

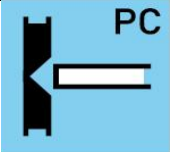


# CEWELD®

## Seamless basic core Ø 1,2 mm

welding	Base mat.	layer	Current	Voltage	W-Speed	Gap Max.
position	thickness	Build Up	Ampere	Volt	M/Min.	(mm)
		1	210 ± 20	24 ± 2	8,5-10,5	4
		2-n	230 ± 20	26 ± 2	9,8	
	single layer > 10 mm	1	240 ± 20	26 ± 2	9,8	
	multi layer	2-n	220 ± 20	25 ± 2	9	
		1	180 ± 10	23 ± 1	7,3	3
		2-n	220 ± 20	25 ± 1	9	