing most steels, using standard AC or DC arc welding equipment. Austarc C & G produces a very high arc force and can be used for general cutting and grooving in joint preparation, removing defective welds and reclaiming scrap metal, etc.

Oxy-acetylene and carbon arc-air cutting and gouging are two processes available to industry capable of giving high quality, smooth preparations. Austarc C & G will not replace these processes but rather provide a convenient, easy to use and mobile tool for the arc gouging and cutting of most metals. It is particularly useful to the maintenance welder operating in awkward locations to remove welds, open up joints and trim off bolt or rivet heads, etc. Similarly, the rural welder will find C & G handy in repairing or preparing joints when operating away from (or without) oxy-acetylene equipment.

CUTTING

Direct the electrode into the work in the desired cutting direction, working from the outside edge. Use an up and down sawing motion, the "up" arc length being increased to increase heating, the "down" arc length being decreased to contact point to force the molten metal out of the groove. Angle of electrode should be approx 70° to the horizontal.

GOUGING

Point the electrode in the direction of gouging at approx 10-20° to the plate surface. Strike the arc and move forward rapidly. If slag and molten metal start to clog the groove bring the electrode up to clear and, without breaking the arc, circle backwards and move forward again. This latter technique may prove more necessary than straight forward motion on lower amps or as the electrode becomes hotter. If amps are excessive, C & G will tend to "cut out" on AC and overheat, causing premature charring of the coating and reduced arc force.

PIERCING

For holes, plunge the electrode into the plate at slightly off right angles. With a small circular motion to the holder, force the electrode into the plate until full penetration is achieved. Once the hole has been made it may be trimmed with an up and down sawing motion.

Operational Data

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE * (amps)
3.2	380	170 - 250
4.0	380	220 - 350

*Recommended for DC+ or AC (minimum 70 OCV) operation

Packaging Data

ELECTRODE SIZE (mm)	PACKAGING (KG)		APPROX NO OF RODS PER KG	PART NUMBER
	Packet	Carton		
3.2	4	12	26	CG32
4.0	4	12	17	CG40

Storage Information

Products should be stored in dry conditions in original sealed undamaged packaging as supplied. The integrity of consumable products can be adversely affected by time and storage conditions and that the detail shown in the batch certificate is true at the time of packaging and is only valid for a LIMITED time. After that time the product may need to be reconditioned or checked to ensure it is suitable for the purpose it is intended to be used for.*

*NOTE: Refer to Welding Technology Institute of Australia (WTIA), technical 3. care and conditioning of arc welding consumables.

WARNING: The fire hazard potential of arc cutting is much greater than for welding, therefore, ensure the arc is clear of all flammable materials before proceeding. Do not cut on or near oil drums, gas cylinders, etc.