

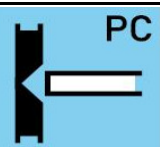





CEWELD®

Suggested parameters for MA 600 (1.4718) 1,2 mm

Welding position	Base mat. tickness	Current Ampere	Voltage Volt	W-Speed M/min.	Oscilation (mm)
	< 5 mm	110	15 ± 1	3	-
	< 10 mm	190	24 ± 1	6,5	-
	< 15 mm	240	27 ± 1	9,7	-
	> 15 mm	260	29 ± 1	11,7	-
	< 5 mm	110	15 ± 1	3	-
	< 10 mm	190	24 ± 1	6,5	-
	< 15 mm	240	27 ± 1	9,7	-
	> 15 mm	260	29 ± 1	11,7	-
	<10 mm	150	18 ± 1	4,4	-
	>10 mm	190	24 ± 1	6,5	-
	<10 mm	150	18 ± 1	4,4	-
	>10 mm	190	24 ± 1	190	-
	<10 mm	110	14,5 ± 1	3	-
	>10 mm	190	24 ± 1	190	-
	<5 mm	110	14,5 ± 1	3	10
	<10 mm	150	18 ± 1	4,4	15
	>10 mm	190	24 ± 1	190	25

± 8%

