

PARAMETER GUIDE FOR ALL-POSITIONAL RUTILE CORED WIRES

Ø 1.2 mm / .045 Inch

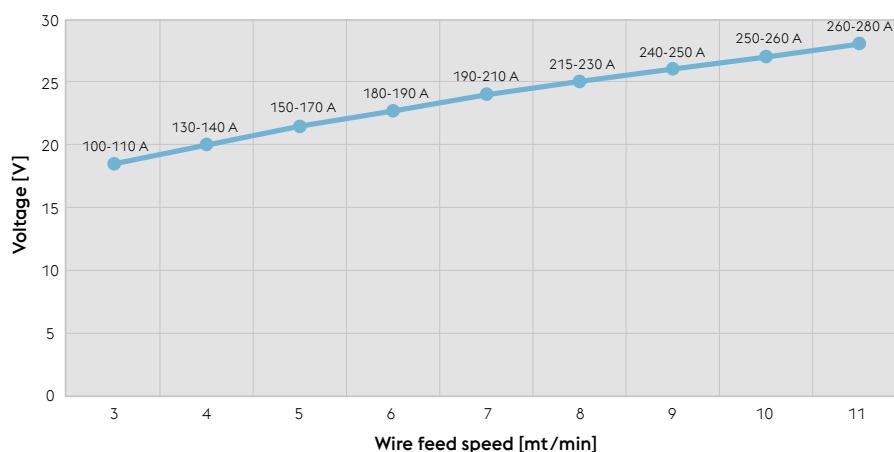


Wire feed speed		Arc voltage	Welding current	Arc mode
(m/min.)	(inch/min.)	(V)	(A)	
3	118	19-20	100-110	Globular - spray arc
4	157	20-21	130-140	Globular - spray arc
5	197	21-22	150-170	Globular - spray arc
6	236	22-23	180-190	Spray arc
7	276	24-25	190-210	Spray arc
8	315	25-26	215-230	Spray arc
9	354	26-27	240-250	Spray arc
10	394	27-28	250-260	Spray arc
11	433	28-29	260-280	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 (CO ₂)
BÖHLER Ti 52 T-FD (HP)
BÖHLER Ti 52 T-FD SR (CO ₂)
BÖHLER NiCu1 Ti T-FD
BÖHLER DMO Ti T-FD
BÖHLER DCMS Ti T-FD
BÖHLER Ti 60 T-FD
BÖHLER Ti 60 T-FD SR
BÖHLER Ti 60 T-FD (CO ₂)
BÖHLER Ti 60 K2 T-FD (CO ₂)
BÖHLER Ti 2 Ni T-FD
BÖHLER Ti 75 T-FD
BÖHLER Ti 70 Pipe T-FD
BÖHLER Ti 75 pipe T-FD
BÖHLER Ti 70 Pipe T-FD - N
BÖHLER Ti 80 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.