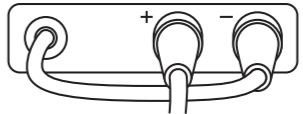
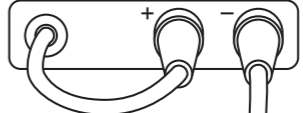


MIGARC 160/F8035

294mm

Material being used		Wire type & polarity setting	Suggested Gas Shielding 9.5-14 L/min Gas Flow	Diameter of welding wire being Used	Plate Thickness (Recommended Amperage/Voltage)						
					1 mm	1.5 mm	2 mm	2.5 mm	3 mm	4 mm	
Steel	Gasless Wire Flux Cored Wire E71T-11 (DCEN)	No Gas Required	0.8mm Knurled Groove Roller	2-3.5 13V	3-4 14V	3-4.5 14.5V	3.5-5 18.5V	4-6 21V	- -	<b>DC Electrode - NEGATIVE</b> 	
			0.9mm Knurled Groove Roller	1.5-3 13V	2.5-3.5 14V	2.5-4 14.5V	3-4.5 18.5V	3.5-5 21V	- -		
			1.0mm Knurled Groove Roller	1.5-2.5 13V	2-3.5 14V	2.5-4 14.5V	3-4 18.5V	3-4.5 22V	- -		
Steel	Mild Steel Solid Wire ER70S-6 (DCEP)	93% Argon 5% CO2 2% Oxy	0.6mm V Groove Roller	3.5-5 12.8V	3.5-6 14.1V	4-7 15.2V	4.5-8 16.8V	- -	- -	<b>DC Electrode - POSITIVE</b> 	
			0.8mm V Groove Roller	2.5-4 13.5V	3-5 14.8V	3.5-6 16.7V	4-7 18V	5-7.5 19.7V	- -		
			0.9mm V Groove Roller	2-3.5 15.2V	2.5-4.5 17V	3-5.5 19.5V	3.5-6.5 20.1V	- -	- -		
			1.0mm V Groove Roller	1.5-3 13.5V	2-4 17V	2.5-5 19.9V	3-6 20.1V	- -	- -		
Stainless Steel	Stainless Steel Solid wire ER316LSI (DCEP)	98% Argon 2% CO2	0.8mm V Groove Roller	2.5-4 13.5V	3-5 15.5V	3.5-5.5 13.5V	4-6 19.2V	4-7 20.7V	5-7.5 22.5V		
			0.9mm V Groove Roller	2-3.5 13.5V	2.5-4.5 15.2V	3-5 16.9V	3.5-6 20V	5-6.5 22V	- -		
			1.0mm V Groove Roller	1.5-3 13.5V	2-4 15.2V	2.5-5 16.9V	3-6 20.5V	- -	- -		
Aluminum	Aluminum 4043, 5356 (DCEP)	100% Argon	1.0mm U Groove Roller	- -	2-3.5 14.2V	2.5-4 15.5V	3-4.5 16.5V	3.5-5.5 19.9V	- -		

Settings are approximate, adjust as required.  
Thicker materials can be welded using proper  
technique, joint preparation and multiple passes.

160mm

技术要求:

- 1、白底，彩色印刷;橘色为PANTONE 1665C
- 2、贴纸外形尺寸为294\*160;
- 3、保证贴纸的粘贴性牢固，防水，耐高温。

					合成纸加3M背胶				 上海沪工焊接 集团股份有限公司	
标记	处数	更改文件号	签字	年、月、日					参数贴纸	
设计		标准化			阶段标记	数量	重量	比例		
校对								1: 2	2.09.04.265 V1.0	
审核					共 xx 张		第 xx 张			
工艺		批准								

旧底图总号	
底图总号	
签字	
日期	