



PHILARK PH GR

Coated Electrode for Surface Preparation, Cutting and Gouging



General Description

PHILARK PH GR is used for ferrous or non-ferrous metals where grooving is necessary without supplementary gases and special electrode holder. For preparing sections prior to welding, gouging out old or defective weld metal, removing flash and risers. All these operations can be carried out in all positions; except vertical upwards. A thick, specially developed exothermic coating produces a forceful gas jet which blows the molten metal away, to give a smooth, clean groove. A finishing operation is unnecessary.

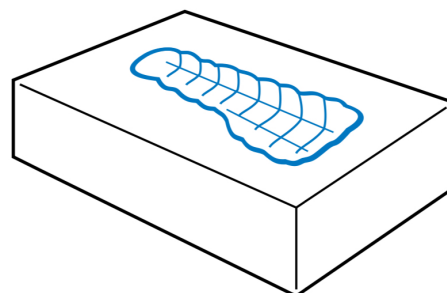
Working Speed	██████████
Clean up	██████████
Heat Input	██████████

Recommended Procedure

Strike the arc with the electrode normal to the workpiece and then immediately incline the electrode at an angle of 15-20° to the workpiece. Point the arc in the direction of travel, move the electrode forward to melt the metal and then pull it back to allow the gas jet to blow the molten metal away. Mechanical Properties of Weld Metal

Typical Applications

- Gouging, bevelling cast iron and other metals
- Removal of old welds and rivets
- Removal of weld defects
- Piercing holes
- Back-gouging root runs



Welding Parameters

Current Type and Polarity : AC/DC(-),
Welding Positions: Flat, Vertical, Overhead.

Diameter [mm]	3.15	4.0	5.0
Length [mm]	350	350	450
Current [A]	180-220	200-275	250-300

PHILARK ALLOYS

REGD. OFFICE & WORKS: E 37, UPSIDC, MG ROAD, HAPUR, UP



011 42821005, 23231260



enquiry@philarkalloys.com



www.philarkalloys.com