

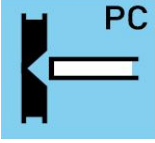


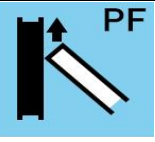


CEWELD®

Seamless rutile core \varnothing 1,0 mm

welding position	Base mat. thickness	layer Build Up	Current Ampere	Voltage Volt	W-Speed M/Min.	Gap Max. (mm)
 PA		1	180 ± 10	23 ± 1	8,6	5
		2-n	220 ± 20	26 ± 2	11,5	
 PB	< 12 mm	1	200 ± 20	25 ± 1	10,4	
	> 12 mm	1	240 ± 20	26 ± 2	12,8	
	multi layer	1	240 ± 20	27 ± 2	12,8	
		2-n	220 ± 20	25 ± 2	11,5	
 PC		1 (root)	160 ± 10	22 ± 1	7,1	4
		2-n	220 ± 20	24 ± 1	11,5	
 PD	< 12 mm		160 ± 10	22 ± 1	7,1	
	> 12 mm	1	220 ± 20	25 ± 1	11,5	
	multi layer	1	160 ± 10	22 ± 1	7,1	
		2-n	220 ± 20	24 ± 1	10,4	
 PE		1	160 ± 10	22 ± 1	7,1	4
		2-n	220 ± 20	25 ± 1	11,5	
 PF	< 12 mm	1	160 ± 10	22 ± 1	7,1	5
	> 12 mm	1	220 ± 20	25 ± 1	11,5	
	multi layer	1	160 ± 10	22 ± 1	7,1	
		2-n	200 ± 20	24 ± 1	10,4	