



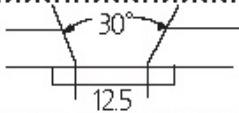
DATA SHEET

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Typical welding conditons

Thick (mm)	Wire dia. (mm)	Groove dimension (mm)	Amp.	Volt.	Travel speed (cm/min)	Pass
25	4.0		600	30	40~50	1~14
3.2	2.4		350	28	150	1~2

