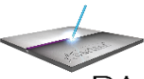
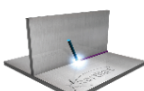
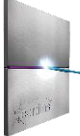
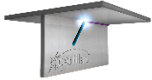
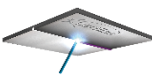
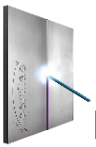


CEWELD E 11018-M

Welding position	Thickness	layer Build Up	Ø 2,5 mm Current	Ø 3,2 mm Current	Ø 4,0 mm M/min.	Gap Max. (mm)
 PA		1 (Root)	75	110	130	4
		Fill/Cap	90	140	195	
 PB	< 5 mm		75	110	140	
	< 10 mm		80	120	160	
	< 15 mm		85	130	180	
	> 15 mm		90	140	200	
 PC		1 (root)	65	110	130	3
		Fill/Cap	90	135	175	
 PD	< 5 mm		75	90	110	
	> 5 mm		85	110	130	
 PE		1 (Root)	65	95	120	2 (3)
		Fill/Cap	85	110	130	
 PF		1 (root)	80	110	120	4
		2nd	85	120	130	
		Fill/Cap	90	130	140	
			Current ± 10 A			