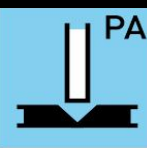

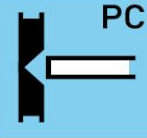


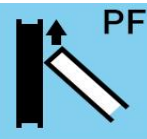


CEWELD®

Suggested parameters for AA R400 Ø 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	23 ± 1	6,5	6
		2nd	250	27 ± 1	11,7	
			285	28 ± 1	14	
 PB	< 12 mm		180	23 ± 1	6,5	
	> 12 mm	1	220	25 ± 1	8,1	
	multi layer	1	260	27 ± 1	12,2	
		2nd	240	26 ± 1	10,8	
 PC		1 (root)	160	23 ± 1	6,1	5
		2nd	210	24 ± 1	7,7	
 PD	< 12 mm	1 run	160	23 ± 1	6,1	
	> 12 mm	1 run	200	24 ± 1	7	
	multi layer	1	160	22 ± 1	6,1	
		2nd	200	24 ± 1	7	
 PE		1 (root)	160	22 ± 1	6,1	4
		2nd	220	25 ± 1	8	
 PF	< 12 mm	1 (root)	170	23 ± 1	6,5	5
		2nd	200	25 ± 1	7,1	
	>12 mm	1 (root)	180	23 ± 1	6,5	6
		2nd	240	26 ± 1	10,8	
	< 12 mm	1 run	160	22 ± 1	6,1	
	> 12 mm	1 run	200	24 ± 1	7,1	
	Multi layer	1	160	23 ± 1	6,1	
		2nd	230	26 ± 1	10,1	

± 8%

