



## HH 8 CHAMFER GOUGING ROD

DC STRAIGHT OR AC ELECTRODE

### General Characteristics

---

HH 8 Chamfer is a grooving, chamfering, cutting and gouging electrode used without air or oxygen. It is a very fast and efficient metal working tool. It can be used on all metals including manganese steel, cast iron, stainless steel, and even aluminum. It performs well on AC as well as DC arc welding machines, however DC Straight will give the best performance. DC Reverse may be used if so desired. HH 8 Chamfer can be used in all positions, and leaves surfaces clean and scale free, ready for welding.

### Procedure

---

Holding the electrode at an angle of approximately  $10^{\circ}$  off the work piece, proceed in a sawing motion, pushing the molten metal ahead of the groove. It is recommended that the gouge be no deeper than  $1/2$  the diameter of the electrode coating. To make a wide groove, use a series of grooves.

### Application

---

HH 8 Chamfer can be used to vee out cracks, to remove old and broken welds, for joint preparation on cast iron, to remove hardsurfacing deposits, and cutting metals that cannot be cut with a torch.

---

Diameter (Inch)	3/32	1/8	5/32	3/16
(mm)	2.5	3.25	4.0	5.0
Amps (approx.)	150-250	210-350	250-400	300-500

---