



Heat Resistant  
Chamfering Electrode

# ChamferTrode®



- Fast and easy chamfering
- Exothermic coating provides precise arc for accurate cutting
- Highest arcing voltage available, for efficient metal removal
- Designed for use with conventional AC/DC machines

# ChamferTrode

ChamferTrode is a highly heat-resistant electrode whose special exothermic coating concentrates the force of the arc right at the point of application, yielding a highly efficient metal removing tool. The concentrated force of the arc blasts the unwanted metal from its path, leaving an ideal surface for subsequent operations.

ChamferTrode's exothermic coating has a special formula to provide the highest arcing voltage of any electrode made. This is accomplished by using materials within the coating to intensify temperatures in the arc and form high velocity pressure waves toward the molten metal. This coating has a very high melting point that breaks down slower than the core wire, forming a crater which focuses the pressure to blast the metal away.

## 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)	3/16" (4.8mm)
AMPERAGE	150-250	250-350	300-400	300-500

## 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 chamfer, 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. Utilizing the heat and force of the highly concentrated arc, push the molten metal ahead and away. If a deeper gouge is needed, repeat procedure until the required depth has been achieved.

## TYPICAL APPLICATIONS

Chamfering of:

- Cast and Malleable Iron
- Low, Medium and High Carbon Steel Parts
- Alloy Steel, Stainless Steel, Manganese Steel

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.

ChamferTrode is excellent for burning (or washing) pitted and rusty surfaces prior to welding, beveling edges in preparation for welding, and forming keyways on shafts prior to final finish milling.

It is also used for producing corrugations to prevent slipping and for chamfering blow holes and leaks prior to filling by welding.



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