



# GEMINI CHAMFERTRODE

## Typical Applications And Characteristics

GEMINI CHAMFERTRODE electrodes are specially designed for powerfully effective cutting and grooving which can also be used for gouging and hole-piercing. It gives a concentrated, forceful arc capable of penetrating plates up to 2.5 mm. in thickness.

### Typical Data

#### Cutting on AC supply ( min. OVC 75)

Plate Material (mm)	∅(mm)	Current (A)	Cutting speed (cm/mm)
12 mild steel	2.6	130	7.0
12 mild steel	3.2	190	10.5
20 mild steel	4.0	280	8.5
25 mild steel	5.0	350	8.5

#### Grooving on DC (pole+) supply

Depth (mm)	∅(mm)	Current (A)	Grooving speed (cm/mm)
3	2.6	150	26
3	3.2	200	36
3	4.0	280	39
3	5.0	350	49

#### Piercing on AC supply

OVC (V)	Plate material (mm)	∅(mm)	Current (A)	Seconds to pierce	Hole size (mm)
75	6 mild steel	2.6	150	4	4
75	10 mild steel	3.2	200	5	7
75	20 mild steel	4.0	280	16	8
94	25 mild steel	5.0	350	11	10

#### Typical current parameters

AC or DC+				
∅/L (mm)	2.6/300	3.2/350	4.0/350	5.0/350
Current min/max(A)	120/150	160/200	200/280	280/350