

A close-up photograph of a welder wearing black protective gear and gloves, using a red and black torch to weld a metal joint. Bright orange sparks are flying from the point of contact. The welder's glove has the 'WELDLINE by Lincoln Electric' logo on it.

**WELDLINE**<sup>TM</sup>  
by Lincoln Electric

[www.weldline.eu](http://www.weldline.eu)

# CARBONAIR

PREMIUM ARC GOUGING CARBON ELECTRODES

# PREMIUM GRAPHITE COPPER COATED CARBON ELECTRODE



**CARBONAIR** and **CARBONAIR PLUS** arc gouging carbon electrodes contain an optimized composition blend of carbon and graphite. Available in multiple types and dimensions for use in a wide range of gouging applications. *Choose yours...*

## Performance

- First class metal removal rates.
- More consistent melt off rate allows for uniform, smooth grooves.
- Dense copper coating improves arc stability.
- High mechanical strength for improved durability.
- Constant quality for a safe process.

## Processes

CAC-A [gouging].

## Applications

Removing defective welds, preparing joints for welding, severing, pad washing, beveling.

## Dimensions

17 separate models ranging from 4 x 305 to 19 x 430.

## Carbon Electrode Types

- Pointed/Round
- Jointed
- Flat
- Hollow



# CARBONAIR

## Pointed electrodes

Versatile, multi-purpose, round, gouging electrodes (most popular type).



Diameter x length (mm)	Quantity per box	Gross weight per box (kg)	I mini (A)	I Max (A)	Air pressure (bars)	Airflow (m³/h)	To order
4 x 305	100	0.7508	150	200	5.0	10	W000010645
5 x 305	100	1.1582	200	300	5.0	10	W000010443
6.4 x 305	50	0.935	300	400	6.0	10,5	W000010444
8 x 305	50	1.4026	450	550	7.0	12	W000010445
10 x 305	50	1.9154	600	700	8.0	13	W000010446
13 x 305	50	3.4112	900	1100	9.0	14	W000010447

## Flat electrodes

Rectangular shape for close tolerance metal removal and/or rectangular grooves production.



Diameter x length (mm)	Quantity per box	Gross weight per box (kg)	I mini (A)	I Max (A)	Air pressure (bars)	Airflow (m³/h)	To order
5 x 15 x 305	50	2.1500	500	600	8.0	13	W202010453
5 x 18 x 355	25	1.6945	600	750	8.0	13	W202010454

## Hollow electrodes

Round electrode with hollow core allows for faster travel speed without sacrificing groove depth.



Diameter x length (mm)	Quantity per box	Gross weight per box (kg)	I mini (A)	I Max (A)	Air pressure (bars)	Airflow (m³/h)	To order
5 x 305	100	1.0472	200	300	5.0	10	W202010455
8 x 305	50	1.3394	450	550	7.0	12	W202010456
9.5 x 305	50	2.0554	500	700	7.0	12	W202010457
12.7 x 305	50	3.3476	850	1100	8.0	13	W202010458

# CARBONAIR PLUS

## Jointed electrodes

Round electrodes with male and female ends to eliminate stub loss

**Application:** Cutting Metal medium and heavy duty

This process requires a MMA direct current (DC) power source, a gouging torch and a compressed air source.



Diameter x length (mm)	Quantity per box	Gross weight per box (kg)	I mini (A)	I Max (A)	Air pressure (bars)	Airflow (m³/h)	To order
8 x 355	50	1.713	400	500	7.0	12	W000010448
10 x 430	50	3.0726	700	850	8.0	13	W000010449
13 x 430	50	5.0886	1000	1200	9.0	14	W000010450
16 x 430	25	3.8728	1300	1500	10.0	16	W000010451
19 x 430	25	5.3048	1500	1700	10.0	16	W000010452

# GOUGING TORCHES

## FLAIR™ 600 & 1600

- ◆ **360° rotating torch** The torch can rotate 360° on the monocable. This results in a comfortable and better freedom of movement.
- ◆ **Smooth finished body for perfect airflow** Manufactured with the greatest accuracy. The inner body is perfectly shaped which results in a perfect airflow, thus in a better cooling as well as a longer life time.
- ◆ **Highly conductive extruded body and nozzle (non-casted)** Better conduction and less heat development and consequently a longer product lifetime.
- ◆ **Thicker high heat resistant insulation** Longer product lifetime but also safer, more comfortable and more productive working conditions.
- ◆ **Flexible monocable (2.5 meter)** provides more ergonomical, comfortable working conditions.
- ◆ **The Airflow** can be regulated on the torch.



FLAIR® 600

To order W000010136

FLAIR® 1600

To order W000010118

### Technical characteristics:

Item Number	Output Power	Open arc voltage	Required Voltage	Compressed air	Electrode Diam Max
FLAIR® 600	600A@60%	> 60 VDC	35 - 56 VDC	400 ÷ 900 l/min @ 5 ÷ 7 bar	10mm - 3/8"
FLAIR® 1600	1600A@60%				19mm - 3/4"

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