

Spoolarc 86

Contiene niveles de Manganeso y Silicio mayores que los grados estándares de microalambre. Muestra excelente tolerancia al óxido y escama de laminación, un charco muy fluido y excelente apariencia de cordón. Sus aplicaciones abarcan equipo pesado, estructuras y soldaduras de aceros al Carbono en general.

Especificaciones	
Clasificaciones	EN ISO 14341-A : G 3Si1 ASME SFA-A5.18 : ER70S-6 AWS A5.18 : ER70S-6 H4
Aprobaciones	ABS : AWS A5.18: ER70S-6 H4 CWB : CAN/CSA-ISO14341,B-G 49A 3C G6 (ER49S-6) CWB : CSA W48 LR : 3S, 3YS (H15) MIL-E-23765/1 : MIL-70S-6
Sector	Fabricación industrial en general Industria Automotriz Equipos móviles Construcción de barcos/embarcaciones

Las aprobaciones se basan en la ubicación de la fábrica. Póngase en contacto con ESAB para obtener más información.

Propiedades típicas de Tensión			
Condición	Límite de flujo	Resistencia a la tracción	Alargamiento
100% CO₂			
Como queda soldado	470 MPa (68 ksi)	565 MPa (82 ksi)	30 %
75% Ar - 25% CO₂			
Como queda soldado	497 MPa (72 ksi)	593 MPa (86 ksi)	27 %
90% Ar - 10% CO₂			
Como queda soldado	503 MPa (73 ksi)	593 MPa (86 ksi)	29 %

Teste Charpy		
Condición	Temperatura de prueba	Valor de impacto
100% CO₂		
Como queda soldado	-29 °C (-20 °F)	60 J (44 ft-lb)
90% Ar - 10% CO₂		
Como queda soldado	-29 °C (-20 °F)	156 J (115 ft-lb)
Como queda soldado	-40 °C (-40 °F)	123 J (91 ft-lb)
Como queda soldado	-45 °C (-50 °F)	130 J (96 ft-lb)
98% Ar - 2% O₂		
Como queda soldado	-29 °C (-20 °F)	118 J (87 ft-lb)

% típico de composición de alambre								
C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.08	1.51	0.85	0.01	0.008	0.01	0.02	0.01	0.11

Depósito			
Diámetro	Corriente	Eficiencia	Tasa de Deposición
100% CO₂			
1.2 mm (.045 in.)	200 A	93 %	2.40 kg/h (5.3 lbs/h)
0.8 mm (.030 in.)	150 A	98 %	1.86 kg/h (4.1 lbs/h)
0.9 mm (.035 in.)	200 A	96 %	2.72 kg/h (6.0 lbs/h)
1.2 mm (.045 in.)	250 A	98 %	3.58 kg/h (7.8 lbs/h)
1.6 mm (1/16 in.)	350 A	98 %	5.13 kg/h (11.3 lbs/h)

Spoolarc 86

Depósito			
Diámetro	Corriente	Eficiencia	Tasa de Deposición
1.6 mm (1/16 in.)	400 A	96 %	6.21 kg/h (13.7 lbs/h)
0.8 mm (.030 in.)	75 A	96 %	0.86 kg/h (1.9 lbs/h)
0.8 mm (.030 in.)	100 A	93 %	1.13 kg/h (2.5 lbs/h)
0.8 mm (.030 in.)	150 A	93 %	1.77 kg/h (3.9 lbs/h)
1.6 mm (1/16 in.)	250 A	98 %	2.95 kg/h (6.5 lbs/h)
0.9 mm (.035 in.)	150 A	98 %	1.90 kg/h (4.2 lbs/h)
0.8 mm (.030 in.)	75 A	93 %	0.82 kg/h (1.8 lbs/h)
1.6 mm (1/16 in.)	300 A	93 %	3.86 kg/h (8.5 lbs/h)
1.2 mm (.045 in.)	200 A	98 %	2.54 kg/h (5.6 lbs/h)
1.2 mm (.045 in.)	100 A	98 %	0.95 kg/h (2.1 lbs/h)
1.6 mm (1/16 in.)	350 A	93 %	4.85 kg/h (10.7 lbs/h)
1.2 mm (.045 in.)	150 A	93 %	1.54 kg/h (3.4 lbs/h)
1.2 mm (.045 in.)	350 A	93 %	5.67 kg/h (12.5 lbs/h)
1.6 mm (1/16 in.)	450 A	93 %	7.48 kg/h (16.5 lbs/h)
0.8 mm (.030 in.)	75 A	98 %	0.91 kg/h (2.0 lbs/h)
1.2 mm (.045 in.)	125 A	93 %	1.22 kg/h (2.7 lbs/h)
1.2 mm (.045 in.)	250 A	96 %	3.45 kg/h (7.6 lbs/h)
0.9 mm (.035 in.)	200 A	98 %	2.81 kg/h (6.2 lbs/h)
0.8 mm (.030 in.)	200 A	93 %	2.95 kg/h (6.5 lbs/h)
0.9 mm (.035 in.)	80 A	96 %	0.95 kg/h (2.1 lbs/h)
1.6 mm (1/16 in.)	400 A	93 %	6.03 kg/h (13.3 lbs/h)
1.2 mm (.045 in.)	100 A	93 %	0.86 kg/h (1.9 lbs/h)
1.6 mm (1/16 in.)	275 A	96 %	3.45 kg/h (7.6 lbs/h)
1.6 mm (1/16 in.)	450 A	96 %	7.76 kg/h (17.1 lbs/h)
1.6 mm (1/16 in.)	350 A	96 %	6.21 kg/h (11.0 lbs/h)
1.2 mm (.045 in.)	350 A	96 %	5.85 kg/h (12.9 lbs/h)
0.8 mm (.030 in.)	200 A	98 %	3.08 kg/h (6.8 lbs/h)
1.6 mm (1/16 in.)	450 A	98 %	7.89 kg/h (17.4 lbs/h)
0.9 mm (.035 in.)	200 A	93 %	2.68 kg/h (5.9 lbs/h)
0.9 mm (.035 in.)	80 A	98 %	1.00 kg/h (2.2 lbs/h)
0.9 mm (.035 in.)	100 A	98 %	1.22 kg/h (2.7 lbs/h)
0.8 mm (.030 in.)	200 A	96 %	3.04 kg/h (6.7 lbs/h)
1.2 mm (.045 in.)	350 A	98 %	5.99 kg/h (13.2 lbs/h)
1.6 mm (1/16 in.)	275 A	98 %	3.49 kg/h (7.7 lbs/h)
1.2 mm (.045 in.)	200 A	96 %	2.49 kg/h (5.5 lbs/h)
1.2 mm (.045 in.)	300 A	96 %	4.53 kg/h (10.0 lbs/h)
0.8 mm (.030 in.)	100 A	98 %	1.18 kg/h (2.6 lbs/h)
0.9 mm (.035 in.)	150 A	96 %	1.86 kg/h (4.1 lbs/h)
1.6 mm (1/16 in.)	250 A	96 %	2.90 kg/h (6.4 lbs/h)
0.9 mm (.035 in.)	250 A	93 %	3.90 kg/h (8.6 lbs/h)
0.9 mm (.035 in.)	250 A	98 %	4.08 kg/h (9.0 lbs/h)
0.9 mm (.035 in.)	80 A	93 %	0.91 kg/h (2.0 lbs/h)
1.2 mm (.045 in.)	300 A	98 %	4.63 kg/h (10.2 lbs/h)
1.6 mm (1/16 in.)	400 A	98 %	6.35 kg/h (14.0 lbs/h)
1.2 mm (.045 in.)	150 A	98 %	1.63 kg/h (3.6 lbs/h)
0.8 mm (.030 in.)	100 A	96 %	1.18 kg/h (2.6 lbs/h)
1.2 mm (.045 in.)	300 A	93 %	4.40 kg/h (9.7 lbs/h)

Spoolarc 86

Depósito			
Diámetro	Corriente	Eficiencia	Tasa de Deposición
0.9 mm (.035 in.)	250 A	96 %	3.09 kg/h (8.8 lbs/h)
1.6 mm (1/16 in.)	250 A	93 %	2.81 kg/h (6.2 lbs/h)
1.6 mm (1/16 in.)	300 A	96 %	3.99 kg/h (8.8 lbs/h)
1.2 mm (.045 in.)	100 A	96 %	0.91 kg/h (2.0 lbs/h)
1.2 mm (.045 in.)	250 A	93 %	3.36 kg/h (7.4 lbs/h)
1.6 mm (1/16 in.)	275 A	93 %	3.31 kg/h (7.3 lbs/h)
1.6 mm (1/16 in.)	300 A	98 %	4.08 kg/h (9.0 lbs/h)
0.9 mm (.035 in.)	100 A	96 %	1.22 kg/h (2.7 lbs/h)
1.2 mm (.045 in.)	125 A	96 %	1.27 kg/h (2.8 lbs/h)
0.9 mm (.035 in.)	100 A	93 %	1.18 kg/h (2.6 lbs/h)
1.2 mm (.045 in.)	150 A	96 %	1.59 kg/h (3.5 lbs/h)
0.9 mm (.035 in.)	150 A	93 %	1.81 kg/h (4.0 lbs/h)
0.8 mm (.030 in.)	150 A	96 %	1.81 kg/h (4.0 lbs/h)
1.2 mm (.045 in.)	125 A	98 %	1.27 kg/h (2.8 lbs/h)
75% Ar - 25% CO₂			
1.2 mm (.045 in.)	200 A	93 %	2.40 kg/h (5.3 lbs/h)
0.8 mm (.030 in.)	150 A	98 %	1.86 kg/h (4.1 lbs/h)
0.9 mm (.035 in.)	200 A	96 %	2.72 kg/h (6.0 lbs/h)
1.2 mm (.045 in.)	250 A	98 %	3.58 kg/h (7.8 lbs/h)
1.6 mm (1/16 in.)	350 A	98 %	5.13 kg/h (11.3 lbs/h)
1.6 mm (1/16 in.)	400 A	96 %	6.21 kg/h (13.7 lbs/h)
0.8 mm (.030 in.)	75 A	96 %	0.86 kg/h (1.9 lbs/h)
0.8 mm (.030 in.)	100 A	93 %	1.13 kg/h (2.5 lbs/h)
0.8 mm (.030 in.)	150 A	93 %	1.77 kg/h (3.9 lbs/h)
1.6 mm (1/16 in.)	250 A	98 %	2.95 kg/h (6.5 lbs/h)
0.9 mm (.035 in.)	150 A	98 %	1.90 kg/h (4.2 lbs/h)
0.8 mm (.030 in.)	75 A	93 %	0.82 kg/h (1.8 lbs/h)
1.6 mm (1/16 in.)	300 A	93 %	3.86 kg/h (8.5 lbs/h)
1.2 mm (.045 in.)	200 A	98 %	2.54 kg/h (5.6 lbs/h)
1.2 mm (.045 in.)	100 A	98 %	0.95 kg/h (2.1 lbs/h)
1.6 mm (1/16 in.)	350 A	93 %	4.85 kg/h (10.7 lbs/h)
1.2 mm (.045 in.)	150 A	93 %	1.54 kg/h (3.4 lbs/h)
1.2 mm (.045 in.)	350 A	93 %	5.67 kg/h (12.5 lbs/h)
1.6 mm (1/16 in.)	450 A	93 %	7.48 kg/h (16.5 lbs/h)
0.8 mm (.030 in.)	75 A	98 %	0.91 kg/h (2.0 lbs/h)
1.2 mm (.045 in.)	125 A	93 %	1.22 kg/h (2.7 lbs/h)
1.2 mm (.045 in.)	250 A	96 %	3.45 kg/h (7.6 lbs/h)
0.9 mm (.035 in.)	200 A	98 %	2.81 kg/h (6.2 lbs/h)
0.8 mm (.030 in.)	200 A	93 %	2.95 kg/h (6.5 lbs/h)
0.9 mm (.035 in.)	80 A	96 %	0.95 kg/h (2.1 lbs/h)
1.6 mm (1/16 in.)	400 A	93 %	6.03 kg/h (13.3 lbs/h)
1.2 mm (.045 in.)	100 A	93 %	0.86 kg/h (1.9 lbs/h)
1.6 mm (1/16 in.)	275 A	96 %	3.45 kg/h (7.6 lbs/h)
1.6 mm (1/16 in.)	450 A	96 %	7.76 kg/h (17.1 lbs/h)
1.6 mm (1/16 in.)	350 A	96 %	6.21 kg/h (11.0 lbs/h)
1.2 mm (.045 in.)	350 A	96 %	5.85 kg/h (12.9 lbs/h)
0.8 mm (.030 in.)	200 A	98 %	3.08 kg/h (6.8 lbs/h)

Spoolarc 86

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1.6 mm (1/16 in.)	450 A	98 %	7.89 kg/h (17.4 lbs/h)
0.9 mm (.035 in.)	200 A	93 %	2.68 kg/h (5.9 lbs/h)
0.9 mm (.035 in.)	80 A	98 %	1.00 kg/h (2.2 lbs/h)
0.9 mm (.035 in.)	100 A	98 %	1.22 kg/h (2.7 lbs/h)
0.8 mm (.030 in.)	200 A	96 %	3.04 kg/h (6.7 lbs/h)
1.2 mm (.045 in.)	350 A	98 %	5.99 kg/h (13.2 lbs/h)
1.6 mm (1/16 in.)	275 A	98 %	3.49 kg/h (7.7 lbs/h)
1.2 mm (.045 in.)	200 A	96 %	2.49 kg/h (5.5 lbs/h)
1.2 mm (.045 in.)	300 A	96 %	4.53 kg/h (10.0 lbs/h)
0.8 mm (.030 in.)	100 A	98 %	1.18 kg/h (2.6 lbs/h)
0.9 mm (.035 in.)	150 A	96 %	1.86 kg/h (4.1 lbs/h)
1.6 mm (1/16 in.)	250 A	96 %	2.90 kg/h (6.4 lbs/h)
0.9 mm (.035 in.)	250 A	93 %	3.90 kg/h (8.6 lbs/h)
0.9 mm (.035 in.)	250 A	98 %	4.08 kg/h (9.0 lbs/h)
0.9 mm (.035 in.)	80 A	93 %	0.91 kg/h (2.0 lbs/h)
1.2 mm (.045 in.)	300 A	98 %	4.63 kg/h (10.2 lbs/h)
1.6 mm (1/16 in.)	400 A	98 %	6.35 kg/h (14.0 lbs/h)
1.2 mm (.045 in.)	150 A	98 %	1.63 kg/h (3.6 lbs/h)
0.8 mm (.030 in.)	100 A	96 %	1.18 kg/h (2.6 lbs/h)
1.2 mm (.045 in.)	300 A	93 %	4.40 kg/h (9.7 lbs/h)
0.9 mm (.035 in.)	250 A	96 %	3.09 kg/h (8.8 lbs/h)
1.6 mm (1/16 in.)	250 A	93 %	2.81 kg/h (6.2 lbs/h)
1.6 mm (1/16 in.)	300 A	96 %	3.99 kg/h (8.8 lbs/h)
1.2 mm (.045 in.)	100 A	96 %	0.91 kg/h (2.0 lbs/h)
1.2 mm (.045 in.)	250 A	93 %	3.36 kg/h (7.4 lbs/h)
1.6 mm (1/16 in.)	275 A	93 %	3.31 kg/h (7.3 lbs/h)
1.6 mm (1/16 in.)	300 A	98 %	4.08 kg/h (9.0 lbs/h)
0.9 mm (.035 in.)	100 A	96 %	1.22 kg/h (2.7 lbs/h)
1.2 mm (.045 in.)	125 A	96 %	1.27 kg/h (2.8 lbs/h)
0.9 mm (.035 in.)	100 A	93 %	1.18 kg/h (2.6 lbs/h)
1.2 mm (.045 in.)	150 A	96 %	1.59 kg/h (3.5 lbs/h)
0.9 mm (.035 in.)	150 A	93 %	1.81 kg/h (4.0 lbs/h)
0.8 mm (.030 in.)	150 A	96 %	1.81 kg/h (4.0 lbs/h)
1.2 mm (.045 in.)	125 A	98 %	1.27 kg/h (2.8 lbs/h)
92% Ar - 8% CO2			
1.2 mm (.045 in.)	200 A	93 %	2.40 kg/h (5.3 lbs/h)
0.8 mm (.030 in.)	150 A	98 %	1.86 kg/h (4.1 lbs/h)
0.9 mm (.035 in.)	200 A	96 %	2.72 kg/h (6.0 lbs/h)
1.2 mm (.045 in.)	250 A	98 %	3.58 kg/h (7.8 lbs/h)
1.6 mm (1/16 in.)	350 A	98 %	5.13 kg/h (11.3 lbs/h)
1.6 mm (1/16 in.)	400 A	96 %	6.21 kg/h (13.7 lbs/h)
0.8 mm (.030 in.)	75 A	96 %	0.86 kg/h (1.9 lbs/h)
0.8 mm (.030 in.)	100 A	93 %	1.13 kg/h (2.5 lbs/h)
0.8 mm (.030 in.)	150 A	93 %	1.77 kg/h (3.9 lbs/h)
1.6 mm (1/16 in.)	250 A	98 %	2.95 kg/h (6.5 lbs/h)
0.9 mm (.035 in.)	150 A	98 %	1.90 kg/h (4.2 lbs/h)
0.8 mm (.030 in.)	75 A	93 %	0.82 kg/h (1.8 lbs/h)

Spoolarc 86

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Diámetro	Corriente	Eficiencia	Tasa de Deposición
1.6 mm (1/16 in.)	300 A	93 %	3.86 kg/h (8.5 lbs/h)
1.2 mm (.045 in.)	200 A	98 %	2.54 kg/h (5.6 lbs/h)
1.2 mm (.045 in.)	100 A	98 %	0.95 kg/h (2.1 lbs/h)
1.6 mm (1/16 in.)	350 A	93 %	4.85 kg/h (10.7 lbs/h)
1.2 mm (.045 in.)	150 A	93 %	1.54 kg/h (3.4 lbs/h)
1.2 mm (.045 in.)	350 A	93 %	5.67 kg/h (12.5 lbs/h)
1.6 mm (1/16 in.)	450 A	93 %	7.48 kg/h (16.5 lbs/h)
0.8 mm (.030 in.)	75 A	98 %	0.91 kg/h (2.0 lbs/h)
1.2 mm (.045 in.)	125 A	93 %	1.22 kg/h (2.7 lbs/h)
1.2 mm (.045 in.)	250 A	96 %	3.45 kg/h (7.6 lbs/h)
0.9 mm (.035 in.)	200 A	98 %	2.81 kg/h (6.2 lbs/h)
0.8 mm (.030 in.)	200 A	93 %	2.95 kg/h (6.5 lbs/h)
0.9 mm (.035 in.)	80 A	96 %	0.95 kg/h (2.1 lbs/h)
1.6 mm (1/16 in.)	400 A	93 %	6.03 kg/h (13.3 lbs/h)
1.2 mm (.045 in.)	100 A	93 %	0.86 kg/h (1.9 lbs/h)
1.6 mm (1/16 in.)	275 A	96 %	3.45 kg/h (7.6 lbs/h)
1.6 mm (1/16 in.)	450 A	96 %	7.76 kg/h (17.1 lbs/h)
1.6 mm (1/16 in.)	350 A	96 %	6.21 kg/h (11.0 lbs/h)
1.2 mm (.045 in.)	350 A	96 %	5.85 kg/h (12.9 lbs/h)
0.8 mm (.030 in.)	200 A	98 %	3.08 kg/h (6.8 lbs/h)
1.6 mm (1/16 in.)	450 A	98 %	7.89 kg/h (17.4 lbs/h)
0.9 mm (.035 in.)	200 A	93 %	2.68 kg/h (5.9 lbs/h)
0.9 mm (.035 in.)	80 A	98 %	1.00 kg/h (2.2 lbs/h)
0.9 mm (.035 in.)	100 A	98 %	1.22 kg/h (2.7 lbs/h)
0.8 mm (.030 in.)	200 A	96 %	3.04 kg/h (6.7 lbs/h)
1.2 mm (.045 in.)	350 A	98 %	5.99 kg/h (13.2 lbs/h)
1.6 mm (1/16 in.)	275 A	98 %	3.49 kg/h (7.7 lbs/h)
1.2 mm (.045 in.)	200 A	96 %	2.49 kg/h (5.5 lbs/h)
1.2 mm (.045 in.)	300 A	96 %	4.53 kg/h (10.0 lbs/h)
0.8 mm (.030 in.)	100 A	98 %	1.18 kg/h (2.6 lbs/h)
0.9 mm (.035 in.)	150 A	96 %	1.86 kg/h (4.1 lbs/h)
1.6 mm (1/16 in.)	250 A	96 %	2.90 kg/h (6.4 lbs/h)
0.9 mm (.035 in.)	250 A	93 %	3.90 kg/h (8.6 lbs/h)
0.9 mm (.035 in.)	250 A	98 %	4.08 kg/h (9.0 lbs/h)
0.9 mm (.035 in.)	80 A	93 %	0.91 kg/h (2.0 lbs/h)
1.2 mm (.045 in.)	300 A	98 %	4.63 kg/h (10.2 lbs/h)
1.6 mm (1/16 in.)	400 A	98 %	6.35 kg/h (14.0 lbs/h)
1.2 mm (.045 in.)	150 A	98 %	1.63 kg/h (3.6 lbs/h)
0.8 mm (.030 in.)	100 A	96 %	1.18 kg/h (2.6 lbs/h)
1.2 mm (.045 in.)	300 A	93 %	4.40 kg/h (9.7 lbs/h)
0.9 mm (.035 in.)	250 A	96 %	3.09 kg/h (8.8 lbs/h)
1.6 mm (1/16 in.)	250 A	93 %	2.81 kg/h (6.2 lbs/h)
1.6 mm (1/16 in.)	300 A	96 %	3.99 kg/h (8.8 lbs/h)
1.2 mm (.045 in.)	100 A	96 %	0.91 kg/h (2.0 lbs/h)
1.2 mm (.045 in.)	250 A	93 %	3.36 kg/h (7.4 lbs/h)
1.6 mm (1/16 in.)	275 A	93 %	3.31 kg/h (7.3 lbs/h)
1.6 mm (1/16 in.)	300 A	98 %	4.08 kg/h (9.0 lbs/h)

Spoolarc 86

Depósito

Diámetro	Corriente	Eficiencia	Tasa de Deposición
0.9 mm (.035 in.)	100 A	96 %	1.22 kg/h (2.7 lbs/h)
1.2 mm (.045 in.)	125 A	96 %	1.27 kg/h (2.8 lbs/h)
0.9 mm (.035 in.)	100 A	93 %	1.18 kg/h (2.6 lbs/h)
1.2 mm (.045 in.)	150 A	96 %	1.59 kg/h (3.5 lbs/h)
0.9 mm (.035 in.)	150 A	93 %	1.81 kg/h (4.0 lbs/h)
0.8 mm (.030 in.)	150 A	96 %	1.81 kg/h (4.0 lbs/h)
1.2 mm (.045 in.)	125 A	98 %	1.27 kg/h (2.8 lbs/h)

Parámetros de soldadura

Corriente	Diámetro del Alambre	Tensión	Velocidad de Alimentación
Transferencia con pulverización Optimum			
70 A	0.6 mm (.023 in.)	15 V	762 cm/min (300 in./min)
100-125 A	0.6 mm (.023 in.)	23-25 V	1016-1575 cm/min (400-620 in./min)
45-90 A	0.6 mm (.023 in.)	14-16 V	381-965 cm/min (150-380 in./min)
110 A	0.6 mm (.023 in.)	23 V	1143 cm/min (450 in./min)
180 A	0.8 mm (.030 in.)	25 V	1321 cm/min (520 in./min)
100 A	0.8 mm (.030 in.)	15 V	559 cm/min (220 in./min)
160-200 A	0.8 mm (.030 in.)	24-26 V	1270-1651 cm/min (500-650 in./min)
60-140 A	0.8 mm (.030 in.)	14-16 V	381-889 cm/min (150-350 in./min)
180-230 A	0.9 mm (.035 in.)	25-27 V	1016-1397 cm/min (400-550 in./min)
130 A	0.9 mm (.035 in.)	17 V	635 cm/min (250 in./min)
90-160 A	0.9 mm (.035 in.)	15-19 V	457-762 cm/min (180-300 in./min)
200 A	0.9 mm (.035 in.)	26 V	1219 cm/min (480 in./min)
260-340 A	1.2 mm (.045 in.)	25-30 V	762-1270 cm/min (300-500 in./min)
300 A	1.2 mm (.045 in.)	27 V	889 cm/min (350 in./min)
130-200 A	1.2 mm (.045 in.)	17-19 V	318-508 cm/min (125-200 in./min)
160 A	1.2 mm (.045 in.)	18 V	381 cm/min (150 in./min)
160 A	1.4 mm (.052 in.)	18 V	356 cm/min (140 in./min)
325 A	1.4 mm (.052 in.)	28 V	787 cm/min (310 in./min)
275-400 A	1.4 mm (.052 in.)	26-33 V	673-991 cm/min (265-390 in./min)

Spoolarc 86

Parámetros de soldadura			
Corriente	Diámetro del Alambre	Tensión	Velocidad de Alimentación
150-200 A	1.4 mm (.052 in.)	17-20 V	343-483 cm/min (135-190 in./min)
340 A	1.6 mm (1/16 in.)	27 V	508 cm/min (200 in./min)
290-400 A	1.6 mm (1/16 in.)	26-36 V	457-711 cm/min (180-280 in./min)
Transferencia de arco corto Optimum			
70 A	0.6 mm (.023 in.)	15 V	762 cm/min (300 in./min)
100-125 A	0.6 mm (.023 in.)	23-25 V	1016-1575 cm/min (400-620 in./min)
45-90 A	0.6 mm (.023 in.)	14-16 V	381-965 cm/min (150-380 in./min)
110 A	0.6 mm (.023 in.)	23 V	1143 cm/min (450 in./min)
180 A	0.8 mm (.030 in.)	25 V	1321 cm/min (520 in./min)
100 A	0.8 mm (.030 in.)	15 V	559 cm/min (220 in./min)
160-200 A	0.8 mm (.030 in.)	24-26 V	1270-1651 cm/min (500-650 in./min)
60-140 A	0.8 mm (.030 in.)	14-16 V	381-889 cm/min (150-350 in./min)
180-230 A	0.9 mm (.035 in.)	25-27 V	1016-1397 cm/min (400-550 in./min)
130 A	0.9 mm (.035 in.)	17 V	635 cm/min (250 in./min)
90-160 A	0.9 mm (.035 in.)	15-19 V	457-762 cm/min (180-300 in./min)
200 A	0.9 mm (.035 in.)	26 V	1219 cm/min (480 in./min)
260-340 A	1.2 mm (.045 in.)	25-30 V	762-1270 cm/min (300-500 in./min)
300 A	1.2 mm (.045 in.)	27 V	889 cm/min (350 in./min)
130-200 A	1.2 mm (.045 in.)	17-19 V	318-508 cm/min (125-200 in./min)
160 A	1.2 mm (.045 in.)	18 V	381 cm/min (150 in./min)
160 A	1.4 mm (.052 in.)	18 V	356 cm/min (140 in./min)
325 A	1.4 mm (.052 in.)	28 V	787 cm/min (310 in./min)
275-400 A	1.4 mm (.052 in.)	26-33 V	673-991 cm/min (265-390 in./min)
150-200 A	1.4 mm (.052 in.)	17-20 V	343-483 cm/min (135-190 in./min)
340 A	1.6 mm (1/16 in.)	27 V	508 cm/min (200 in./min)
290-400 A	1.6 mm (1/16 in.)	26-36 V	457-711 cm/min (180-280 in./min)

Spoolarc 86

Parámetros de soldadura			
Corriente	Diámetro del Alambre	Tensión	Velocidad de Alimentación
Transferencia con pulverización			
70 A	0.6 mm (.023 in.)	15 V	762 cm/min (300 in./min)
100-125 A	0.6 mm (.023 in.)	23-25 V	1016-1575 cm/min (400-620 in./min)
45-90 A	0.6 mm (.023 in.)	14-16 V	381-965 cm/min (150-380 in./min)
110 A	0.6 mm (.023 in.)	23 V	1143 cm/min (450 in./min)
180 A	0.8 mm (.030 in.)	25 V	1321 cm/min (520 in./min)
100 A	0.8 mm (.030 in.)	15 V	559 cm/min (220 in./min)
160-200 A	0.8 mm (.030 in.)	24-26 V	1270-1651 cm/min (500-650 in./min)
60-140 A	0.8 mm (.030 in.)	14-16 V	381-889 cm/min (150-350 in./min)
180-230 A	0.9 mm (.035 in.)	25-27 V	1016-1397 cm/min (400-550 in./min)
130 A	0.9 mm (.035 in.)	17 V	635 cm/min (250 in./min)
90-160 A	0.9 mm (.035 in.)	15-19 V	457-762 cm/min (180-300 in./min)
200 A	0.9 mm (.035 in.)	26 V	1219 cm/min (480 in./min)
260-340 A	1.2 mm (.045 in.)	25-30 V	762-1270 cm/min (300-500 in./min)
300 A	1.2 mm (.045 in.)	27 V	889 cm/min (350 in./min)
130-200 A	1.2 mm (.045 in.)	17-19 V	318-508 cm/min (125-200 in./min)
160 A	1.2 mm (.045 in.)	18 V	381 cm/min (150 in./min)
160 A	1.4 mm (.052 in.)	18 V	356 cm/min (140 in./min)
325 A	1.4 mm (.052 in.)	28 V	787 cm/min (310 in./min)
275-400 A	1.4 mm (.052 in.)	26-33 V	673-991 cm/min (265-390 in./min)
150-200 A	1.4 mm (.052 in.)	17-20 V	343-483 cm/min (135-190 in./min)
340 A	1.6 mm (1/16 in.)	27 V	508 cm/min (200 in./min)
290-400 A	1.6 mm (1/16 in.)	26-36 V	457-711 cm/min (180-280 in./min)
Transferencia de arco corto			
70 A	0.6 mm (.023 in.)	15 V	762 cm/min (300 in./min)
100-125 A	0.6 mm (.023 in.)	23-25 V	1016-1575 cm/min (400-620 in./min)

Spoolarc 86

Parámetros de soldadura

Corriente	Diámetro del Alambre	Tensión	Velocidad de Alimentación
45-90 A	0.6 mm (.023 in.)	14-16 V	381-965 cm/min (150-380 in./min)
110 A	0.6 mm (.023 in.)	23 V	1143 cm/min (450 in./min)
180 A	0.8 mm (.030 in.)	25 V	1321 cm/min (520 in./min)
100 A	0.8 mm (.030 in.)	15 V	559 cm/min (220 in./min)
160-200 A	0.8 mm (.030 in.)	24-26 V	1270-1651 cm/min (500-650 in./min)
60-140 A	0.8 mm (.030 in.)	14-16 V	381-889 cm/min (150-350 in./min)
180-230 A	0.9 mm (.035 in.)	25-27 V	1016-1397 cm/min (400-550 in./min)
130 A	0.9 mm (.035 in.)	17 V	635 cm/min (250 in./min)
90-160 A	0.9 mm (.035 in.)	15-19 V	457-762 cm/min (180-300 in./min)
200 A	0.9 mm (.035 in.)	26 V	1219 cm/min (480 in./min)
260-340 A	1.2 mm (.045 in.)	25-30 V	762-1270 cm/min (300-500 in./min)
300 A	1.2 mm (.045 in.)	27 V	889 cm/min (350 in./min)
130-200 A	1.2 mm (.045 in.)	17-19 V	318-508 cm/min (125-200 in./min)
160 A	1.2 mm (.045 in.)	18 V	381 cm/min (150 in./min)
160 A	1.4 mm (.052 in.)	18 V	356 cm/min (140 in./min)
325 A	1.4 mm (.052 in.)	28 V	787 cm/min (310 in./min)
275-400 A	1.4 mm (.052 in.)	26-33 V	673-991 cm/min (265-390 in./min)
150-200 A	1.4 mm (.052 in.)	17-20 V	343-483 cm/min (135-190 in./min)
340 A	1.6 mm (1/16 in.)	27 V	508 cm/min (200 in./min)
290-400 A	1.6 mm (1/16 in.)	26-36 V	457-711 cm/min (180-280 in./min)