



MODI XL CUT

CUTTING & GOUGING ELECTRODE

CHARACTERISTICS : An electrode with special coating which gives a stable arc during the cutting and piercing processes. The kerfs are clean and narrow. Suitable for all positions. Almost no slag is produced.

APPLICATIONS : Suitable for cutting, gouging, chamfering of various grades of steels such as mild steels, low alloy steels, stainless steels and cast irons. Cuts are fairly smooth. There is no need of any supplementary gas like oxygen/acetylene or compressed air. Piercing of metals can be done in all positions.

RECOMMENDATIONS : Use correct technique, angle of electrode and recommended current. Re-dry the moist electrodes at 200°C for 30 minutes. After striking, swing the arc back & forth as in sawing.

CURRENT CONDITIONS : USE AC OR DC (-)

Size (mm)	3.15 X 350	4.0 X 450	5.0 X 450
Range (Amps.)	150-200	200-250	300-350

RECOMMENDED TECHNIQUES :

FOR PIERCING : Hold the electrode at 90° to the job. Apply push-in and pull-out technique .

FOR CUTTING : Hold the electrode at 45°. Press it on the job and use to & fro motion like sawing.



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