



# SUPRA TIG ROD-3



## Codification :

AWS SFA 5.12	EWCe-2
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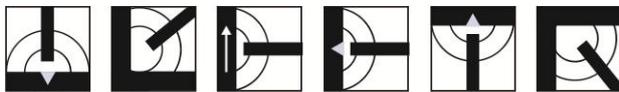
## Characteristics & Applications :

EWCe-2 is a Non consumable alloyed tungsten electrode with 2% Cerium oxide, easier the arc initiation, arc stability and reduced rate of vaporization or burn-off. It is non-radioactive material. These electrode operate successfully with AC or DC, either polarity.

## Typical Chemical Composition of Tungsten Electrodes (%):

Element	CeO <sub>2</sub>	W	Impurities
Typical	1.88-2.20	Balance	0.10 Max

## Welding Positions :



## Current And Packing Data :

Polarity	DCEN		DCEP		AC	
	Size (mm) Dia x Length	2.40x150	1.6x150	2.40x150	1.6x150	2.40x150
Current (Amps)	150-250	60-150	15-25	10-20	120-210	60-125
Qty (Pcs/Carton)	10	10	10	10	10	10

## Identification:

Grey colour ring on either end of electrodes.

## Instructions:

1. Grind the Tungsten electrode straight on the wheel specially designed for tungsten grinding (to avoid contamination & retain the hardness of electrode) Vs at 90 Deg. Angle to ensure grind marks run the length of the electrodes.
2. Grind the Taper on the Tungsten electrode to a distance not more than 2.5times the diameter of electrode.