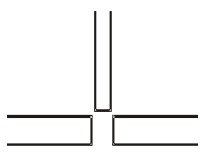


NSP	FLUX COATED MMA ELECTRODE FOR CUTTING ALL METALS FERROUS AND NON-FERROUS			DATA SHEET NO. 154	
SPECIFICATION	NO NATIONAL SPECIFICATION				
CLASSIFICATION					
PRODUCT DESCRIPTION	<p>A high iron oxide flux, very low in conventional minerals that produces a highly oxidising gas plasma around the arc initiated by the core wire.</p> <p>The flux is extruded onto the core wire using special silicates to maintain coating strength during electrode usage.</p>				
CUTTING FEATURES OF THE ELECTRODE	<p>The electrode functions AC and DC producing a strong arc accompanied by a highly oxidizing gas plasma.</p> <p>It is necessary to start cutting action at the edge of plate. Once started the metal is cut by an oxidizing action and the gravitational removal of the molten or cooling resultant oxides.</p>				
APPLICATIONS AND MATERIALS TO BE CUT	<p>Cutting all metals without specialised equipment up to 15mm thick. Particularly useful on site.</p> <p>No slag remains, only sintered iron oxide particles which are only lightly attached, not fused, to the plate surface.</p> <p>The cut edges and sub-surface do not suffer any carbon pick-up and after light mechanical dressing are of very acceptable appearance.</p>				
SLAG	<p>No slag in the conventional use of the word exists, only sintered metal oxides lightly attached to the plate surface.</p>				
APPEARANCE OF CUT EDGES	<p>The cut is perpendicular to the plate surface.</p> <p>The cut surface has the appearance of an cut with some incipient surface melting. On high carbon steels, a small sub-surface hardening may have occurred, but only light grinding is needed to remove it.</p>				
WELDING AMPERAGE AC or DC+	Ø (mm)	3.2	4.0	5.0	
	MIN	150	230	290	
	MAX	200	270	330	
OTHER DATA	<p>Electrodes that have become damp should be re-dried at 110°C for 1 hour.</p>				