

# SHUBER E 100

## CHAMFERING & CUTTING ELECTRODE



### DESCRIPTION

ECONOMICAL TOOL FOR CHAMFERING AND CUTTING ALL METALS. IT CAN BE USED EVEN ON DIFFICULT-TO-CUT METALS SUCH AS STAINLESS STEELS, CAST IRON, BRONZE AND MANGANESE STEEL. The special coating creates a gas of intense velocity causing a "jet blast" action. The heat generated by the electrode melts the base metal and the high velocity gas stream blows away the molten metal in seconds.

### SPECIAL FEATURES

- No extra equipment or gases required.
- Outstanding strike and re-strike capability.
- Easy control of groove shape and depth.
- Grooves & cuts are smooth and uniform due to exothermic action coating.

### APPLICATION INSTRUCTIONS

**CHAMFERING :** Hold electrode at an angle of 15° and strike arc. Push in the direction of travel at a faster speed for shallow chamfer and slower speed for deep grooves. For deeper grooves, procedure is repeated until the required depth is achieved.

**CUTTING :** Hold electrode at a 45° angle and strike arc. Push in the direction of travel using a saw-like motion to melt and blow out the molten metal.

### RECOMMENDED CURRENT:

AC or DC (Straight Polarity)	DIAMETER	AMPS
	3.2 mm (1/8")	120 - 200
	4.0 mm (5/32")	200 - 270
	5.0 mm (3/16")	290 - 330