

**ARCAIR**<sup>®</sup>

AN ESAB<sup>®</sup> BRAND



**INDUSTRIAL CUTTING  
AND GOUGING EQUIPMENT**



**MANUAL GOUGING**

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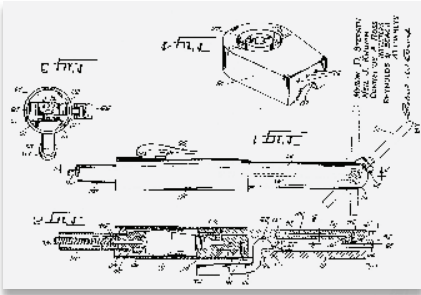
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*This information is accurate to the best of our knowledge at the time of printing and is subject to change at any time at ESAB's sole discretion.*



**1949**  
 Myron Stepath invents CAC-A cutting and gouging process.  
 Stepath founds Arcair Co.  
 Introduces G-3 cutting and gouging torch.



**1956**  
 Introduces H-5 cutting and gouging torch.



**1961**  
 Arcair relocates manufacturing to Lancaster, Ohio.



**1968**  
 Introduces K-3 cutting and gouging torch.



**1972**  
 Introduces Underwater Cutting and Welding Torch.



**1974**  
 Myron Stepath retires.

**1980s**  
 SLICE® torch introduced, allowing for portable and quick cutting operations for fire and rescue.

# ARCAIR IS SYNONYMOUS WITH **CARBON ARC GOUGING**



**1983**  
Introduces K4000®  
cutting and gouging torch.



**2004**  
Arcair relocates to  
Denton, Texas combines  
manufacturing with Victor.



**2011**  
Introduces Arcair-Matic®  
N7500 Automated Gouging  
System.



**2014**  
Arcair becomes  
An ESAB Brand

**2018**  
Introduces AirPro X4000  
gouging torch and cable  
assembly with the industry's  
first ever pneumatic arm.

## GOUGING TORCHES

### FEATURES & BENEFITS

#### IMPROVED TORCH AIR FLOW

- More efficient use of air supply
- Improved metal removal

#### FOUR HOLE HEAD ASSEMBLY

- Optimizes air flow to the arc
- Efficiently cleans slag from groove edge

#### AIR ASSIST POSITIVE AIR SHUT-OFF

- Minimizes air supply unit cycling on and off
- Allows torch usage when air supply is marginal

#### IMPROVED CABLE ELECTRICAL CONDUCTION

- Improves cable service life
- Decreases heat build up in cable and torch

#### SUPERIOR OUTER CABLE COVER

- Durable cover for improved cable life in a harsh environment
- Resists breakdown due to exposure to heat produced by gouging

#### INSULATED CONNECTION BOOT & HOOK-UP KIT

- Makes for easy torch hook-up
- Virtually eliminates the possibility of arcing when contacting electrically hot parts

## IMPROVED CARBON-ARC TORCH CABLE BOOT DESIGN

### FEATURES & BENEFITS

- **Patented two-piece boot design**  
Molded from a hard nylon reinforced fiber polymer made to withstand the substantial abuse in shop and field applications
- **Helps prevent accidental arcing**  
No chance of the "boot" pulling away from the power connection as seen with prior "boot" design
- **Ease of replacement in the field**  
Threaded screws holds the two halves together and can be loosened with a standard straight blade screwdriver
- **Available in two (2) different molded "boot" housing configurations**
  - Conventional Boot (Part No. 94-105-032)**
    - Accepts one 4/0 welding cable from the power supply and one 3/4" (19 mm) diameter air hose assembly providing current and compressed air
  - Quick-Connect Hook-Up Kit (Part No. 94-463-046)**
    - Twist lock-style power connection and air hose extending from the rear of the torch cable. This option allows the operator to connect or disconnect the incoming power lead and air line quickly and easily



### THE "BEST" JUST GOT BETTER

Help prevent accidental arcing in your workplace

Patent No. D708,240 S



Angle-Arc®  
Gouging Torches



Straight Handle  
Gouging Torches



Tri-Arc®  
Gouging Torches



**Conventional**  
Replacement Part No. 94-105-032



**Quick-Connect Hook-Up Kit**  
Replacement Part No. 94-463-046

**NOTE:** Replacement Boots will fit onto all Arcair manual hand torch cable assemblies having an amperage range of 1000 Amps or less.

## GOUGING TECHNIQUES FOR SPECIFIC MATERIALS

### CARBON STEEL & LOW ALLOY STEEL, SUCH AS ASTM A514 & A517

Use DC electrodes with DCEP (electrode positive). AC electrodes with an AC transformer can be used, but for this application, AC is only half as efficient as DC.

### STAINLESS STEEL

Use DC electrodes with DCEP (electrode positive). AC electrodes with an AC transformer can be used, but for this application, AC is only half as efficient as DC.

### CAST IRON INCLUDING MALLEABLE AND DUCTILE IRON (NODULAR)

Use 1/2" (12.7 mm) or larger diameter CCDC electrodes at the highest rated amperage. Use an angle of 70° off the workpiece and the depth of gouge should not exceed 1/2" (12.7 mm) per pass.

### COPPER ALLOYS (COPPER CONTENT 60% AND UNDER)

Use CCDC electrodes with DCEN (electrode negative) at the electrode's highest amperage rating.

### ALUMINUM BRONZE AND ALUMINUM NICKEL BRONZE (NAVAL PROPELLER ALLOY)

Use CCDC electrodes with DCEN (electrode negative) at the electrode's highest amperage rating.

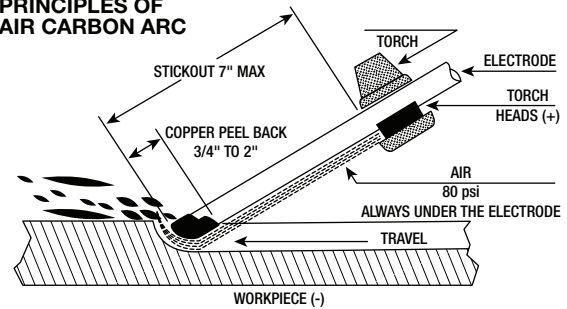
### NICKEL ALLOYS (NICKEL CONTENT OVER 80% OF MASS)

Use CCAC electrodes with AC current.

### NICKEL ALLOYS (NICKEL CONTENT UNDER 80% OF MASS)

Use CCDC electrodes with DCEP (electrode positive) at the electrode's highest amperage rating.

### PRINCIPLES OF AIR CARBON ARC



### MAGNESIUM ALLOYS

Use CCDC electrodes with DCEP (electrode positive) and prior to welding, wire brush the groove.

### ALUMINUM

Use CCDC electrodes with DCEP (electrode positive). You must brush with a stainless wire brush before welding. Electrode stick-out (length of electrode between torch and workpiece) should not exceed 3" (76.2 mm).

### TITANIUM, ZIRCONIUM, HAFNIUM, AND THEIR ALLOYS

Do not cut or gouge to prepare for welding or remelting unless you mechanically remove the surface layer from the cut/gouge surface.

NOTE – If you preheat for welding, preheat for gouging

### CURRENT REQUIREMENTS

Electrode Diameter	1/8"	5/32"	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	3/8" Flat	5/8" Flat
	3.2 mm	4.0 mm	4.8 mm	6.4 mm	7.9 mm	9.5 mm	13 mm	16 mm	19 mm	25 mm	9.5 mm Flat	16 mm Flat
Minimum amps DC	60	90	200	300	350	450	800	1000	1250	1600	250	300
Maximum amps DC	90	150	250	400	450	600	1000	1250	1600	2200	450	500
Minimum amps AC	–	–	200	300	–	350	–	–	–	–	–	–
Maximum amps AC	–	–	250	400	–	450	–	–	–	–	–	–

### GOUGING TORCH SELECTION GUIDE

Copperclad Electrodes	Amperage Range					Recommended	Alternate
	90 – 450	450 - 1000	1000 -1400	1400 – 2000	2000 - 2400		
1/8" - 3/8" Round (3.2 mm - 9.5 mm) 3/8" & 5/8" Flats (9.5 mm & 15.9 mm)	████████████████████					K3000™	
5/32" – 1/2" Round (4.0 mm – 12.7 mm) 3/8" & 5/8" Flats (9.5 mm & 15.9 mm)	████████████████████					AirPro X4000®	K4000™
5/16" - 5/8" Round (7.9 mm - 15.9 mm)	████████████████████					K-5	Tri-Arc®, AirPro™ X4000, K4000®
5/16" – 1" Round (7.9 mm – 25.4 mm)	████████████████████					Tri-Arc®	

### WHICH TORCH IS RIGHT FOR YOU?

Torch Model	Amperage (Maximum)	Swivel Cable	Swivel Cable Lengths (Ft)	Air-Cooled Water-Cooled	Handle Design	Body/ Upper Arm Construction	Application	Special Features
K3000™	600	360°	7 ft & 10 ft	Air-Cooled	Small & Ergonomic	Brass	Medium Duty	All brass torch parts with a copper head assembly having 4-hole design
K4000®	1000	360°	7 ft & 10 ft	Air-Cooled	Small & Ergonomic	Brass	Heavy Duty	All brass torch parts with a copper head assembly having 4-hole design
AirPro™ X4000	1000	360°	7 ft & 10 ft (2 m & 3 m)	Air-Cooled	Small & Ergonomic	Brass	Heavy Duty	All brass torch parts with a copper head assembly having 4-hole design, pneumatically operated upper arm
K-5	1250	340°	7 ft & 10 ft	Air-Cooled	Straight	Brass	Heavy Duty	All brass torch parts with a copper head assembly having 4-hole design
Tri-Arc®	2200	340°	7 ft & 10 ft	Air-Cooled & Water-Cooled	Straight	Copper	Heavy Duty	Versatility with three (3) different head assemblies to choose from to meet any metal removal application

## ANGLE-ARC® MANUAL GOUGING TORCHES

### FEATURES & BENEFITS

#### NATURAL 15° TORCH ANGLE

- Greater operator comfort

#### DURABLE FRONT INSULATORS

- High impact and heat resistant protecting the torch metal parts

#### 360° SWIVEL CABLE

- Less cable twist
- Less strain on operator

#### POSITIVE GRIP HANDLE

- Greater operator feel and ease in positioning the torch

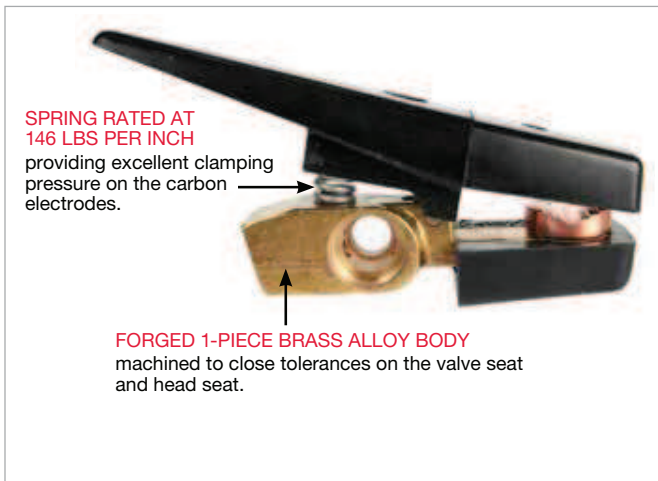
#### REDUCED WEIGHT

- Optimum cable and torch weight to minimize fatigue

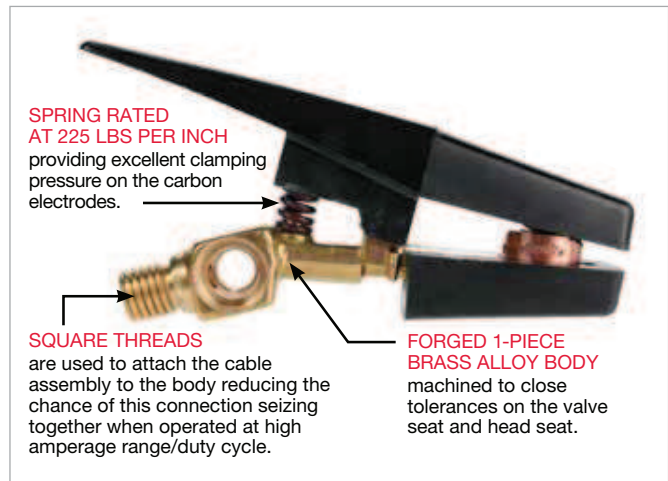
#### HIGH QUALITY CABLE HOSE

- Best quality cable hose offers high heat and abrasion resistance
- Non-conductive

### K3000

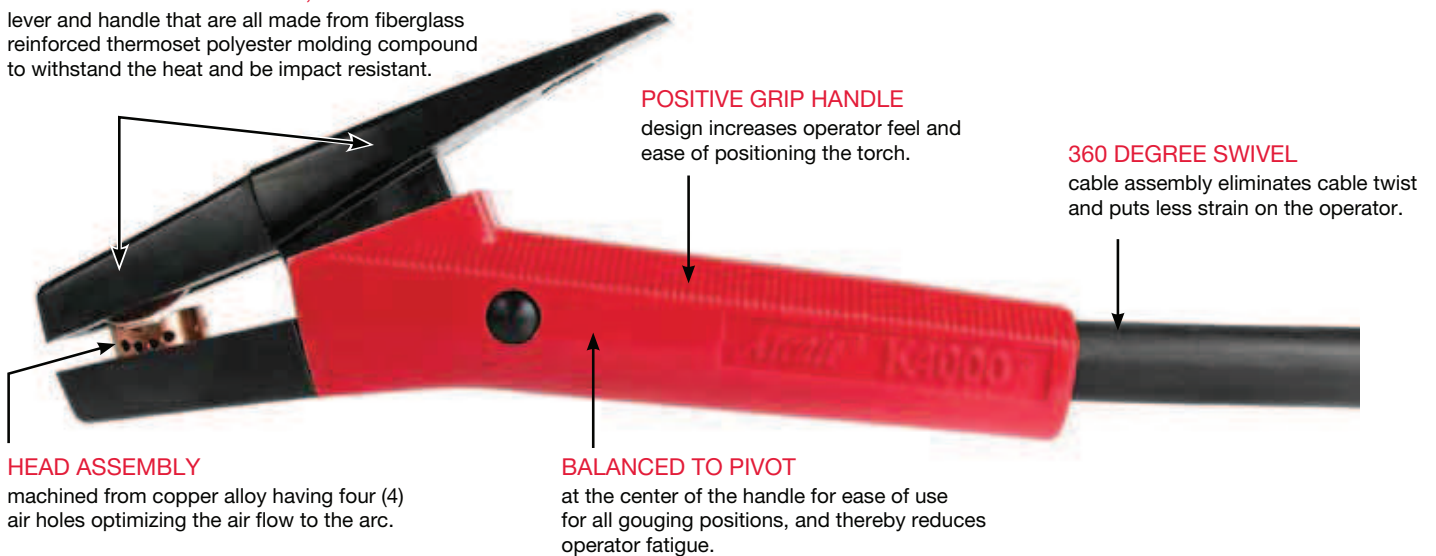


### K4000



#### HEAVY-DUTY INSULATORS,

lever and handle that are all made from fiberglass reinforced thermoset polyester molding compound to withstand the heat and be impact resistant.





## K3000™

Medium Duty - General repair and maintenance jobs such as mining, construction, and all types of metal fabrication.



### AMPERAGE RANGE

- 90 – 600 amps

### ELECTRODE SIZE

- Pointed – 1/8" – 3/8" round (3.2 mm – 9.5 mm)
- Jointed - 5/16" – 3/8" round (7.9 mm – 9.5 mm)
- Flat – 3/8" and 5/8" (9.5 mm – 15.9 mm)
- Half Round – 5/8" (15.9 mm)

### AIR REQUIREMENTS

- psi – 80
- kg/cm<sup>2</sup> – 5.6
- cfm – 22
- l/min – 624

Part No.	Description
01-065-001	Torch Only
61-065-006	Torch w/7 ft (2.1 m) 360° Swivel Cable
61-065-002	Torch w/7 ft (2.1 m) 360° Swivel Cable & Insulated Hook-Up Kit
61-065-007	Torch w/10 ft (3 m) 360° Swivel Cable
61-065-003	Torch w/10 ft (3 m) 360° Swivel Cable & Insulated Hook-Up Kit

## K4000®

Heavy Duty - Heavy metal removal applications such as weld preparations in pressure vessel shops and shipyards.



### AMPERAGE RANGE

- 90 – 1000 amps

### ELECTRODE SIZE

- Pointed – 5/32" – 1/2" round (4.0 mm – 12.7 mm)
- Jointed – 5/16" – 1/2" round (7.9 mm – 12.7 mm)
- Flat – 3/8" and 5/8" (9.5 mm – 15.9 mm)
- Half Round – 5/8" (15.9 mm)

### AIR REQUIREMENTS

- psi – 80
- kg/cm<sup>2</sup> – 5.6
- cfm – 25
- l/min – 708

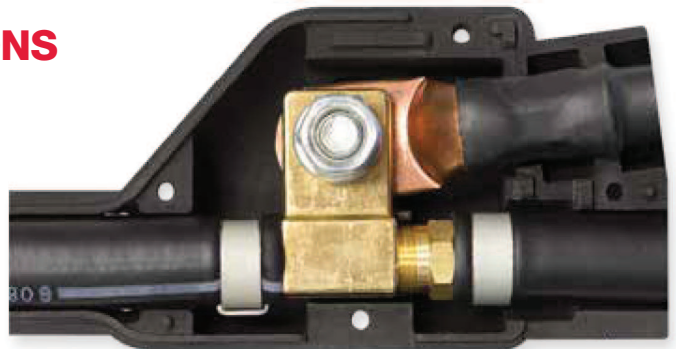
Part No.	Description
01-082-002	Torch Only
61-082-008	Torch w/7 ft (2.1 m) 360° Swivel Cable
61-082-006	Torch w/7 ft (2.1 m) 360° Swivel Cable & Insulated Hook-Up Kit
61-082-009	Torch w/10 ft (3 m) 360° Swivel Cable
61-082-007	Torch w/10 ft (3 m) 360° Swivel Cable & Insulated Hook-Up Kit

## SWIVEL CABLE ASSEMBLY OPTIONS

K3000 360° Swivel Cable



K4000 360° Swivel Cable



Part No.		Description
K3000	K4000	
70-088-107	70-084-207	7 ft (2.1 m) 360° Swivel Cable Assembly
70-088-110	70-084-210	10 ft (3 m) 360° Swivel Cable Assembly

## AIRPRO™ X4000 PNEUMATIC GOUGING TORCH & CABLE ASSEMBLY

### FEATURES & BENEFITS

#### EASY TO LOAD

- Uses compressed air to raise and lower the upper arm; no force required to load/unload electrodes

#### SIMPLE OPERATION

- To gouge, press the rocker switch and slide lock forward to lock in place to begin the airflow through the torch assembly; simply slide the lock back and release the rocker switch to stops

#### NO LEAKS

- Positive air valve to eliminate compressed air from leaking

#### POSITIVE GRIP HANDLE

- Greater operator feel and ease in positioning the torch

#### DURABLE FRONT INSULATORS

- High impact and heat resistance protecting the torch metal parts



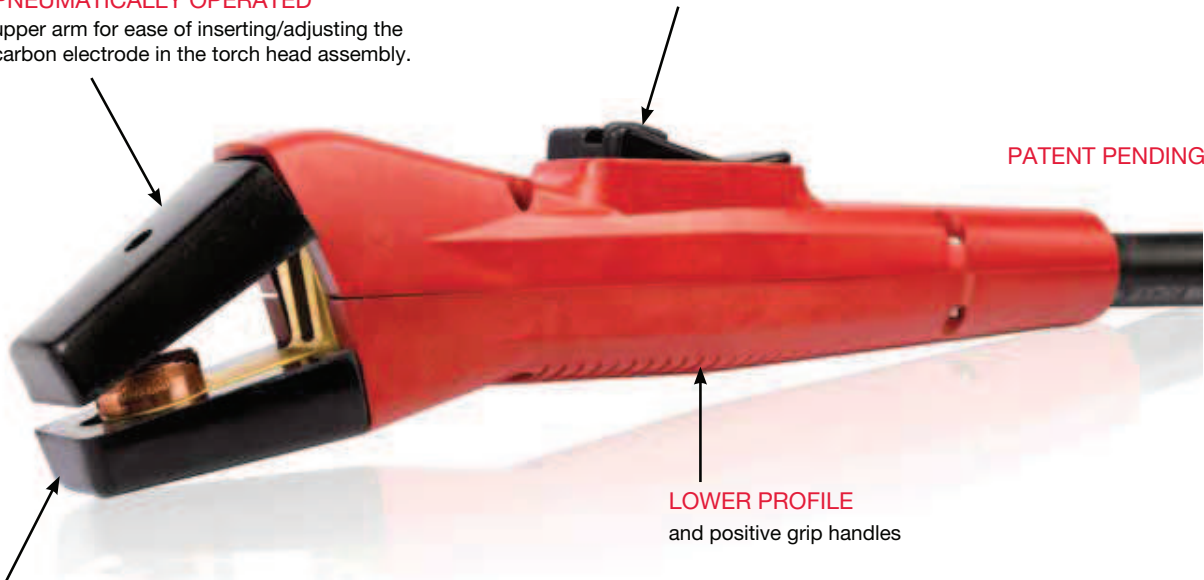
#### PNEUMATICALLY OPERATED

upper arm for ease of inserting/adjusting the carbon electrode in the torch head assembly.

#### ROCKER SWITCH

allowing the insertion/adjustment of the carbon electrode and compressed air on/off. No air flow through the torch and cable assembly without initiating flow through the rocker switch

PATENT PENDING



HIGH IMPACT,  
heat resistant insulators

LOWER PROFILE  
and positive grip handles

## AIRPRO™ X4000

Introducing the next generation air carbon-arc metal removal torch and cable assembly, AirPro X4000. The unique, patent-pending, pneumatically operated upper arm and air valve design eliminates air leakage through the torch and cable when turned off, making this torch assembly the best in the market.



### COMFORTABLE AND EASY TO USE

- Ship and Offshore Yards
- Civil Construction
- Pipe Construction
- Repair and Maintenance
- Heavy Fabrication
- Industrial and General Fabrication
- Mining
- Steel Erectors

### AMPERAGE RANGE

- 90 – 1000 amps

### ELECTRODE SIZE

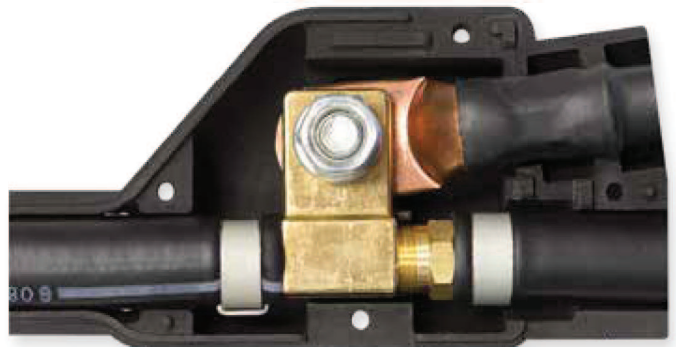
- Pointed – 3/16" – 1/2" round (4.7 mm – 12.7 mm)
- Jointed – 5/16" – 1/2" round (7.9 mm – 12.7 mm)
- Flat – 3/8" and 5/8" (9.5 mm – 15.9 mm)
- Half Round – 5/8" (15.9 mm)

### AIR REQUIREMENTS

- psi – 80
- kg/cm2 – 5.6
- cfm – 25
- l/min – 708

Part No.	Description
01-084-002	AirPro X4000 Torch Only
61-084-008	AirPro X4000 Torch & Cable Assembly 7 ft. (2.1 m) – 360° Swivel
61-084-006	AirPro X4000 Torch & Cable Assembly 7 ft. (2.1 m) – 360° Swivel & Insulated Hook-up Kit
61-084-009	AirPro X4000 Torch & Cable Assembly 10 ft. (3 m) – 360° Swivel
61-084-007	AirPro X4000 Torch & Cable Assembly 10 ft. (3 m) – 360° Swivel & Insulated Hook-up Kit

## SWIVEL CABLE ASSEMBLY



Part No.	Description
70-084-407	7 ft (2.1 m) 360° Swivel Cable
70-084-410	10 ft (3 m) 360° Swivel Cable
94-463-046	Quick Connect Hook-Up Kit

## TRI-ARC® FOUNDRY GOUGING TORCHES

### FEATURES & BENEFITS

#### THREE TORCHES IN ONE

- Designed for foundry applications, defect removal, general purpose applications, and padwashing by just changing head assemblies

#### HIGH IMPACT, HEAT RESISTANT INSULATORS

- Provides protection for the torch metal parts

#### FORGED BODY

- Provides cooler operation, improved air flow and greater current ratings

#### POWERFUL INSULATED COIL SPRING & HIGH STRENGTH UPPER ARM

- Insures positive electrode contact at all angles

#### BETTER BALANCE

- Streamline design and high strength fluted handles reduce operator fatigue

#### EASY CABLE INSTALLATION

- No need to disassemble the torch, just slide the sleeve from the rear of the handle

### TRI-ARC TORCH HEADS

#### DEFECT REMOVAL HEADS

- For removal of defects and fine removal application
- Accepts electrode diameters – 3/8" (9.5 mm) through 3/4" (19.05 mm)



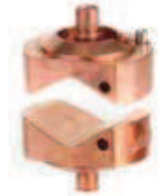
#### GENERAL PURPOSE CLEANING HEADS

- For removal of defects, fin removal, padwashing, and piercing applications
- Accepts electrode diameters – 1/2" (12.7 mm) through 1" (25.4 mm)



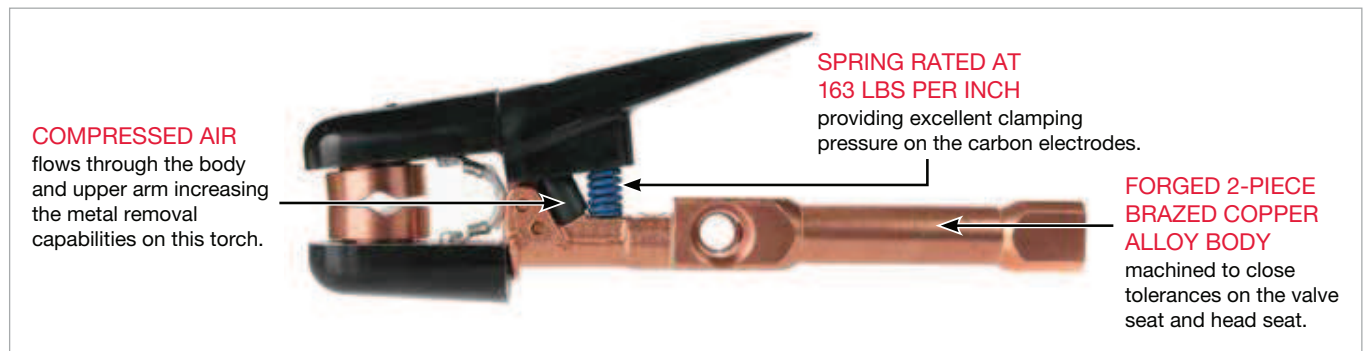
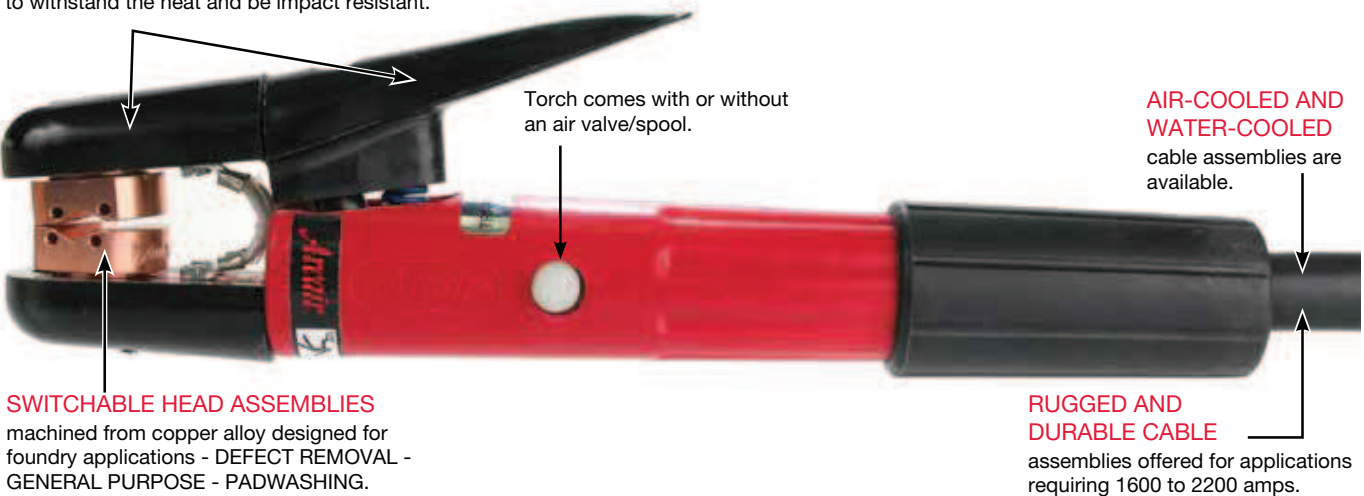
#### PADWASHING HEADS

- For padwashing applications only
- Heads are fixed on a 35° work angle
- Accepts electrode diameters – 1/2" (12.7 mm) through 3/4" (19.05 mm)



#### HEAVY-DUTY INSULATORS,

lever and handle that are all made from fiberglass reinforced thermoset polyester molding compound to withstand the heat and be impact resistant.



## TRI-ARC®

Foundry - General foundry work, pad washing, defect, nails, sprue and interior work



### AMPERAGE RANGE

- 450 – 2200 amps

### ELECTRODE SIZE

- 5/16" – 1" Round (7.9 mm – 25.4 mm)

### AIR REQUIREMENTS

- psi – 80
- kg/cm<sup>2</sup> – 5.6
- cfm – 33
- l/min – 934

Part No.	Description	Electrode Size
<b>NO HEADS IN TORCH</b>		
02-991-411	Torch Only	–
62-991-417	Torch & 7 ft (2.1 m) Cable	–
<b>NO HEADS IN TORCH – NO VALVE</b>		
02-991-426	Torch Only	–
<b>DEFECT REMOVAL HEADS</b>		
94-378-298	Replacement Heads	3/8" (9.5 mm) thru 3/4" (19.05 mm)
<b>PADWASHING HEADS</b>		
94-378-286	Replacement Heads	1/2" (12.7 mm)
94-378-289	Replacement Heads	5/8" (15.9 mm)
94-378-283	Replacement Heads	3/4" (19.05 mm)
<b>GENERAL PURPOSE CLEANING HEADS</b>		
94-378-267	Replacement Heads	1/2" (12.7 mm)
94-378-270	Replacement Heads	5/8" (15.9 mm)
94-378-273	Replacement Heads	3/4" (19.05 mm)
94-378-343	Replacement Heads	1" (25.4 mm)

Note: The cable assembly that comes standard on the assemblies is Part No. 74-143-607, 7 ft (2.1 m) long and rated for 1600 amperes maximum.

## SWIVEL CABLE ASSEMBLY OPTIONS



Part No.		Description
7 ft (2.1M)	10 ft (3M)	
74-143-607	74-143-610	Std. Duty - 340° Swivel Cable Assembly
74-161-907	–	E-H-D 340° Swivel Cable Assembly
74-085-207	74-085-210	Water-Cooled Cable Assembly – Non-Swivel



Part No.	Description
70-128-507	7 ft (2.1 m) 340° Swivel Cable Assembly
70-128-510	10 ft (3 m) 340° Swivel Cable Assembly

## STRAIGHT HANDLE MANUAL GOUGING TORCHES

### FEATURES & BENEFITS

#### RELIABLE TORCH DESIGN

- Market leader for over 60+ years
- Greater operator comfort

#### ACCEPTS A WIDE RANGE OF CCDC GOUGING ELECTRODES

- 5/16" (7.9 mm) - through 5/8" (15.9 mm) round

#### DURABLE FRONT INSULATORS

- High impact and heat resistant protecting the torch metal parts

#### SWIVEL CABLE

- Less cable twist
- Less strain on the operator

#### HIGH QUALITY CABLE HOSE

- Best quality cable hose offers high heat and abrasion resistance
- Non-conductive

#### RUGGED CONSTRUCTION OVERALL

- Can withstand harsh environments

### K-5

Extra Heavy-Duty - Heavy metal removal applications such as weld preparations in pressure vessel shops, shipyards and defect removal in foundries.



#### AMPERAGE RANGE

- 450 - 1250 amps

#### ELECTRODE SIZE

- Pointed - 5/16" - 1/2" round (7.9 mm - 12.7 mm)
- Jointed - 5/16" - 5/8" round (7.9 mm - 15.9 mm)
- Half Round - 5/8" (15.9 mm)

#### AIR REQUIREMENTS

- psi - 80
- kg/cm<sup>2</sup> - 5.6
- cfm - 30
- l/min - 850

Part No.	Description
01-104-003	Torch Only
61-104-007	Torch w/7 ft (2.1 m) 360° Swivel Cable
61-104-008	Torch w/10 ft (3 m) 360° Swivel Cable

## CUTSKILL MANUAL GOUGING TORCHES

### FEATURES & BENEFITS

#### NATURAL 15° TORCH ANGLE

- Greater operator comfort

#### DURABLE FRONT INSULATORS

- High impact and heat resistant protecting the torch metal parts

#### 360° SWIVEL CABLE

- Less cable twist
- Less strain on operator

#### POSITIVE GRIP HANDLE

- Greater operator feel and ease in positioning the torch

#### REDUCED WEIGHT

- Optimum cable and torch weight to minimize fatigue

#### HIGH QUALITY CABLE HOSE

- Best quality cable hose offers high heat and abrasion resistance
- Non conductive

### CSK4000

Heavy-Duty - Heavy metal removal applications such as weld preparations in pressure vessel shops and shipyards.



#### ELECTRODE SIZE

- Pointed - 5/32" - 1/2" round (4.0 mm - 12.7 mm)
- Jointed - 5/16" - 1/2" round (7.9 mm - 12.7 mm)
- Flat - 3/8" and 5/8" (9.5 mm - 15.9 mm)
- Half Round - 5/8" (15.9 mm)

#### AIR REQUIREMENTS

- Maximum Amperage - 1000 amps
- Compressed Air - 80 psi (5.6 kg/cm<sup>2</sup>)
- Compressed Air Flow Rate - 28 cfm (0.79 m<sup>3</sup>/min)
- Torch and Cable Weight: 5.4 lbs (2.4 kg)

Part No.	Description
01-088-000	Torch Only
61-088-007	Torch & 7 ft (2.1 m) Cable Assembly
61-088-010	Torch & 10 ft (3 m) Cable Assembly
70-088-007	7 ft (2.1 m) Cable Assembly
70-088-010	10 ft (3 m) Cable Assembly

# INCHES OF GROOVE PER ELECTRODE

## POINTED COPPERCLAD DC ELECTRODES

Groove Depth	5/32" x 12" (4.0 mm x 30.5 cm)	3/16" x 12" (4.8 mm x 30.5 cm)	1/4" x 12" (6.5 mm x 30.5 cm)	5/16" x 12" (8.0 mm x 30.5 cm)	3/8" x 12" (9.5 mm x 30.5 cm)	1/2" x 14" (12.7 mm x 35.6 cm)
1/8" (3.2 mm)	65" (165 cm)	70" (178 cm)	81" (206 cm)	NR	NR	NR
5/32" (4.0 mm)	57" (145 cm)	65" (165 cm)	70" (178 cm)	81" (206 cm)	NR	NR
3/16" (4.8 mm)	NR	57" (145 cm)	66" (168 cm)	72" (183 cm)	82" (208 cm)	NR
1/4" (6.4 mm)	NR	46" (117 cm)	58" (147 cm)	66" (168 cm)	72" (183 cm)	112" (285 cm)
5/16" (8.0 mm)	NR	20" (51 cm) – 2P	46" (117 cm)	58" (147 cm)	59" (150 cm)	100" (254 cm)
3/8" (9.5 mm)	NR	12" (30 cm) – 2P	24" (61 cm) – 2P	47" (119 cm)	59" (150 cm)	88" (224 cm)
1/2" (12.7 mm)	NR	NR	14" (36 cm) – 2P	26" (66 cm) – 2P	47" (119 cm)	73" (185 cm)
5/8" (15.9 mm)	NR	NR	NR	16" (41 cm) – 2P	26" (66 cm) – 2P	57" (145 cm)
3/4" (19.05 mm)	NR	NR	NR	NR	16" (41 cm) – 2P	43" (109 cm)
7/8" (22.0 mm)	NR	NR	NR	NR	NR	35" (89 cm) – 2P
1" (25.4 mm)	NR	NR	NR	NR	NR	28" (71 cm) – 2P

Note: All figures derived from gouging mild steel under laboratory conditions. Field results may vary due to type of metal, power source, compressed air supply,

operators experience and other parameters.

NR = Not Recommended

2P = Two (2) Passes

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Groove Depth	5/16" x 14" (7.9 mm x 35.6 cm)	3/8" x 17" (9.5 mm x 43.2 cm)	1/2" x 17" (12.7 mm x 43.2 cm)
5/32" (4.0 mm)	160" (406 cm)	NR	NR
3/16" (4.8 mm)	142" (361 cm)	206" (523 cm)	NR
1/4" (6.4 mm)	125" (318 cm)	172" (437 cm)	260" (660 cm)
5/16" (7.9 mm)	112" (284 cm)	150" (310 cm)	188" (478 cm)
3/8" (9.5 mm)	84" (213 cm)	136" (345 cm)	157" (399 cm)
1/2" (12.7 mm)	72" (183 cm) – 2P	103" (262 cm)	140" (356 cm)
5/8" (15.9 mm)	48" (122 cm) – 2P	75" (191 cm) – 2P	102" (259 cm)
3/4" (19.05 mm)	NR	57" (145 cm) – 2P	90" (229 cm)
7/8" (22.0 mm)	NR	NR	80" (203 cm)
1" (25.4 mm)	NR	NR	72" (183 cm)

Note: All figures derived from gouging mild steel under laboratory conditions. Field results may vary due to type of metal, power source, compressed air supply,

operators experience and other parameters.

NR = Not Recommended

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