

## GROOVEES

### ◆ INTRODUCTION

Aufhauser GROOVEES is a high quality cored electrode with a special non-conductive heat resistance coating that allows it to be run at high amperages. It is much like a welding rod, only in reverse. The electrode will act as a blasting force, enabling the removal of unwanted metal. GROOVEES can slice, pierce or gouge ferrous and non-ferrous metals as well as stainless steels, cast iron, aluminum, and brass. It is excellent for removing old welds, enlarging openings, and smoothing sharp edges prior to welding.

### ◆ SPECIAL FEATURES

- no oxygen or air supply required.
- use with regular arc welding machines.
- Leaves a clean, smooth surface, requiring no additional preparation.
- Free from carbon contamination.



### ◆ PROCEDURE

Use AC or DC reverse polarity on regular welding machines. For **slicing**, strike an arc at the point where cut is to begin, holding the electrode at a 5 to 20 degree angle. Maintain electrode contact with the metal once the arc is struck, using a continuous up and down sawing motion. Do not allow an arc gap. For **piercing** holes, hold the electrode perpendicular to the work metal. Once arc is struck, push the electrode through until metal is completely pierced and remove immediately. To enlarge holes, move electrode in a circular motion, until desired diameter is reached. For **gouging**, hold the electrode almost parallel to the work. Use only a slight pressure to push the electrode forward to gouge metal. For deeper gouges, make several passes.

### ◆ PARAMETERS

Diameter	Length	Amperage
3/32"	14"	80-150
1/8"	14"	170-300
5/32"	14"	225-400
3/16"	14"	250-450
1/4"	14"	350-600