

# PARAMETER GUIDE FOR ALL-POSITIONAL RUTILE CORED WIRES

Ø 1.4 mm / .052 Inch

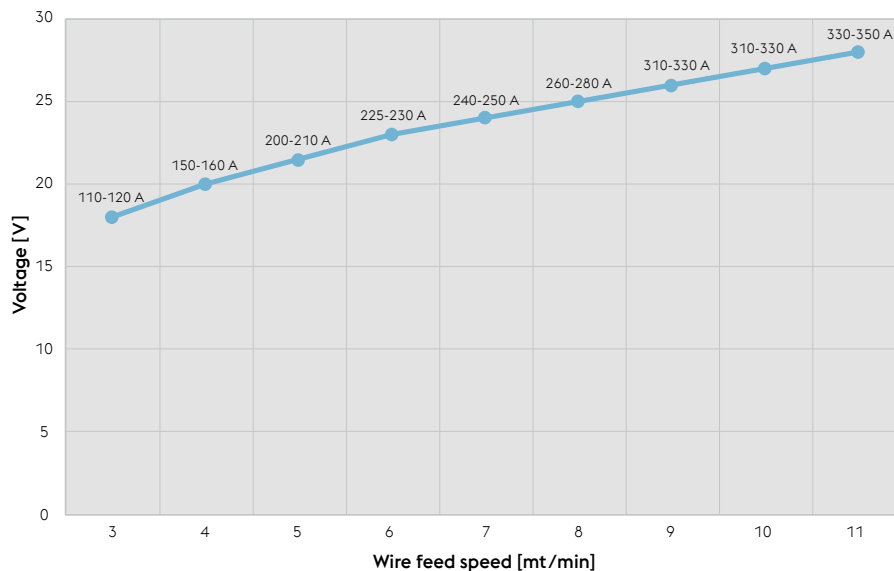


Wire feed speed (m/min.)	(inch/min.)	Arc voltage (V)	Welding current (A)	Arc mode
3	118	16-17	110-120	Globular-spray arc
4	157	17-19	150-170	Spray arc-spray arc
5	197	19-21	200-210	Spray arc-spray arc
6	236	21-22	220-230	Spray arc
7	276	23-24	240-250	Spray arc
8	315	25-26	260-280	Spray arc
9	354	26-27	290-310	Spray arc
10	394	28-29	310-330	Spray arc
11	433	29-30	330-350	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 (HP)
BÖHLER Ti 52 T-FD (CO <sub>2</sub> )
BÖHLER Ti 52 T-FD SR (CO <sub>2</sub> )
BÖHLER NiCu1 Ti T-FD
BÖHLER Ti 60 T-FD
BÖHLER Ti 60 T-FD (CO <sub>2</sub> )

Polarity: DC+    Stickout: 15-20 mm/0.6-0.8"    Shielding gas: M21

## Welding parameters Ø 1.4 mm / .052 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.