

## GOUGING CARBONS – ELECTRICAL REQUIREMENTS

To make sure that the machine is of sufficient size to produce the required current. Amperages required depend upon the size (diameter) of the Electrode, as follows :-

Electrode (inch)	5/32	3/16	1/4	5/16	3/8	1/2
Electrode (mm)	4	5	6	8	9.5	13
Min. Amps dc	90	200	300	350	450	800
Max. Amps dc	150	250	400	450	600	1000
Min. Amps ac		200	300	325	350	500
Max. Amps ac		250	400	425	450	600

### AIR REQUIREMENTS

Compressed Air at 80 to 100 p.s.i. (5.62 to 7.03 kg/cm<sup>2</sup>) and 30 to 50 cfm (0.85 to 0.99 m<sup>3</sup>/min) is required for optimum removal of the molten metal (Slag) from the gouge, groove or cut. (Note : to convert p.s.i. to Kpa-kilopascals-multiply by 6.895).

Compressed air is normally obtained from the standard shop supply, but a suitable compressor may also be used (say 3 to 5 HP).