THE HARRIS PRODUCTS GROUP
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TECHNICAL SPECIFICATION SHEET

HARRIS CUT ROD

ISO 9001
Cert. No. 31598

STATEMENT OF LIABILITY- DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

PERFORMANCE CHARACTERISTICS OF HARRIS CUT ROD:

Plate thickness is based on 1 inch plate

	MILD STEEL	CAST IRON	STAINLESS STEEL	BASIC PARAMETERS
SIZE	AMPS / IPM	AMPS / IPM	AMPS / IPM	AMPS
3/32	140 / 1.4	155 / 1.68	125 / 0.53	120-200
1/8	195 / 1.09	220 / 1.27	190 / 1.35	`160-240
5/32	215 / 1.50	250 / 1.31	235 / 1.92	180-300
3/16	305 / 2.48	315 / 1.88	300 / 2.55	240-400

CUTTING PROPERTIES:

Cut rod will cut through almost any type of metal Cast Iron, Aluminum, Stainless Steels, Nickel, Copper, Brass, Bonze, and many other ferrous and non-ferrous metals. The procedure is best performed in the flat position, using the rod in a 45° angle accompanied by a constant sawing motion, and maintaining a short arc as possible..

CHARACTERISTICS

Harris Cut Rod can be used by any welder to produce clean cuts in almost all materials. The burn off rate is slow so more Inches of cut can be produced per electrode. The metal cutting is due to a high arc temperature and pressure exerted by the hand pushing the rod against the metal. When piercing through a metal hold the rod vertical strike an arc and push the rod through the material, to increase the hole size use the same sawing motion and pressure in the cutting procedure. AC or DCEN.

*** All parameters are suggested as basic guidelines and will vary depending on joint design, number of passes and other factors.**

WARNING: PROTECT yourself and others. Read and understand this information.
FUMES AND GASES can be hazardous to your health.
ARC RAYS can injure eyes and burn skin.
ELECTRIC SHOCK can KILL.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDSs), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes,* published by the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402