

PARAMETER GUIDE FOR ALL-POSITIONAL METAL CORED WIRES

Ø 1.4 mm / .052 Inch



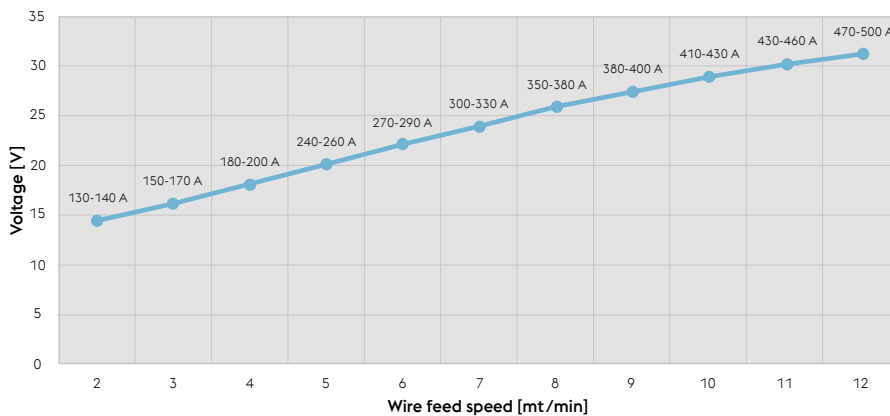
Wire feed speed (m/min.)	(inch/min.)	Arc voltage (V)	Welding current (A)	Arc mode
2	79	14-15	130-140	Short arc
3	118	15-16	150-170	Short arc
4	157	18-19	180-200	Globular arc
5	197	20-21	240-260	Globular arc
6	236	22-23	270-290	Spray arc
7	276	23-24	300-330	Spray arc
8	315	25-26	350-380	Spray arc
9	354	26-27	380-400	Spray arc
10	394	27-28	410-430	Spray arc
11	433	28-29	430-460	Spray arc
12	472	30-31	470-500	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 X70 L-MC
 BÖHLER alform® 700 L-MC

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.