

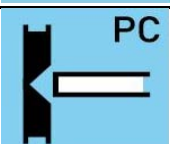





# CEWELD®

## Seamless rutile core $\varnothing$ 1,2 mm

welding position	Base mat. thickness	layer Build Up	Current Ampere	Voltage Volt	W-Speed M/Min.	Gap Max. (mm)
 PA		1 (root)	180	22 ± 1	5,8	6
		2nd	250	27 ± 1	9,7	
			280	28 ± 1	11,6	
 PB	< 12 mm		180	24 ± 1	5,8	
	> 12 mm	1	220	25 ± 1	5,5	
	multi layer	1	260	27 ± 1	10,4	
		2nd	240	26 ± 1	9,3	
 PC		1 (root)	160	22 ± 1	5,1	5
		2nd	210	24 ± 1	6,9	
 PD	< 12 mm	1 run	160	22 ± 1	5,1	
	> 12 mm	1 run	200	24 ± 1	6,7	
	multi layer	1	160	22 ± 1	5,1	
		2nd	200	24 ± 1	6,7	
 PE		1 (root)	160	22 ± 1	5,1	4
		2nd	220	25 ± 1	7,7	
 PF	< 12 mm	1 (root)	160	22 ± 1	5,1	5
		2nd	200	25 ± 1	6,7	
	>12 mm	1 (root)	180	22 ± 1	5,8	6
		2nd	240	26 ± 1	9,3	
	< 12 mm	1 run	160	22 ± 1	5,1	
	> 12 mm	1 run	200	23 ± 1	6,7	
	Multi layer	1	160	22 ± 1	5,1	
		2nd	230	26 ± 1	8,4	

± 8%