

Guts

CATEGORY SMAW Stick Electrodes

TYPE Special coated electrode with hard blowing effect for gouging.

APPLICATIONS Guts is suitable for all materials that has conductivity, it is used on aluminium, cast iron, steel, copper, nickel etc.... Guts can be a solution in cases where a cutting flame will produce too much heat or at hardly reachable places. Also it can be very useful on materials that cannot be flame cut such as stainless steel.

PROPERTIES Chamfering instructions:
Guts can be used on high amps and must have an angle of about 15 degrees (almost flat) to give the best results. The working speed when making grooves can be improved by making slightly pushing movements in one direction. Guts B2 has a non conductive coating for excellent applicability in hard to reach places.

CLASSIFICATION

AWS	no standard
EN ISO	no standard
DIN	no standard

SUITABLE FOR Gouging, drilling holes, remove old weld metal, chamfering, cutting, weld preparations etc.

APPROVALS CE approved

WELDING POSITIONS:



NA

C	Mn	Si	Cr	Ni	Mo
-	-	-	-	-	-

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
	-						

GOUGING PARAMETERS / PACKING

D (mm)	Parameters		Packing	
	Length (mm)	Current (A)	kg / can	kg / 1000
2.5	350	90-130	2	
3.2	350	160-200	2	28.2
4.0	350	200-280	2.2	52.5
5.0	350	280-350	2.2	106.1

REDRYING TEMPERATURE nor required