



High Speed Cutting, Gouging and
Piercing Electrode

ChamferCut®



- Fast and easy cutting and piercing
- Particulary efficient with most ferrous and non-ferrous alloys
- Excellent for use with Arc-Air and Carbon-Arc metal removal processes
- Designed for use with conventional AC/DC machines

ChamferCut

ChamferCut is a high speed electrode formulated for efficient cutting, gouging, piercing overall metal removing tool. It cuts the unwanted metal from its path, leaving an ideal surface for subsequent operations.

ChamferCut is designed for ferrous and non-ferrous alloys, including stainless steel and nickel alloys, cast iron, aluminum and copper.

TECHNICAL DATA

Typical Values

Designed for use with conventional AC/DC welding machines using a standard electrode holder.

Current & Polarity: AC or DCEN (-)

DIAMETER	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)
AMPERAGE	150-190	230-310	280-380

Note: suggested amperage ranges are considered typical set-up values. Adjust for the particular metal being cut and base metal thickness

PROCEDURE FOR USE

1. Mark a chalk line where chamfer is desired.
2. On DC, use straight polarity DCEN (-)
3. Point electrode like a lance, in direction of travel, at an angle of not more than 20° with the plane of the work.
4. Push electrode along the line of cut, quickly for a shallow cut, more slowly, or with a weaving motion, for a deeper gouge. Maintain contact with the base metal at all times. Avoid back and forth movement.
5. If a deeper gouge is needed, repeat procedure until the required depth has been achieved.

TYPICAL APPLICATIONS

It is possible to vee out cracks or remove unwanted metal without dismantling, especially in hard-to-reach spaces where it would be impossible to work with a grinder, tools, or even a cutting torch.

ChamferCut is excellent for burning (or washing) pitted and rusty surfaces prior to welding.



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