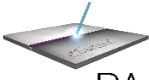
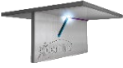


CEWELD Ultra Clean III - 1,0mm

Welding position	Base mat. thickness	layer Build Up	Current Ampere	Voltage Volt	W-Speed M/min.	Gap Max. (mm)
 PA	12	1 (root)	95	17,0	4,1	3
		2-n	220	28,5	11,6	
 PB	12		200	24,0	9,6	
			250	28,0	13,0	
 PC	12	1 (root)	95	17,0	4,1	3
		2-n	215	25,5	10,0	
 PD	12		200	23,0	9,2	
			220	27,2	11,0	
 PE	12	1 (root)	100	17,0	4,4	3
		2-n	175	20,2	7,5	
 PF (3F)	12		140	18,5	6,0	
 PF	12	1 (root)	80	17,0	3,6	3
		2-n	130	18,5	5,5	

± 8%