
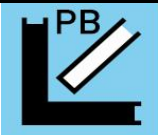
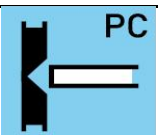





CEWELD®

Seamless metal core Ø 1,0 mm

welding position	Base mat. thickness	layer Build Up	Current Ampere	Voltage Volt	W-Speed M/Min.	Gap Max. (mm)
		1 (root)	100 ± 20	14,5 ± 1	2,5	4
		2-n	220 ± 20	26 ± 1	10,7	
	< 5 mm		120 ± 20	15,5 ± 1	3,8	
	< 10 mm	1	220 ± 10	26 ± 1	10,7	
	> 10 mm	1	220 ± 20	26 ± 1	10,7	
		1 (root)	90 ± 10	14,5 ± 1	2,3	3
		2-n	220 ± 10	25 ± 1	10,7	
	< 5 mm		120 ± 20	15,5 ± 1	3,8	
	> 5 mm		220 ± 10	25 ± 1	10,7	
		1 (root)	100 ± 10	14,5 ± 1	2,9	2 (3)
	weaving	2-n	120 ± 10	15 ± 1	3,8	
	stringer	2-n	200 ± 10	24 ± 1	9,5	
		1	100 ± 20	15 ± 1	2,9-3,8	5
		2-n	130 ± 20	15 ± 2	3,8-5,1	