

Tweco® Arcair®



Only ALL-Stainless Steel rod oven in welding

# ROD OVEN

TRB50

\$340.00 EA



Part No. /	TRB50
Electrode Capacity:	50 lbs. / 22.7Kg
Volts:	110
Thermostat:	Adjustable
Temperature Range:	150F-300F/60C - 150C
Element:	1 ea. 150 watt arc element for even heat distribution.
Cabinet:	Stainless Steel
Illuminated Power Indicator	
Dimensions:	23" x 9" x 11"
Shipping Weight:	30 lbs. / 13.6 Kg

AWS (Type)	Air Conditioned Storage Before Opening RH=Relative Humidity	Dry Rod Oven Holding Temperature After Opening	After Exposure to Moisture a Sufficient Amount of Time to Affect Weld Quality	
			Recommended Step #1	Recommended Step #2
Cellulose EXX10 EXX11 EXX20	70 - 120°F (21 - 43°C) 50% Max. RH	100 - 120°F (38 - 49°C)	Not Recommended	Not Recommended
Titania EXX12 EXX13 EXX14	70 - 120°F (21 - 42°C) 50% Max. RH	100 - 120°F (38 - 49°C)	180 - 230°F (82 - 110°C) 1/2 Hour	250 - 300°F (121 - 149°C) 1 Hour
Iron Powder m.s. EXX24 EXX27	70 - 120°F (21 - 42°C) 50% Max. RH	100 - 120°F (38 - 49°C)	180 - 230°F (82 - 110°C) 1/2 Hour	400 - 500°F (204 - 260°C) 1/2 Hour
Iron Powder Low Hydrogen EXX18 EXX28				
Low Hydrogen EXX15 EXX16	70 - 120°F (21 - 42°C) 50% Max. RH	250 - 300°F (121 - 149°C)	180 - 220°F (82 - 104°C) 1 - 1/2 Hour	650 - 750°F (343 - 399°C) 1 Hour
Low Hydrogen High Tensile EXXX15 EXXX16 EXXX18				
Stainless EXXX-15 EXXX-16	40-120°F (4.5 - 49°C) 60% (+/- 10) Max. RH	250 - 300°F (121 - 149°C)	180 - 220°F (82 - 104°C) 1 - 1/2 Hour	500 - 600°F (260 - 116°C) 1 Hour
Inconnel Monel Nickel Hard-Surfacing	40-120°F (4.5 - 49°C) 60% (+/- 10) Max. RH	150 - 200°F (66 - 93°C)	180 - 230°F (82 - 110°C) 1/2 Hour	Not Recommended
Brasses Bronzes	40-120°F (4.5 - 49°C) 60% (+/- 10) Max. RH	150 - 200°F (66 - 93°C)	Not Recommended	Not Recommended
Granulated or Agglomerated Flux	60% (+/- 10) Max. RH 40-120°F (4.5 - 49°C)	100 - 200°F (38 - 93°C)	Contact Manufacturer For Specific Temperatures	
Flux Cored Wire EXXT-1 EXXT-2 EXXT-5 EXXT-G	40-120°F (4.5 - 49°C) 60% (+/- 10) Max. RH	250 - 300°F (122 - 149°C)	Contact Manufacturer For Specific Temperatures	

**PHOENIX**

eliminate expensive rework & protect welding profits

## Guide to Electrode and Flux Stabilization

This table is offered as a general guide to proper storage and oven holding temperatures.

- Recondition/rebake procedures for electrode coatings exposed to moisture are included.
- Remove electrodes from cardboard containers before placing in ovens.
- Electrode coatings should not be exposed to the rebaking temperature without first being reconditioned at a lower temperature. Failure to do so may result in breakdown of electrode coatings. After REBAKING... lower temperature to HOLDING level until reissued.



## CRACK CHECK PRODUCTS

### LIQUID SOLVENT DYE PENETRANT SYSTEMS FOR NONDESTRUCTIVE TESTING

Crack Check Kit: Each of the kits contain two cans of Cleaner and one can each of Penetrant and Developer.

\$37.20 Nuclear Grade Aerosol Kit	#CCKNSA
\$25.60 Standard Grade Aerosol Kit	#CCKSNAK
\$5.95 Standard Grade Cleaner (Type C-NF) Nonflammable. 15.2 oz. Aerosol	#SGCCFOD
\$6.35 Standard Grade Developer (Type D-NF) Nonflammable. Detects the penetrant. 14.25 oz. Aerosol	#SGDDFOD

\$8.90 Nuclear Grade Cleaner (Type C-F) 8.5 oz. Aerosol #NGCCFOD Halogen and Sulfur free	
\$6.39 Nuclear Grade Developer (Type D-F) 9 oz. Aerosol #NGDDFOD Halogen and Sulfur free - Formulated to give the thinnest layer of developer to detect the penetrant.	
\$7.35 Nuclear/Standard Grade Penetrant (Type P-HF) Halogen and Sulfur free - For detecting cracks, fissures and porosity. 9oz. Aerosol	#NSPPFOD