

Typical settings Steel

plate Thickness	C02			MIX		
	1.0	1.2	1.6	1.0	1.2	1.6
1.0	1.8m/16.6V	1.4m/16.3V		2.1m/15.3V	1.5m/13.8V	
2.0	4.5m/17.9V	2.4m/17V	1.8m/18V	4.3m/17V	3.5m/16.7V	1.7m/15.8V
3.0	6.8m/22.5V	2.9m/17.7V	2.3m/17.7V	6.4m/19.1V	4.7m/18.2V	2.2m/17.4V
4.0	7.9m/23.7V	5.6m/21.4V	2.5m/19.1V	7.6m/20.3V	5.8m/20.7V	2.7m/18.4V
5.0	8.5m/24.3V	7.8m/25V	2.7m/19.4V	11.1m/25.3V	7.2m/24.6V	3.4m/19.8V
6.0	10.1m/25.8V	8.9m/26.4V	3.1m/20.9V	12.3m/27.1V	7.9m/26V	3.8m/20.9V
8.0	12.5m/28V	9.9m/27.8V	3.6m/22.6V	14.1m/29.5V	8.9m/28V	4.4m/22.9V
10	14.5m/32V	11m/29.2V	4.1m/24V	16.4m/31.4V	11.1m/30.1V	5.1m/26V
12	16.5m/33.8V	12.3m/32.1V	5.3m/27.4V	17.3m/31.9V	12.3m/31.7V	5.9m/28.3V
14	19.5m/36.5V	13.7m/35V	6.4m/30.3V	18.2m/32.4V	13.4m/33.2V	6.7m/30.7V
16	20m/37V	15m/37V	7.3m/32.9V	20m/33V	14.5m/34V	7.2m/31.5V
18		16m/38V	7.9m/34.4V		15.7m/35V	7.7m/31.6V
20		17m/39V	8.5m/36V		16.6m/35.5V	8.3m/31.8V
25			10m/40V		19.2m/37V	9.5m/32V