# SHANDONG TAIRAN IMPORT AND EXPORT CO.,LTD

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## Carbon Arc Gouging Carbon Rod


1,Performance parameters of Carbon arc gouging carbon rod

| ITEM | Unit | DIA Φ6 | DIA Φ8 |
|---|---|---|---|
| Current A | A | 280-300 | 320-350 |
| Voltage | v | 40 | 42 |
| Planing cutting speed | mm/min | 1200 | 1400 |
| Compressed air pressure | Mpa | 0.5-0.6 | 0.5-0.6 |
| Thickness of copper layer | mm | 0.07-0.08 | 0.07-0.08 |
| Ash content | % | ≤1.0 | ≤0.8 |
| Flexural strength | Mpa | ≥20 | ≥20 |
| Water content | % | ≤0.03 | ≤0.03 |
| Resistivity | μΩ•m | ≤20 | ≤18 |

2. Instructions

1) The product must be kept dry. If it is damp, it needs to be dried at 120 ℃ for 2 hours before use

2) When used for DC power supply, the carbon rod is connected to the positive pole of the power supply

3) The compressed air pressure should be kept at 0.4-0.6 Mpa

4) The arc distance between the carbon rod and the workshop is about 3 mm, and the carbon rod is about 100 mm out of the fixture

5) The angle between the carbon rod and the working room is generally 45 ° and

planed along the tangent or straight line direction

3. Product application knowledge

1) Compressed air pressure: the pressure of compressed air will directly affect the planing speed and quality. If the pressure is too small, the molten metal can not be blown off, and the planing is difficult to continue. If the pressure is lower than 0.4MPa, the planing can not be carried out. If the pressure is high, it is conducive to planing, but when the pressure is too high and the current is small, the arc will be unstable or even extinguished. Commonly used pressure: 0.4-0.6Mpa

2) Carbon rod extension length: the carbon rod extension length refers to the length of the carbon rod from the muzzle to the beginning of the arc. If the extension length is large, the nozzle of compressed air will be far away from the arc, the resistance will increase, and the carbon rod will be burnt out, which will cause insufficient wind force, so the slag can not be blown off smoothly, and the carbon rod is easy to break. Generally, the extension length is 80-100 mm

3) Angle between carbon rod and work piece: this parameter mainly affects the depth and speed of planing groove. With the increase of angle, the planing speed increases and the planing speed decreases, generally from 45 ° to 60 °

4) Arc length: during operation, if the arc length is too long, it will cause arc instability and even cause arc extinction. Generally, it is appropriate to keep 1-2mm, and try to keep short arc, so as to improve the production efficiency and the utilization rate of carbon rod. But if the arc is too short, it is easy to cause "carbon inclusion" defects

5)Planing speed: the planing speed has a certain influence on the size, surface quality and stability of the planing groove. The planing speed should match with the current and the planing depth (or the angle between the carbon rod and the work piece). If the planing speed is too fast, it is easy to cause the carbon rod to contact with the metal and condense on the top of the planing groove, resulting in the specification, arc extinction and carbon inclusion defect The general planing speed is 0.5-1.2m/min

4 working principle

Carbon arc gouging is a kind of hot working technology, which uses the arc heat generated between the carbon rod and the workpiece to melt the metal, and at the same time uses compressed air to blow off the molten slag, so as to gouge out the groove on the metal

5 product specifications

You can choose from 7 specifications. Φ4-12mm*355（305）mm

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6.Product photos



7.Are you looking for a professional carbon arc gouging carbon rod supplier? Our company is your best choice

Honesty is the culture of our company

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5,Good feedback of product use effect,the products have been exported to South Korea, Brazil,England
6,We are a professional supplier, who can provide customers with free product technology, use and other issues

Do you want to find a professional supplier of Anti Rust Oil products?

Do you want to find a stable and credible supplier?

Then please contact with us

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