

# Chamfer 204

Shielded Metal Arc Cutting  
(SMAC) Stick Electrode

Gouging Electrode

AC/DCEN  
All Position



*"The Royal Line"*

**CROWN** ALLOYS COMPANY

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## Premium High Speed Chamfering and Gouging Electrode for All Metals

### Typical Applications

**Chamfer 204** works well with all types of welding machines with sufficient capacity. The special coating or flux produces a forceful arc-blow which eliminates the need for compressed air or oxygen.

**Chamfer 204** is an excellent electrode for scarfing, gouging and veeing of both ferrous and non-ferrous metals. It is used to remove unwanted or defective weld deposits, vee out cast iron prior to welding and reduce large areas of metal prior to machining. When chamfering cast iron, it not only produces a clean groove but the powerful arc "sears" the base metal and burns out grease, oil, moisture and some of the excess carbon which can produce a hard, brittle, porous weld that is difficult to machine.

### Specifications

- Current AC or DC straight polarity (DCEN)

### Procedure

The use of DC straight polarity (DCEN) will produce the cleanest, fastest grooves. However, AC may also be used. Turn amperage high. Hold the electrode at a low angle to the work (about 15°). Strike an arc and push the electrode in the direction of the desired groove. Keep the electrode in contact with the work and move as fast as possible. The maximum depth of any single groove should not be greater than the diameter of the core rod. If a deeper groove is desired, successive passes should be made until the desired depth is obtained.

### Sizes, Amps and Part Numbers

Diameter	Amps	Part Numbers	
		1# Package	25# Package
1/8	200 - 350	ME204/EO-BP	ME204/EO
5/32	250 - 400	ME204/EP-BP	ME204/EP
3/16	300 - 550	ME204/EQ-BP	ME204/EQ



**!!!! WARNING !!!!**



**WELDING FUMES AND GASES CAN BE DANGEROUS TO YOUR HEALTH.**

**BEFORE USING THIS PRODUCT THE WELDER (END-USER) MUST READ AND UNDERSTAND THE COMPLETE PRODUCT WARNING LABEL AND THE NEW 16 SECTION SAFETY DATA SHEET (SDS).**

**THE SAFETY DATA SHEET (SDS) WHICH OUTLINES THE POTENTIAL HEALTH HAZARDS AND SAFETY INFORMATION RELATED TO THIS PRODUCT CAN BE DOWNLOADED FROM THE SDS PORTION OF THIS WEBSITE. IT IS ALSO AVAILABLE FROM YOUR EMPLOYER AND WELDING SUPPLY DISTRIBUTOR.**

**DO NOT PROCEED WITH USE OF THIS PRODUCT UNTIL YOU READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) AND PRODUCT WARNING STATEMENT.**

**BE SURE TO CONSULT THE LATEST VERSION OF THE SDS.**

**SEE THE PRODUCT WARNING LABEL AND SDS FOR COMPLETE WARNING INFORMATION.**

