

Carbon Arc Gouging

STORMTM torch

BY **GOUGE TECH**[®]
a Division of Flame Technologies, Inc.

STORM TORCH (ST4000)

Utilizing superior designs and quality craftsmanship, the Storm Torch[™] is the best choice when choosing an arc gouging torch. Storm Torch[®] works with the normal motions and angles of the wrist and arm to enable easy, comfortable metal removal while arc gouging. This quality tool delivers performance and reliability. Combined with Gouge Tech[®] high performance hollow carbon Lightning Rods[™], the Storm Torch[™] is the optimal performer!



Natural 15° Torch Angle
Greater Operator Comfort

360° Swivel Cable
Less Cable Twist

Positive Grip Handle
Less Strain On Operator

Balanced Weight
Optimum Cable and Torch Weight to Minimize Fatigue

High Quality Cable Hose
Best Quality Cable Hose Offers High Heat
and Abrasion Resistance

Rugged Construction
Overall Rugged Construction for the Harsh Environment

STORMTM torch

ACCEPTS

- Pointed Carbons:
5/32" (4mm) to 1/2" (13mm)
- Flat Carbons:
3/8" (10mm) to 5/8" (16mm)

AMPERAGE

- Maximum 1000 Amps

COMPRESSED AIR

- Pressure:
80 PSI (5.6 Kg/cm²)
- Flow Rate:
28 cfm (0.79 m³/min)

TORCH & CABLE WEIGHT

- 5.4 lbs. (2.4 Kg)

LIGHTNING RODS™ FOR STORM TORCH™

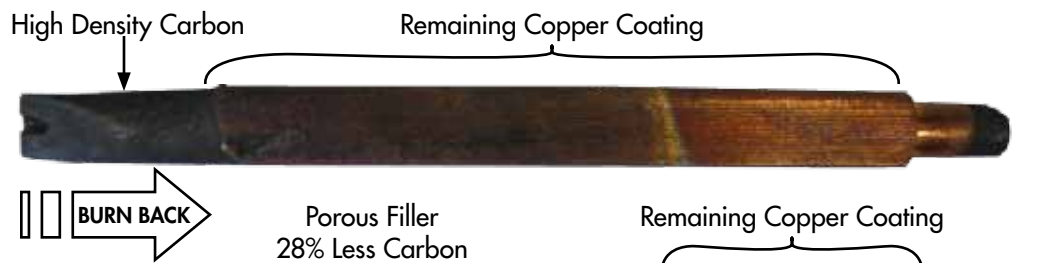
LIGHTNING ROD

- 50%+ Faster Compared to Solid DC Copper Coated Rods
- More Gouging-Inches Per Minute of Operation (Increased Productivity)
- Cleaner, Smoother, Reduced Smoke



With larger diameter rods, the Lightning Rod™ doesn't turn red and burn back as fast as conventional rods. The Lightning Rod™ uses high density carbon surrounded by a thicker layer of copper. This feature provides enhanced arc stability and increased current for faster metal removal with less stub end loss. Picture below illustrates the burn back properties of the Lightning Rod™ versus standard carbon rods. The Lightning Hollow Core Jointed Rods have a tighter joint connection allowing efficient current transfer. With standard jointed rods the connection is loose causing the joint to heat-up, turn red and prematurely break off during the gouging process.

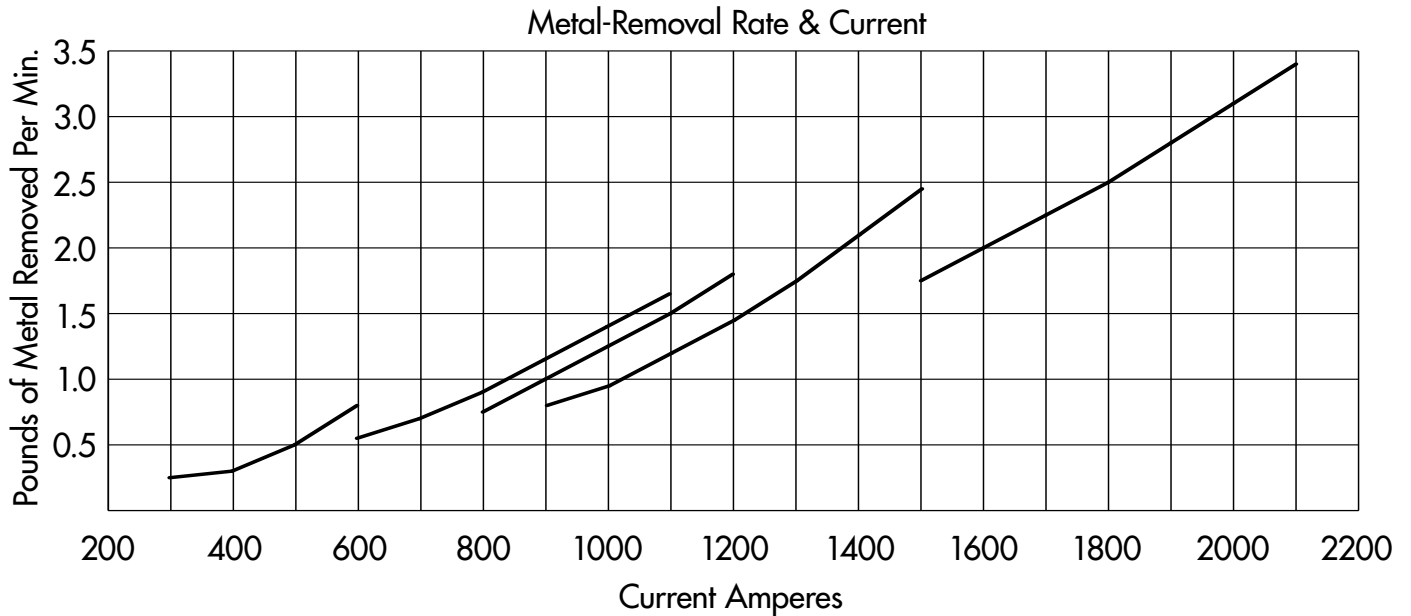
**Gouge Tech®
Hollow Core
Lightning Rod™**



**Popular Brand
Solid Core Rod**

Both 1/2" rods are were run at the same amperage, for the same length of time.

THE LIGHTNING ROD™ ADVANTAGE



Metal-removal rate is directly related to current. As shown in graph above, when current doubles, the metal removal rate increases four times. For example, at 1,400 amps a 3/4 inch rod removes twice as much metal per minute as at 1,000 amps. The graph is based on typical foundry conditions. Specific applications may extend or limit the range of any rod

diameter or length actually used. The Lightning Rods™ can carry increased currents of 15 to 20% more due to the copper coating, high density carbon and the extruded hole. This has shown to provide smooth arc stability on all metals. When your prime requirement is a smooth finish, select the largest diameter Lightning Rod™ for the available power supply.

CURRENT REQUIREMENTS

LIGHTNING ROD™ DIAMETER	5/32" (4MM)	3/16" (5MM)	1/4" (6MM)	5/16" (8MM)	3/8" (10MM)	1/2" (13MM)	5/8" (16MM)	3/4" (19MM)	1" (25MM)
Min. Amps	90	200	300	350	450	800	1000	1250	1600
Max. Amps	150	250	400	450	600	1000	1250	1600	2200

RECOMMENDED AIR REQUIREMENTS

TYPE OF TORCH	AIR PRESSURE		AIR CONSUMPTION		CONTINUOUS		ASME RECEIVER SIZE	
	PSI	KPA	CFM	L/MIN	HP	KW	GAL	LIT.
Light Duty	40	280	8	227	1.5	1.1	60	227
General Duty	80	550	25	708	7.5	5.6	80	303
Multipurpose	80	550	33	934	10	7.5	80	303
Automatic	60	414	46	1303	15	11.2	80	303

LIGHTNING ROD™ ORDERING INFORMATION

When purchasing rods, they must be ordered in quantities equal to whole cartons or whole cases. However, you will need to tell the customer service person the total number of rods you wish to order, not the number of cartons or cases. Please refer to the chart below to declare how many rods you wish to order.

MINIMUM ORDER SIZE IS ONE WHOLE CARTON QUANTITY OF RODS

HOW PACKAGING WORKS

- Rods are packed into boxes. Boxes are the smallest quantity sold to end users.
- Boxes are packed into cartons, so as to create a stable and safe group of boxes. This prevents rods from breaking while in shipment.
- Cartons are packed into cases for easier handling of many cartons.

Sizes and Ordering Quantities Chart

STANDARD RODS	Part Number	Rods/Box	CARTON PACKAGING			CASE PACKAGING		
			Boxes/Carton	Rods/Carton	Weight (lbs)	Cartons/Case	Rods/Case	Weight (lbs)
5/32" × 12" (4.0mm × 305mm)	GT532X12	100	5	500	9	4	2,000	33
3/16" × 12" (4.8mm × 305mm)	GT316X12	50	5	250	7	8	2,000	53
1/4" × 12" (6.4mm × 305mm)	GT14X12	50	5	250	12	4	1,000	48
5/16" × 12" (7.9mm × 305mm)	GT516X12	50	5	250	16	4	1,000	64
3/8" × 12" (9.5mm × 305mm)	GT38X12	50	5	250	17	2	500	33
1/2" × 12" (12.7mm × 305mm)	GT12X12	50	5	250	38	1	250	38

JOINTED RODS	Part Number	Rods/Box	CARTON PACKAGING			NO CASE PACKAGING		
			Boxes/Carton	Rods/Carton	Weight (lbs)	Cartons/Case	Rods/Case	Weight (lbs)
3/8" × 17" (9.5mm × 431mm)	GTJ38X17	50	6	300	41	N/A	N/A	N/A
1/2" × 17" (12.7mm × 431mm)	GTJ12X17	50	4	200	45	N/A	N/A	N/A
3/4" × 17" (19.1mm × 431mm)	GTJ34X17	25	4	100	45	N/A	N/A	N/A