



Electrodes for Gouging and Cutting |

GEMINI CHAMFETRODE

GEMINI CHAMFETRODE electrodes are specially designed for powerfully effective cutting and grooving which can also be used for gouging and hole-piercing. It gives a concentrated, forceful arc capable of penetrating plates up to 2.5mm in thickness.

TYPICAL DATA					
CUTTING ON AC SUPPLY (min. OVC 75)					
Plate Material (mm)		Diameter (mm)	Current (A)	Cutting Speed (cm/mm)	
12 mild steel		2.6	130	7.0	
12 mild steel		3.2	190	10.5	
20 mild steel		4.0	280	8.5	
25 mild steel		5.0	350	8.5	
GROOVING ON DC (POLE +) SUPPLY					
Depth (mm)		Diameter (mm)	Current (A)	Grooving Speed (cm/mm)	
3		2.6	150	26	
3		3.2	200	36	
3		4.0	280	39	
3		5.0	350	49	
PIERCING ON AC SUPPLY					
OVC (V)	Plate Material (mm)	Ø (mm)	Current (A)	Seconds to pierce	Hole size (mm)
75	6 mild steel	2.6	150	4	4
75	10 mild steel	3.2	200	5	7
75	20 mild steel	4.0	280	16	8
94	25 mild steel	5.0	350	11	10
TYPICAL CURRENT PARAMETERS					
AC or DC +					
Diameter /Length (mm)		2.6/ 300	3.2/ 350	4.0/ 350	5.0/ 350
Current min/ max (A)		120/ 150	160/ 200	200/ 280	280/ 350
PACKAGING & ORDERING INFORMATION					
Size		Packet		Carton	
2.6mm		1 kg		20 kgs	
3.2mm		1 kg		20 kgs	
4.0mm		1 kg		20 kgs	
5.0mm		1 kg		20 kgs	

Disclaimer: The information provided serves as a general guideline. Actual welding parameters may vary depending on the specific characteristics of the welding equipment. Additional variables to consider include weld length, plate thickness, operator proficiency, etc. Users are encouraged to assess their unique circumstances and seek professional advice as needed. It is important to acknowledge that neither we nor our affiliates can be held liable for any misuse or improper application of products.