

PARAMETER GUIDE FOR ALL-POSITIONAL METAL CORED WIRES

Ø 1.6 mm / 1/16 Inch

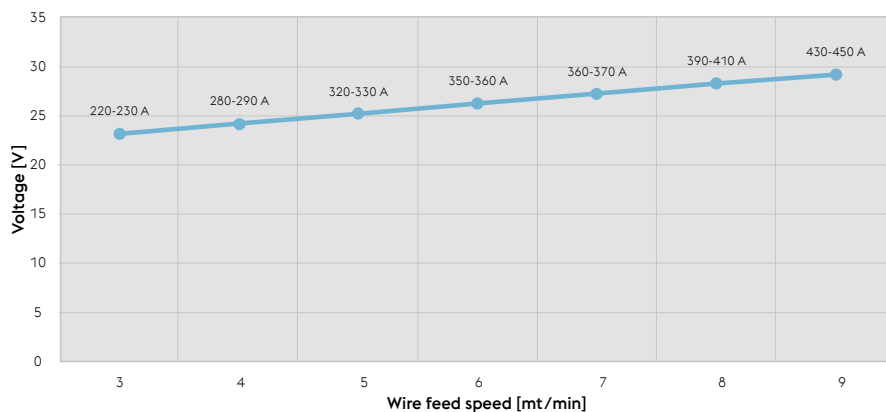


Wire feed speed		Arc voltage	Welding current	Arc mode
(m/min.)	(inch/min.)	(V)	(A)	
3	118	23-24	220-230	Short arc
4	157	24-25	280-290	Globular arc
5	197	25-26	320-330	Globular arc
6	236	26-27	350-360	Spray arc
7	276	27-28	360-370	Spray arc
8	315	28-29	380-410	Spray arc
9	354	29-30	430-450	Spray arc

Chart valid for:
BÖHLER HL 46 T-MC
BÖHLER HL 51 L-MC
BÖHLER HL 51 T-MC
BÖHLER NiCu1 T-MC
BÖHLER HL 53 T-MC
BÖHLER HL 65 T-MC
BÖHLER HL 75 T-MC
BÖHLER DMO T-MC
BÖHLER DCMS T-MC
BÖHLER CM2 T-MC
BÖHLER X70 L-MC
BÖHLER alform® 700 L-MC

Polarity: DC+ Stickout: 20 mm/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.