



WELTRODE[®]
—The Welding Technology

Weltrade WC 9000 AC-DC

Premium Multipurpose Electrode For Gauging, Chamfering, Cutting & Piercing

Special Features

- ✦ Blasting Arc Yielding High Speed And Clean Cutting And Gauging.
- ✦ No Compressed Air Or Oxygen Required.
- ✦ Excellent All Position Welding And Restrike Capability.
- ✦ Designed To Operate On All Type Of Welding Machines With Limited Capacity.



Application

Ideal For Gauging, Cutting & Chamfering Of Unalloyed And Low Alloyed Steel Cr-Ni, Cr-Ni-Mo And Other Alloyed Stainless Steels.

Different Grades Of Cast Irons, Cast Steels, Aluminums And Copper, For Which The Oxy-Fuel Cutting Methods Are Not Applicable .

Recommended Amperage Settings

Diameter (mm)	1/8 (3.15)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	140	200	280
Maximum Amperage	230	310	430

Welding Techniques

Initiate Arc By Holding Electrode At A Low Angle To The Workpiece (10° To 15°) . Push The Electrode As Fast As The Material Is Removed . Maintain Shorter Arc For Faster And Cleaner Cut . For Piercing Hold Electrode Vertically And Push In And Out . For Cutting Action Use Sawing Action Technique .