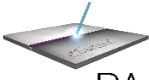
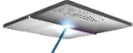


CEWELD Ultra Clean III - 1,2mm

Welding position	Base mat. thickness	layer Build Up	Current Ampere	Voltage Volt	W-Speed M/min.	Gap Max. (mm)
 PA	12	1 (root)	95	15,1	2,2	4
		2-n	280	29,0	9,8	
 PB	12		285	27,7	8,7	
 PC	12	1 (root)	115	16,0	3,0	4
		2-n	220	22,5	6,7	
 PD	12		255	26,0	7,7	
 PE	12	1 (root)	120	16,5	3,2	4
		2-n	220	21,0	6,6	
 PF (3F)	12		165	18,0	4,2	
 PF	12	1 (root)	120	16,8	3,2	4
		2-n	160	18,3	4,3	

± 8%