

PARAMETER GUIDE FOR DOWNHAND BASIC CORED WIRES

Ø 1.2 mm / .045 Inch

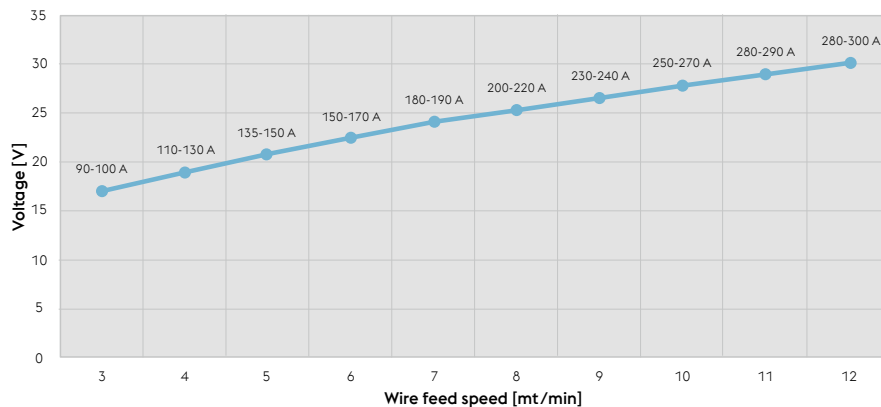


Wire feed speed		Arc voltage	Welding current	Arc mode
(m/min.)	(inch/min.)	(V)	(A)	
3	118	17-18	90-100	Short arc
4	157	18-19	110-130	Short arc
5	197	20-21	135-150	Globular arc
6	236	22-23	150-170	Globular arc
7	276	23-24	180-190	Globular arc
8	315	25-26	200-220	Globular arc
9	354	26-27	230-240	Spray arc
10	394	27-28	250-270	Spray arc
11	433	28-29	280-290	Spray arc
12	472	29-30	280-300	Spray arc

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

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

Welding parameters Ø 1.2 mm / .045 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.