

ELECTRODES / RODS

TECH NOTE:

Recommended oxygen pressures for all cutting electrodes is 80-150 PSI (5-10 kg/cm²). Optimum cutting pressure at the torch varies with material thickness. To find the needed pressure multiply depth in feet by .45 (meters by .105) and add result to recommended pressure below. A DC welding power supply set on straight polarity at 300-400 amps is recommended.

Plate Thickness		Oxygen Pressure	
in.	mm	PSI	kg/cm ^{2*}
Up to 1/2 in.	12.7	80	5.6
Up to 1 in.	25.4	100	7.0
Up to 3 in.	76.2	150	10.5

*To obtain kpa multiply PSI x 6.895



Sea Dragon Cutting Electrodes

42-075-005

Sea Dragon cutting rods (50 pieces) will burn most materials encountered in underwater cutting jobs. The Sea Dragon Rod can be used like other oxygen-arc cutting electrodes.

Specifications	
Dia. x Length	3/8 in. x 18 in. (9.5 mm x 458 mm)
Box Weight (lbs)	19



Arcair Tuff-Cote® Cutting Electrodes

42-059-008

Tubular steel oxygen-arc cutting electrodes (50 pieces) are coated with an arc stabilizing flux coating, then are waterproofed. The waterproof coating protects the flux from moisture absorption and provides electrical insulation.

Specifications	
Dia. x Length	5/16 in. x 14 in. (8 mm x 355.6 mm)
Box Weight (lbs)	14



Sea Jet® Cutting Electrodes

42-066-006

Sea Jet cutting electrodes (50 pieces) will burn ferrous and melt non-ferrous materials such as concrete, rock, barnacles and other sea growth. The Sea-Jet electrode can be used like other oxygen-arc cutting electrodes.

Specifications	
Dia. x Length	3/8 in. x 18 in. (9.5 mm x 458 mm)
Box Weight (lbs)	20



Arcair Sea-Cut® I Cutting Electrodes

42-059-007

Tubular steel design used for oxygen-arc cutting. These electrodes (50 pieces) are coated with a waterproof insulating material. They are not Flux coated.

Specifications	
Dia. x Length	5/16 in. x 14 in. (8 mm x 355.6 mm)
Box Weight (lbs)	14



Arcair Arcwater® Gouging Electrodes

42-059-006

These copper coated carbon/graphite electrodes (50 pieces) are especially made for the Arcwater process. Arcwater electrodes are waterproof with a white coating. Arcwater electrodes require 350 to 450 amperes for proper oxygen free burning.

Specifications	
Dia. x Length	5/16 in. x 9 in. (8 mm x 228.6 mm)
Box Weight (lbs)	14 approx.



Arcair Sea-Weld® Welding Electrodes

SEE BELOW

Arcair's improved Sea-Weld electrode is the answer to the need for structural fabrication and repairs requiring underwater wet welding. All position, flux coated Shielded Metal Arc Welding electrodes.

Specifications					
Order No.	Size (Dia.) Length - 14 in.	Current (Amps)	Burn Off Time 12 in. (305 mm)	Pieces Per Box	Box Weight (lbs)
42-024-002	1/8 in. (3.2 mm)	150-180	40-46 sec.	150	13
42-984-004	5/32 in. (4.0 mm)	170-210	44-56 sec.	100	13
42-034-007	3/16 in. (4.8 mm)	190-230	59-66 sec.	75	13