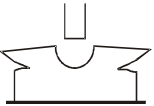


<b>NSG</b>	<b>FLUX COATED MMA ELECTRODE FOR GOUGING ALL METALS</b>			DATA SHEET NO. <b>153</b>	
SPECIFICATION	NO NATIONAL SPECIFICATIONS				
CLASSIFICATION					
PRODUCT DESCRIPTION	<p>A unique flux coating high in organic materials extruded onto a mild steel core wire with a blend of silicates that ensures coating strength.</p> <p>The flux also contains arc stabilising elements.</p>				
GOUGING FEATURES OF THE ELECTRODE	<p>The electrode functions AC and DC producing a strong arc surrounded by a powerful gas plasma.</p> <p>The strong arc melts the metal and the gas plasma blows it away leaving a clean gouge corresponding to the outside diameter of the electrode used.</p>				
APPLICATIONS AND MATERIALS GOUGED	<p>Gouging mild steel, stainless steel, cast irons, nickel based alloys.</p> <p>To assist weld preparation or back gouging when welding from both sides.</p> <p>Removal of worn hard facing deposits.</p> <p>Stress relieving grooves in cast irons etc.</p> <p>Removing weld defect, cracks etc.</p>				
WELD SLAG	No residual slag is evident, only a porous sintered dross which is readily removable.				
GOUGE APPEARANCE	<p>The gouge is smooth and internally clean.</p> <p>The dross covers only the groove edges and the gouge itself.</p> <p>May be welded directly by manual electrodes if TIG and MIG is to be used.</p> <p>The gouge should be pre-ground.</p>				
WELDING AMPERE AC or DC+	∅ (mm)	3.2	4.0	5.0	
	MIN	150	230	290	
	MAX	200	270	330	
OTHER DATA	Electrodes that have become damp should be re-dried at 100°C for 30 minutes				