

MAGNA 150 AC-DC

FEATURES:

Magna 150 is a special cutting electrode designed with a non-conductive, heat-resistant coating which has an exothermic action. It has the following features:

- 1. High Efficiency.** Magna 150 cuts rapidly and cleanly. It provides a clean cutting action that results from its special exothermic coating. The coating has a blasting effect due to its release of gases which removes molten metal in the same way oxygen or compressed air do, but no special equipment is necessary. The exothermic reaction is produced by the melting of oxides of titanium, aluminium and iron along with special chemicals which produce super heated gases.
- 2. Versatility.** Magna 150 can be used for cutting or piercing cast iron, stainless steel, aluminium and practically all metals. It can be used for cutting, piercing, bevelling, or gouging. Precision cuts can be made by using a template made of asbestos or heat resisting board.
- 3. Applications.** Magna 150 will remove the head of a rivet and can also be used to cut out the body of the rivet. It is excellent for foundry cutting of gates and risers and side fins.

Due to its lack of deep contamination it is excellent for cutting stainless steel. It is ideal for cutting metals which do not respond to the phenomena of oxidation and upon which the oxyacetylene torch can only be used with difficulty, such as cast iron, aluminium, stainless steel and armour plate.

One of the most important features of Magna 150 is its convenience. No special holder needs to be used nor does it require oxygen or compressed air. Merely insert Magna 150 in any electrode holder and start cutting. Magna 150 performs perfectly on both AC or DC welding machines. It is particularly useful for on site or field repair jobs where oxy bottles are inconvenient or prohibitive due to their bulkiness and weight.

APPLICATION

Magna 150 can be used with any electrode holder on either AC or DC straight polarity welding machines. Set machine amperage in accordance with size electrode being used.

To Punch a Hole Using Magna 150

Position electrode on spot where hole is required and strike surface to establish an arc then apply pressure until penetrating right through metal. On thick metal a "jabbing" technique is desirable.

When Using Magna 150 for Cutting

When dissecting thin sections it is advisable to use a pattern or template as a guide. Move electrode around edge of pattern keeping an even pressure on electrode when applied to metal. The pattern can be made from wood, fibre board or any non conductor.

Heavier sections are best managed by working electrode up and down, the same action as in sawing.

Recommended Sizes and Amperages:

Metal Thickness	Electrode Diameter		Gauge	Setting
	Metric	Inches		
Up to 3 mm (1/8")	3.2 mm.	(1/8)	10	175-350 amps
3-12 mm (1/8" to 1/2")	4.0 mm.	(5/32)	8	180-400 amps
Over 12 mm (1/2")	4.8 mm.	(3/16)	6	200-425 amps