

GEMINI-B FLUX CORE OPTIMUM WELDING PARAMETERS

WIRE DIAMETER	WELD POSITION	APPROX. AMP.	WIRE FEED SPEED	VOLTAGE	STICKOUT ±1/4"	DEP. RATE LB./HR.
.045 (1.2mm)	FLAT	190	455	26	3/4"	8.06
.045 (1.2mm)	HORIZONTAL	190	455	26	3/4"	8.06
.045 (1.2mm)	VERTICAL-UP	160	330	25	3/4"	6.10
.045 (1.2mm)	OVERHEAD	185	430	26	3/4"	6.24

DCEP - REVERSE POLARITY - ELECTRODE POSITIVE

Refer to Data Sheet for additional information