

# PARAMETER GUIDE FOR DOWNHAND BASIC CORED WIRES

Ø 1.6 mm / 1/16 Inch



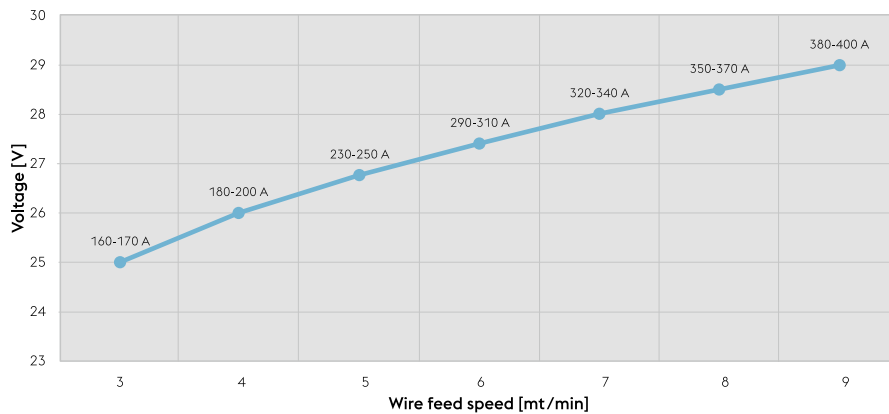
Wire feed speed		Arc voltage	Welding current	Arc mode
(m/min.)	(inch/min.)	(V)	(A)	
3	118	24.5-25.5	160-170	Short arc
4	157	25.5-26.5	180-200	Globular arc
5	197	26.5-27	230-250	Globular arc
6	236	27-27.5	290-310	Spray arc
7	276	27.5-28	320-340	Spray arc
8	315	28-28.5	350-370	Spray arc
9	354	28.5-29	380-400	Spray arc

**Chart valid for:**

- BÖHLER Kb 46 T-FD
- BÖHLER Kb 52 T-FD
- BÖHLER Kb Ni1Cu T-FD
- BÖHLER CM5 Kb T-FD
- BÖHLER DCMS Kb T-FD
- BÖHLER Kb 60 T-FD
- BÖHLER Kb 65 T-FD
- BÖHLER Kb 85 T-FD
- BÖHLER Kb 90 T-FD
- BÖHLER DMO Kb T-FD
- BÖHLER CM2 Kb T-FD
- BÖHLER DCMV Kb T-FD
- BÖHLER Kb 85 T-FD

Polarity: DC+      Stickout: 20mm/0.8"      Shielding gas: M21

## Welding parameters Ø 1.6 mm / 1/16 Inch



### How to use:

- » Welding parameters are valid for the recommended polarity, stickout length and shielding gas.
- » First set wire feed speed and voltage according to the diagram, then fine-tune according to the table.
- » Variations in stickout length will change the welding current.
- » Values shown on welding machine displays may be higher than the actual arc voltage due to the voltage drop in welding cables.
- » Add 1.5-2V arc voltage for C1.