

780

## Recommended Welding Parameters

Hardness: 65-67 Rockwell "C"

63-MCO - Open arc, metal cored wire

Diameter	Polarity	Current (amps)	Voltage	ESO
.045"	DCEP	150-200	23-27	1/2"-1"
1/16"	DCEP	200-270	24-28	3/4"-1 1/4"
5/64"	DCEP	220-350	24-29	3/4"-1 1/4"
7/64"	DCEP	300-450	24-31	1 1/4"-1 3/4"
1/8"	DCEP	450-650	26-34	1 1/4"-1 3/4"