

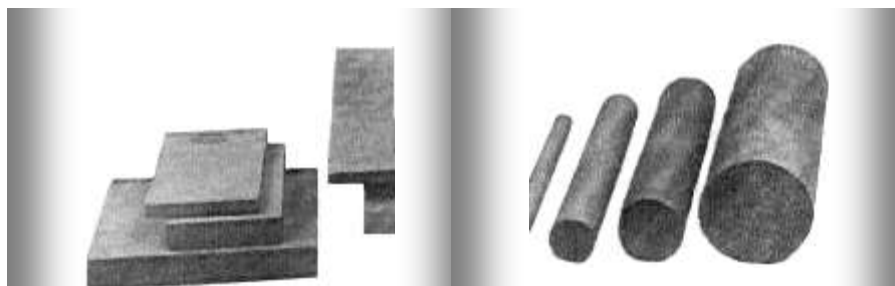


# Welding Carbon Products

A THERMADYNE Company



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Using carbon to control weld metal's flow - an old process is increasingly important in today's welding jobs.

Save time and money by using carbon rods, plates and paste as holding devices when you weld. Welding carbon products eliminate the need for many one-time jigs and fixtures. They are excellent dams or molds for weld deposits.

Welders, by their very nature, are creative people. Arcair carbon products promote that creativity by helping welders produce the quality weldments that are a first-class welder's trademark.

**CARBON PLATES:** Carbon plates are an excellent backup material when thin sections of metal are to be welded or brazed together or onto thicker sections. In the thin to thick application they are particularly useful, since most of the heat is transferred to the thin section. A section of carbon plate placed under the thin section will enable heat to flow more evenly throughout the joint. Carbon plates are very useful in aluminum welding; they prevent sagging of parts during the welding or brazing operation.

These versatile plates can also be used in forming dams and molds that ensure smooth straight corners and edges after weld repair.

By forming square corners with carbon plates, the welder can deposit weld metal and build up the missing section to correct dimensions with little finishing required. **For best results do not direct the arc at the carbon.** For a smooth surface, flow the metal against the sides formed by the carbon plates. These plates may be shaped by sawing, machining or using other methods to provide the correct contour for your application.



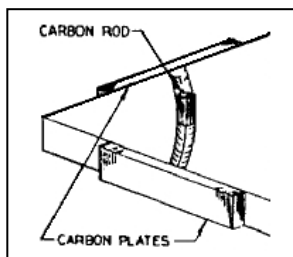
## CARBON PLATES

Size Inches	Part No.	UNIT PRICE
1/4 x 12 x 12	48-043-012	\$95.25 EA
3/8 x 12 x 12	48-063-012	\$161.00 EA
1/2 x 12 x 12	48-083-012	\$182.00 EA
3/4 x 12 x 6	48-123-006	\$131.00 EA
3/4 x 12 x 12	48-123-012	\$235.00 EA
1 x 12 x 12	48-163-012	\$269.00 EA

## CARBON RODS

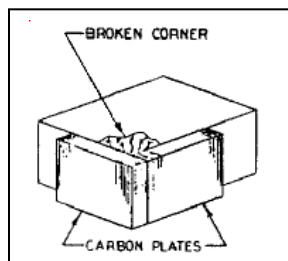
Size Inches	Part No.	UNIT PRICE
3/4 x 12	47-123-000	\$21.50 EA
7/8 x 12	47-143-000	\$29.95 EA
1 x 7	47-164-000	\$31.95 EA
1-1/8 x 12	47-183-000	\$80.26 EA
1-1/4 x 12	47-203-000	\$99.79 EA
1-1/2 x 12	47-243-000	\$115.81 EA
2 x 12	47-323-000	\$198.75 EA

**CARBON RODS:** These rods may be used as cores and fillers to prevent re-drilling holes that otherwise would be filled with weld metal during welding. Save time and money by threading the correct diameter of rod in the threaded holes, using normal threading methods. In most cases carbon rods can be reused.



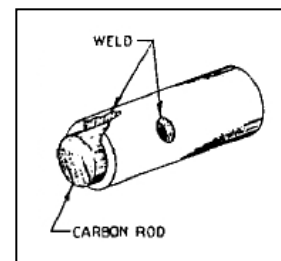
### REPAIRING A BROKEN SECTION WITH DRILLED HOLE IN BREAK:

1. Line up broken section and gouge crack with Air Carbon Arc, leaving 1/16" land.
2. Put a properly fitting carbon rod into drilled hole.
3. Place carbon plates at the end of the groove.
4. Do not apply arc directly on plates. Flow weld deposit against them to form square corner.
5. Remove rod and plates for further use.



### REPAIRING A BROKEN CORNER USING CARBON PLATES:

1. Wire brush broken edges to provide clean surface for weld deposit.
2. Cut sections from carbon plate and secure these sections with clamps or weights.
3. Fill the cavity with weld metal, taking care not to touch the carbon plates with the arc. The metal should be flowed into the corner to form a square edge.
4. Machine or grind repaired area.



### REPAIRING A PIPE SECTION WITH A CARBON ROD:

1. Insert a carbon rod into the pipe.
 

Note: The carbon rod can be machined to the diameter required.
2. Weld defective area and plug weld hole (see sketch).
3. Avoid putting the arc directly on the carbon, the rod may be removed intact for further use.
4. Machine or grind repaired area