

Lehami 7100

Chamfering / cutting electrode with 25% more arc blast force



SPECIAL FEATURES

- Reactionary coating creates the highest levels of arc blast.
- Special coating elements form an electrically conductive “cup” for ease of restrike.
- Designed specifically for small AC welding machines.

APPLICATIONS

Can gouge, bevel or cut all metals including stainless steel, aluminium, and copper. Excellent for the removal of stainless steel joints and overlays. No oxygen is required.

AVAILABLE SIZES

INCHES	METRIC	GAUGE	RECOMMENDED AMPERAGE
3/32"	2.5 mm	12	100 - 170
1/8"	3.2 mm	10	170 - 250
5/32"	4.0 mm	8	220 - 330
3/16"	5.0 mm	6	300 -450

RECOMMENDED CURRENT: DC Straight polarity (Electrode -) or AC

GOUGING/ CUTTING POSITIONS: Flat, Vertical Up, Vertical Down, Horizontal, Overhead

GOUGING/ CUTTING TECHNIQUES:

Hold electrode at a 10° angle above workpiece. Initiate arc and move forward in a straight or back and forth motion. For cutting use a “sawing action” technique.

TYPICAL MECHANICAL PROPERTIES

This electrode does not leave deposits.

MICROSTRUCTURE:

This electrode does not leave deposits.

WELD METAL ANALYSIS (Typical Weight,%)

This electrode does not leave deposits.

GOUGING RATES

<i>Diameter</i>	<i>Length</i>	<i>Weight of Gouged Metal g / min</i>	<i>Arc Time of Gouging in seconds / inch (mm)</i>	<i>Amperage Setting</i>
3/32" (2.5 mm)	14" (350 mm)	35	1.6 (0.064)	160
1/8" (3.2 mm)	14" (350 mm)	100	1.2 (0.048)	230
5/32" (4.0 mm)	14" (350 mm)	120	1.0 (0.04)	310
3/16" (5.0)	14" (350 mm)	180	0.8 (0.032)	420

INTERNATIONAL
SPECIFICATIONS

None Applicable for this
Proprietary Product