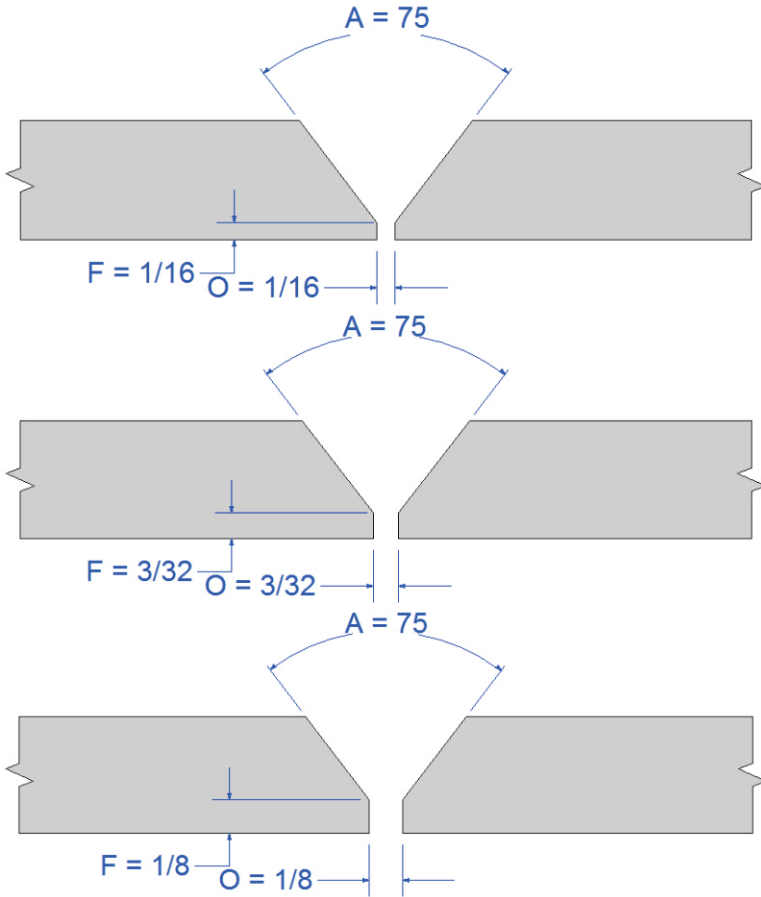
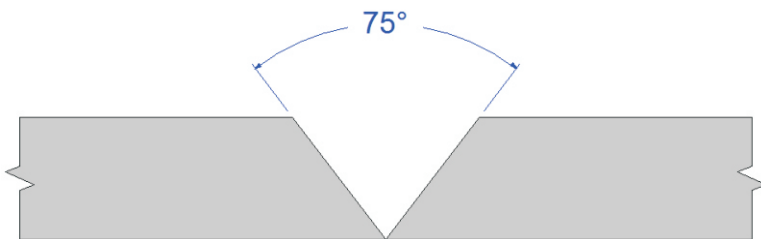


Open Root Geometries



Closed Root Geometries



PASS 1

OPEN ROOT (.035 Wire)

125 to 145 amps - 25 to 35 WFS

CLOSED ROOT (.035 Wire)

170 to 200 amps - 20 to 30 WFS

The heavier the wall the greater the amperage, as it acts as a heat sync.

Amperage also depends on the operator and his WFS and travel speed.

When rooting the pipe, you must stay on the leading edge of the puddle and maintain this throughout the process.

PASS 2 FILL

200 to 250 amps - 45 to 60 WFS

PASS 3 or PASS 3 - 4 CAP

170 to 200 amps - 30 - 40 WFS

2G Fixed, 5G Fixed, 6G Incline Fixed use lower settings.

1G Rotating use higher settings.

