

PARAMETER GUIDE FOR ALL-POSITIONAL METAL CORED WIRES

Ø 1.2 mm / .045 Inch

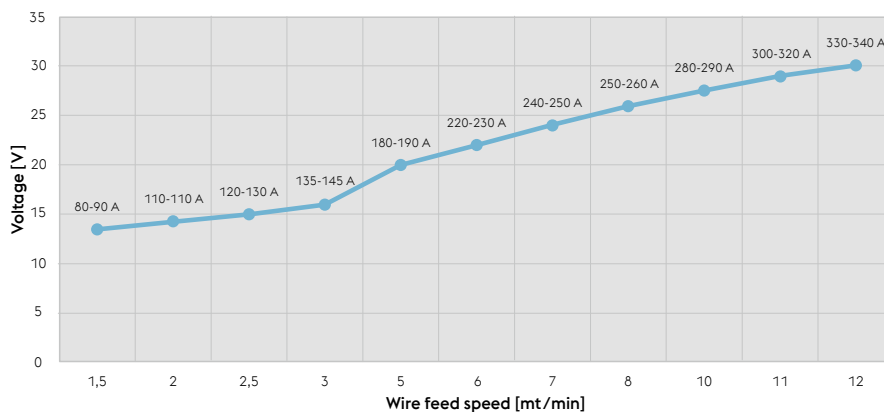


Wire feed speed (m/min.)	(inch/min.)	Arc voltage (V)	Welding current (A)	Arc mode
1.5	59	13.5-14.5	80-90	Short arc
2.0	79	14-15	100-110	Short arc
2.5	98	14.5-18	120-130	Short arc
3	118	16-20	135-140	Short arc
5	197	20-22	180-190	Globular arc
6	236	22-23	220-230	Spray arc
7	276	24-25	240-250	Spray arc
8	315	26-28	250-260	Spray arc
10	394	28-29	280-290	Spray arc
11	433	29-30	300-320	Spray arc
12	472	30-31	330-340	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 60 Pipe T-MC
BÖHLER HL 3,5 T-MC
BÖHLER DMO T-MC
BÖHLER DCMS T-MC
BÖHLER CM2 T-MC
BÖHLER HL 65 T-MC
BÖHLER HL 75 T-MC
BÖHLER X70 L-MC
BÖHLER alform® 700 L-MC
BÖHLER X90 L-MC
BÖHLER alform® 900 L-MC
BÖHLER X96 L-MC
BÖHLER alform® 960 L-MC

Polarity: DC+ Stickout: 15mm/0.6" 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.