

# PARAMETER GUIDE FOR ALL-POSITIONAL RUTILE CORED WIRES

Ø 1.0 mm / .039 Inch



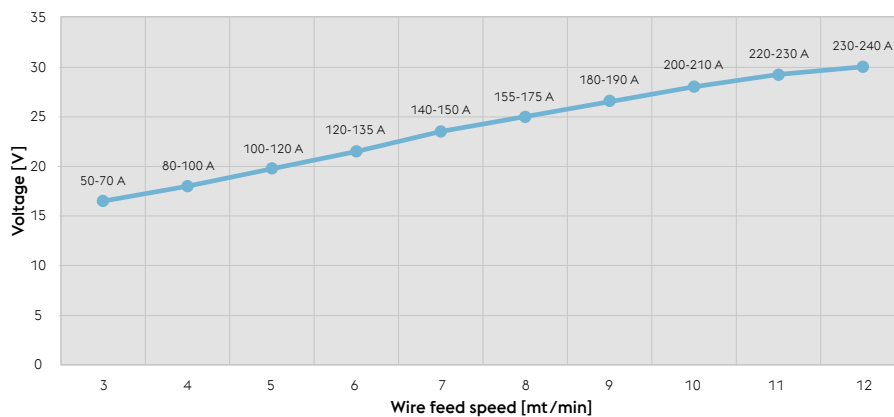
Wire feed speed		Arc voltage	Welding current	Arc mode
(m/min.)	(inch/min.)	(V)	(A)	
3	118	16-17	50-70	Globular - spray arc
4	157	17-18	80-100	Globular - spray arc
5	197	19-20	100-120	Globular - spray arc
6	236	21-22	120-135	Globular - spray arc
7	276	23-24	140-150	Spray arc
8	315	24-25	155-175	Spray arc
9	354	26-27	180-190	Spray arc
10	394	28-29	200-210	Spray arc
11	433	29-30	220-230	Spray arc
12	472	29-31	230-240	Spray arc

### Chart valid for:

BÖHLER Ti 42 T-FD  
BÖHLER Ti 46 T-FD  
BÖHLER Ti 52 T-FD  
BÖHLER Ti 52 T-FD (CO<sub>2</sub>)  
BÖHLER Ti 52 T-FD (HP)  
BÖHLER NiCu1 Ti T-FD  
BÖHLER Ti 60 T-FD  
BÖHLER Ti 80 T-FD

Polarity: DC    Stickout: 15 mm/0.6"    Shielding gas: M21

### Welding parameters Ø 1.0 mm / .039 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.