

USER MANUAL

ELECTRO-AIR GOUGING TORCHES K3, K4, K5

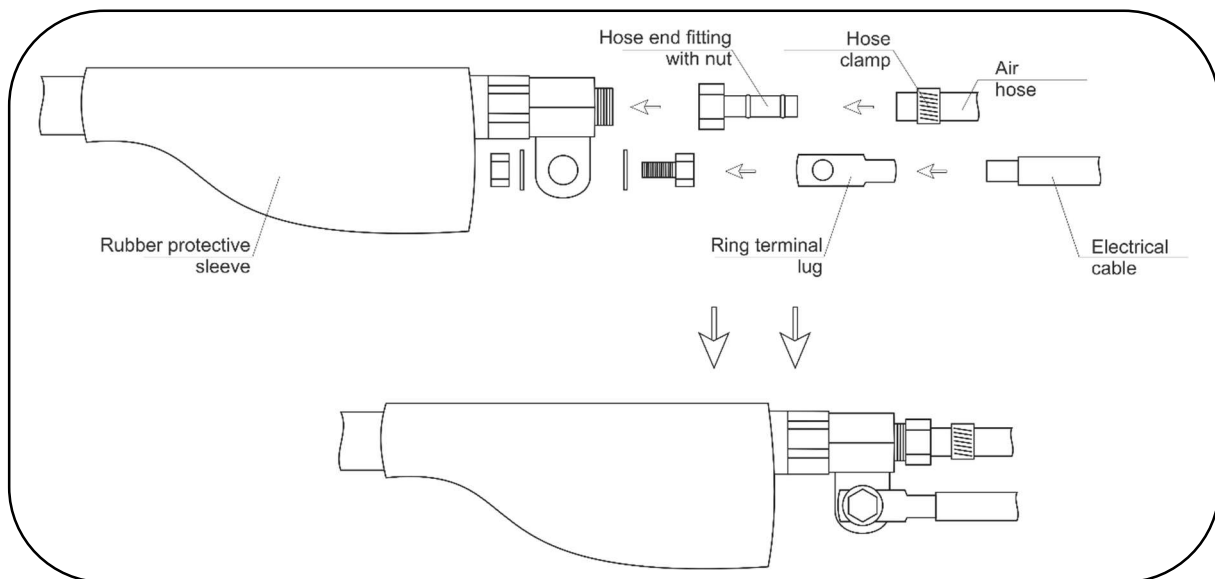


The torch is designed for electro-air gouging with round copper carbon electrodes. After replacing the current insert, it allows the use of flat electrodes. It is widely used in metallurgy in the processing of ingots, shipbuilding, regeneration of large elements, removal of defective sections of welds, beveling of sheet metal and removal of weld ridges.

SPECIFICATIONS

Torch Type	K3	K4	K5
Maximum gouging current	600 A	1000 A	1250 A
Duty cycle	60 %		
Compressed air pressure	3 – 8 bar		
Airflow	0.5 – 2 m ³ /min		
Range of crimped electrodes	φ 4 - 10 mm		φ 4 - 16 mm
Hose Assembly Length	2.1 m		

CONNECTING THE TORCH

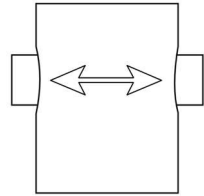


1. Slide the rubber cover at the end of the torch
2. Prepare a welding cable with a suitable cross-section, remove the insulation from it at a length of approx. 20 mm.
3. Clean the copper core from deposits and impurities.
4. Put on the eyelet and clamp it tightly on the cable.
5. Screw the eyelet tip onto the torch.
6. Slide the cable tie onto the compressed air hose.
7. Put the nut on the hose end and slide the end into the hose hole.
8. Tighten the cable tie.
9. Screw the hose end nut onto the torch.
10. Slide the rubber cover over to cover the connection.

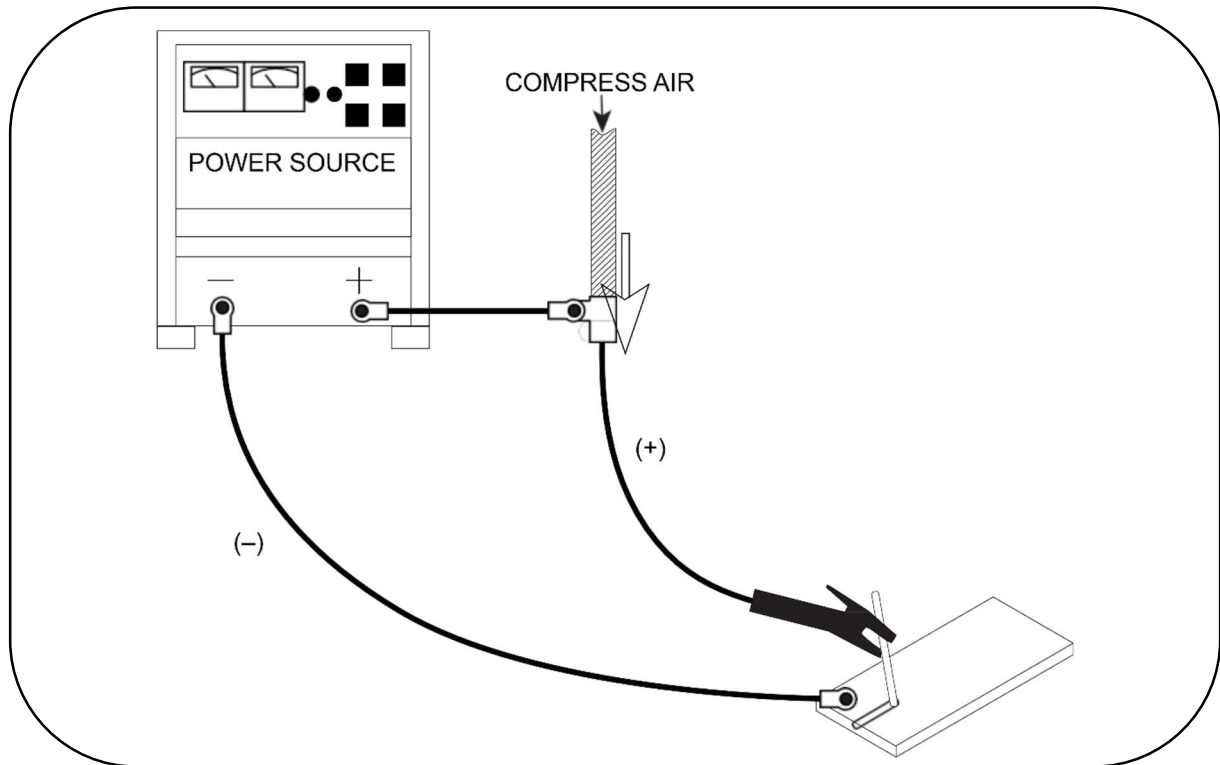
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COMPRESSED AIR CONTROL

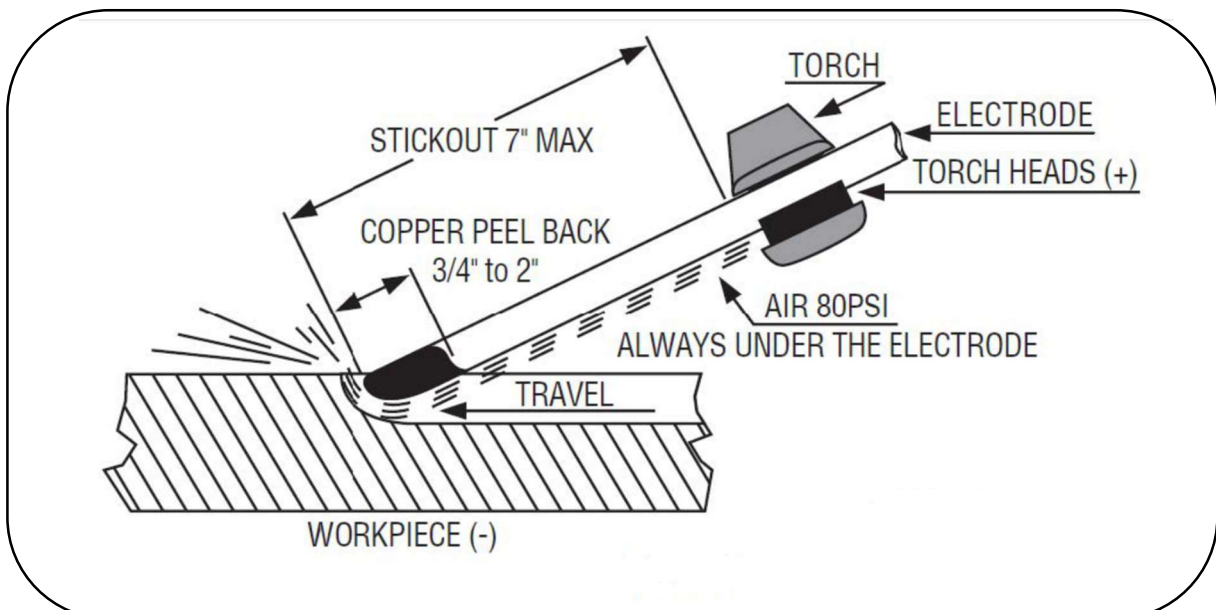
The torch is equipped with a sliding valve for opening and closing compressed air. The airflow is opened and closed when the valve arm is moved to the side.



GOUGING



1. Connect the torch to the positive terminal of the welder.
2. Insert the electrode into the holder so that its usable length is approx. 150 mm.
3. Open the valve of the compressed air supply hose. Start the welding machine, ignite the arc and guide the electrode at an angle of 50 degrees to the groove level. After the electrode has been heated to a length of approx. 50 mm, stop the gouging and extend the electrode to a length of approx. 150 mm.



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Table of approximate current ranges depending on the electrode.

Round electrodes	
Electrode Diameter (mm)	Gouging Current (A)
3	60 – 90
4	90 – 180
5	200 – 250
6	250 – 400
8	300 – 450
10	400 – 600
13	800 – 1000

Flat Electrodes	
Electrode Dimensions	Gouging Current (A)
3 x 25 mm	440 – 520
4 x 20 mm	500 – 600

TERMINATION

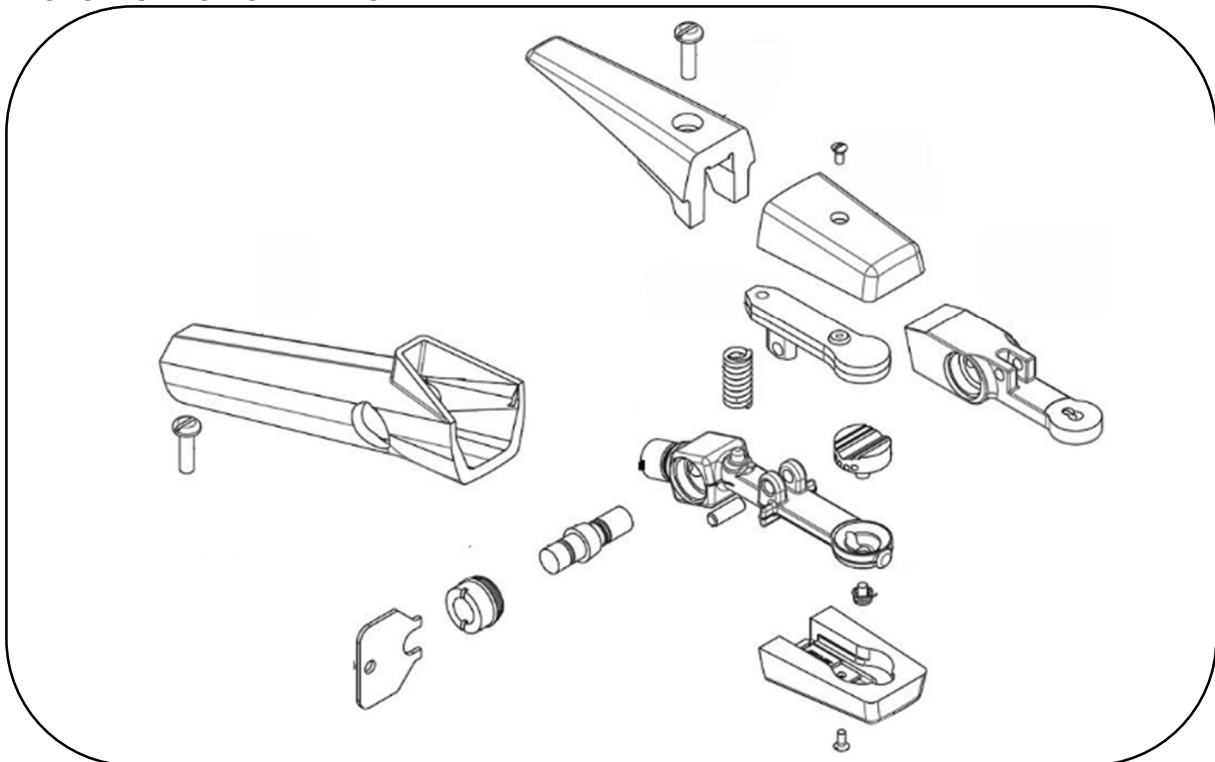
After completing the work, you should:

1. Close the valve at the torch.
2. Turn off the welding machine and remove the electrode from the holder.
3. Close the valve supplying air to the torch.
4. Open the valve in the torch and release the air from the hose.

OPERATION

Clean the electrode mount insert regularly and remove spatter from the holder, especially around the airflow outlet from the holder.

CONSTRUCTION OF THE TORCH



If you intend to dispose of this product, do not dispose of it with ordinary household waste. According to the WEEE Directive (Directive 2012/19/EU) in force in the European Union, separate disposal methods must be used for used electrical and electronic equipment. In Poland, in accordance with the provisions of the Act of 11 September 2015 on Waste Electrical and Electronic Equipment, it is prohibited to place waste equipment marked with the crossed-out bin symbol together with other waste.