

# MEGAFIL® Welding parameters - guidance values: rutile flux-cored wires



## MEGAFIL® - rutile flux-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	180 ± 10	23 ± 1	5.4	6	
			2-n	250 ± 20	27 ± 1	9.6		
PC 2G			1	160 ± 10	22 ± 1	5	5	
			2-n	210 ± 20	24 ± 1	6.3		
PF 3G		t < 12 mm	1	160 ± 10	22 ± 1	5	5	
			2-n	200 ± 20	25 ± 1	6.1		
		t > 12 mm	1	180 ± 10	23 ± 1	5.4	6	
			2-n	240 ± 20	26 ± 1	9.3		
PE 4G			1	160 ± 10	22 ± 1	5	4	
			2-n	220 ± 10	25 ± 1	6.4		
PA 1F			1	260 ± 20	27 ± 2	10.5		
PB 2F	single layer	t < 12 mm		180 ± 20	24 ± 1	5.4		
		t > 12 mm	1	260 ± 20	27 ± 2	10.5		
	multi layer		1	260 ± 20	27 ± 2	10.5		
			2-n	240 ± 20	26 ± 2	9.3		
PF 3F	single layer	t < 12 mm		160 ± 10	22 ± 1	5		
		t > 12 mm	1	200 ± 20	23 ± 2	6.1		
	multi layer		1	160 ± 10	22 ± 1	5		
			2-n	230 ± 10	26 ± 1	8.5		
PD 4F	single layer	t < 12 mm		160 ± 10	22 ± 1	5		
		t > 12 mm	1	200 ± 20	24 ± 1	6.1		
	multi layer		1	160 ± 10	22 ± 1	5		
			2-n	200 ± 20	24 ± 1	6.1		