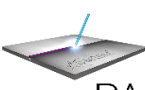
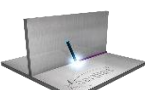

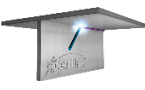
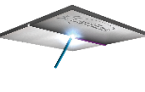
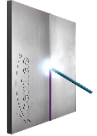


AA R400 Ø 1,2 mm

Welding position	Base mat. tickness	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		220	25 ± 1	8,1		
	Multi layer			260	27 ± 1	12,2	
				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		
	Multi layer	1 run	200	24 ± 1	7		
		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		
	Multilayer	1	160	23 ± 1	6,1		
		2nd	230	26 ± 1	10,1		

± 8%