

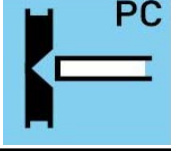


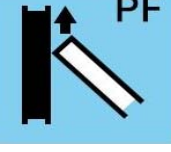


CEWELD®

Seamless metal core wire Ø 1,2 mm

Welding position	Base mat. tickness	layer Build Up	Current Ampere	Voltage Volt	W-Speed M/min.	Gap Max. (mm)
		1 (root)	90	14,5 ± 1	1,6	4
		2nd	240	25 ± 1	5,5	
	< 5 mm		120	14,5 ± 1	2,6	
	< 10 mm		220	25 ± 1	5,5	
	< 15 mm		240	27 ± 1	6,6	
	> 15 mm		300	29 ± 1	9,7	
	< 5 mm		120	14,5 ± 1	2,2	
	< 10 mm		220	25 ± 1	5,5	
	< 15 mm		240	27 ± 1	6,6	
	> 15 mm		300	29 ± 1	9,7	
		1 (root)	90	14,5 ± 1	1,6	3
		2nd	230	24 ± 1	6,1	
	< 5 mm		160	15,5 ± 1	3,6	
	> 5 mm		220	25 ± 1	5,7	
		1 (root)	100	14,5 ± 1	1,9	2 (3)
	weaving	2nd	130	15 ± 1	2,6	
	no weaving	2nd	220	24 ± 1	5,7	
		1 (root)	90	14,5 ± 1	1,6	4
		2nd	110	14,5 ± 1	2	
		3th	120	15,5 ± 1	2,2	
	singel run		140	15,5 ± 1	2,8	
	multi run		160	15,5 ± 1	3,8	

± 8%