

MEGAFIL® Welding parameters - guidance values: metal-cored wires



MEGAFIL® - metal-cored wire - Ø 1.2 mm; gas flow 12-18 l/min (25-38 cfh)

Position		Plate thickness	Layer	Amperage [A]	Voltage [V]	W.- Speed [m/ min]	Gap max (mm)	Symbol	
PA 1G			1 (Root)	90 ± 10	14.5 ± 1	1.8	4		
			2-n	240 ± 20	26 ± 1	7.1			
PC 2G			1 (Root)	90 ± 10	14.5 ± 1	1.8	3		
			2-n	230 ± 10	25 ± 1	6.7			
PF 3G			1 (Root)	90 ± 10	14.5 ± 1	1.8	4		
			2	110 ± 10	14.5 ± 1	2.2			
			3-n	120 ± 20	15.5 ± 1	2.6			
PE 4G			1 (Root)	100 ± 10	14.5 ± 1	2	2 (3)		
			weaver	2-n	130 ± 10	15 ± 1	3		
			stringer beads	2-n	220 ± 10	25 ± 1	6.6		
PA 1F	min 1.5 mm	< 5 mm		120 ± 20	14.5 ± 1	2.6			
		< 10 mm		220 ± 10	26 ± 1	6.6			
		< 15 mm		240 ± 20	27 ± 1	7.1			
		> 15 mm		300 ± 20	30 ± 1	9.5			
PB 2F	min 1.5 mm	< 5 mm		120 ± 10	15.5 ± 1	2.6			
		< 10 mm		220 ± 10	26 ± 1	6.6			
		< 15 mm		240 ± 20	27 ± 1	7.1			
		> 15 mm		300 ± 20	30 ± 1	9.5			
PF 3F			single layer	140 ± 20	15.5 ± 1	3.2			
			multi layer	160 ± 20	16.5 ± 1	3.8			
PD 4F		< 5 mm		160 ± 20	16.5 ± 1	3.8			
		> 5 mm		220 ± 10	25 ± 1	6.6			