



WASHINGTON ALLOY'S
Quality Management System is
Certified to **ISO 9001**
Cert # 05-R0925

USA Chamfer Rod

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



American Welding Society
Sustaining Company Member



ALLOY DESCRIPTION AND APPLICATION;

USA Chamfer Rods are used for gouging, beveling and veeing out of excess metal in ferrous and nonferrous materials. This rod is most commonly used for removing old weld metal and sharp edges prior to subsequent welding operation. USA Chamfer Rods may be used with little or no oxygen/air present. Our Chamfer Rods may be used with AC or DC- (straight polarity) on any welding machine. Use the recommended amperage and hold the electrode at a low angle 10-15°, pushing it forward while applying slight pressure on the work piece. One pass will produce a clean groove, removing material equal to the diameter of the rod itself. Deeper grooves may be attained by making multiple passes. These rods will produce a “blowing action” which removes all your unwanted materials (including dirt, grease, oil, rust etc.) from the base metal. It acts as a welding rod in reverse needing no gases or special equipment such as an air compressors or specialized electrode holder. Typical metals maybe Steels, low alloy steels, Stainless Cast Irons, Aluminum, and even copper base grades of base metals. DC - gives the fastest and cleanest of the two polarities.

TYPICAL WELDING PROCEDURES; DCEN or AC **OPTIMUM IN BOLD**

Diameter	Amps
3/32”	100- 120 -145
1/8”	145- 170 -220
5/32”	200- 230 -320
3/16”	325- 350 -375

AVAILABLE SIZES: All sizes are packaged in 40 lb. cartons
Or 48 lbs in 6 plastic tubes
Other sizes may be available – please inquire



SPECIFICATIONS; N/A

WA. ALLOY CO.

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