

PARAMETER GUIDE FOR ALL-POSITIONAL METAL CORED WIRES

Ø 1.0 mm / .039 Inch



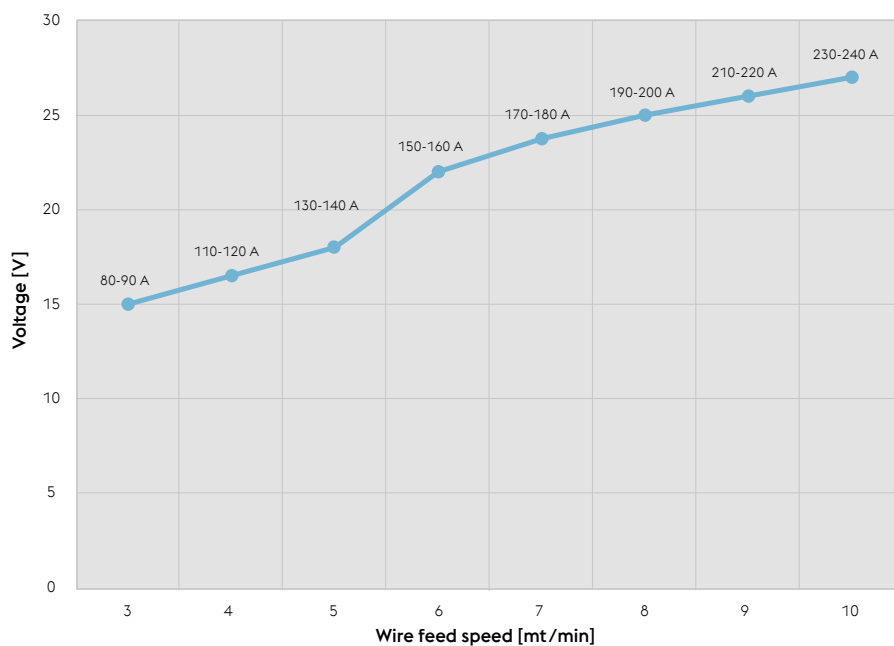
Wire feed speed		Arc voltage	Welding current	Arc mode
(m/min.)	(inch/min.)	(V)	(A)	
3	118	15-15.5	80-90	Short arc
4	157	16-17	110-120	Short arc
5	197	18-18.5	130-140	Globular arc
6	236	22-23	150-160	Globular arc
7	276	24-24.5	170-180	Spray arc
8	315	25-26	190-200	Spray arc
9	354	26-27	210-220	Spray arc
10	394	27-28	230-240	Spray arc

Chart valid for:

BÖHLER HL 46 T-MC
 BÖHLER HL 51 L-MC
 BÖHLER HL 51 T-MC
 BÖHLER HL 53 T-MC
 BÖHLER DMO T-MC
 BÖHLER DCMS T-MC
 BÖHLER HL 60 Pipe T-MC
 BÖHLER X70 L-MC
 BÖHLER alform® 700 L-MC
 BÖHLER alform 900 L-MC
 BÖHLER alform 960 L-MC
 BÖHLER X90 L-MC
 BÖHLER X96 L-MC

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.