

Tru-Core[®] CORED WELDING WIRES

APPROXIMATE WELDING PARAMETERS (ALL CORED WIRES)

		DIA. (in)	POLARITY	WIRE FEED SPEED in/min		VOLTAGE		AMPERAGE		CTWD (in)	SHIELDING GAS
				Min.	Max.	Min.	Max.	Min.	Max.		
ALL FLUX CORED WIRES	ALL POSITIONS	0.045	DCEP	145	200	23	25	270	330	5/8	100% CO ₂ or 75-80% Argon/ Balance CO ₂
		0.052		150	215	24	26	200	245	5/8	
		1/16 (.062)		165	220	24	26	130	160	3/4	
	FLAT AND HORIZ. POSITIONS	0.045		120	270	23	28	200	500	5/8	
		0.052		160	315	24	29	225	425	5/8	
		1/16 (.062)		260	360	25	30	250	325	3/4	
ALL METAL CORED WIRES	FLAT AND HORIZ. POSITIONS	0.045	DCEP	120	340	17	30	190	520	5/8	75-90% Argon/ Balance CO ₂
		0.052		145	360	17	30	175	475	5/8	
		1/16 (.062)		190	485	17	30	150	450	3/4-1	
		1/16 (.062)		345	550	21	31	150	250	1-Jan	