

Welding & Cleaning Programs for STEEL, TITANIUM, NICKEL ALLOYS

FUSION WELDING			20 ga 0.038"	16 ga 0.063"	14 ga 0.078"	11 ga 0.125"	9 ga 0.156"	6 ga 0.203"	4 ga 0.234"
METAL	SHIELDING GAS	PROGRAM							
STAINLESS STEEL	NITROGEN	A1	250 W	400 W	500 W	800 W	1000 W	1300 W	1500 W*
MILD STEEL	NITROGEN	A4	250 W	400 W	500 W	800 W	1000 W	1300 W	1500 W*
GALVANIZED STEEL	NITROGEN	A7	250 W	400 W	500 W	800 W	1000 W	1300 W	1500 W*
TITANIUM	ARGON	E1	250 W	400 W	500 W	800 W	1100 W	1500 W*	
NICKEL ALLOYS	NITROGEN	E4	300 W	480 W	600 W	900 W	1100 W	1400 W*	

*Adjust wobble frequency value to -50

TACK WELDING			20 ga 0.038"	16 ga 0.063"	14 ga 0.078"	11 ga 0.125"	9 ga 0.156"	6 ga 0.203"	4 ga 0.234"
METAL	SHIELDING GAS	PROGRAM							
STAINLESS STEEL	NITROGEN	A0	220 W	260 W	450 W	750 W	1000 W	1350 W	-
MILD STEEL	NITROGEN	A3	220 W	390 W	500 W	800 W	1050 W	1400 W	-
TITANIUM	ARGON	E0	220 W	360 W	450 W	750 W	1000 W	1350 W	-
NICKEL ALLOYS	NITROGEN	E3	250 W	430 W	550 W	850 W	1150 W	1500 W	-

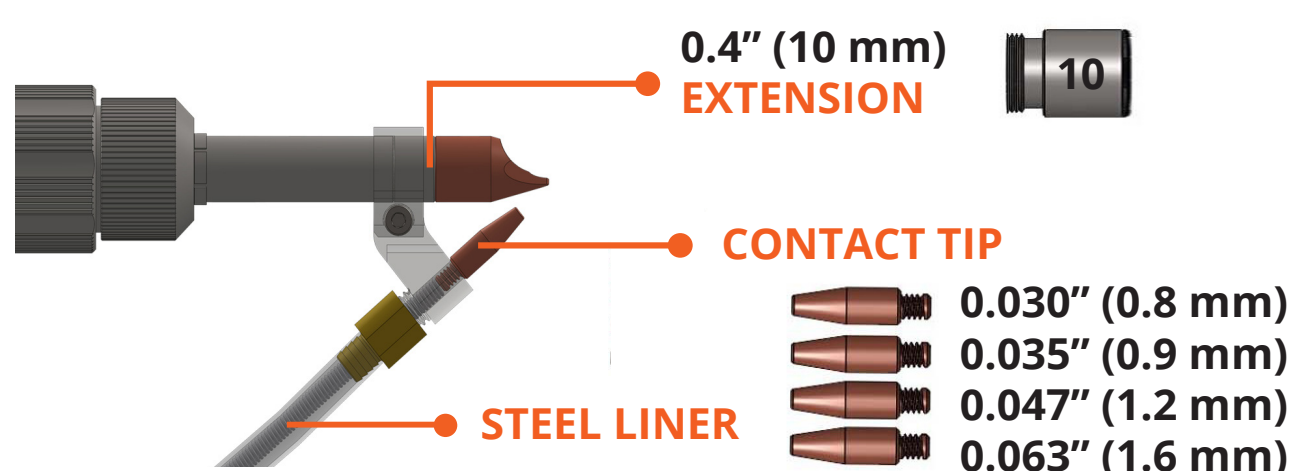
METAL	INTENSITY		
	LOW	MEDIUM	HIGH
STEELS, TITANIUM, NICKEL ALLOYS	C0	C1	C2

HARD WIRE WELDING				20 ga 0.038"	16 ga 0.063"	14 ga 0.078"	11 ga 0.125"	9 ga 0.156"	6 ga 0.203"	
METAL	SHIELDING GAS	WIRE ALLOY	WIRE SIZE	PROGRAM						
STAINLESS STEEL	NITROGEN	308LSi	0.045"	A2	350 W	530 W	650 W	950 W	1250 W	1500 W*
					16 ipm	15 ipm	14 ipm	12 ipm	12 ipm	10 ipm
MILD STEEL	NITROGEN	ER70S-6	0.045"	A5	350 W	530 W	650 W	950 W	1250 W	1500 W*
					14 ipm	13 ipm	12 ipm	10 ipm	10 ipm	8 ipm
NICKEL ALLOYS	NITROGEN	ERNi-1	0.045"	E5	400 W	610 W	750 W	1100 W	1450 W	-
					18 ipm	17 ipm	16 ipm	14 ipm	12 ipm	-

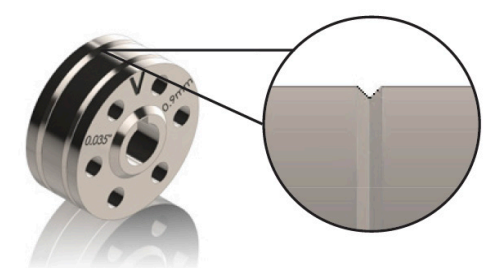
*Adjust wobble frequency value to -50

HARD WIRE WELDING CONFIGURATION

HARD WIRE



Wire Feeder Programs require LightWELD Wire Feeder.



V - Groove



Welding & Cleaning Programs for ALUMINUM & COPPER

FUSION WELDING

METAL	SHIELDING GAS	PROGRAM	18 ga 0.040"	14 ga 0.064"	12 ga 0.081"	8 ga 0.129"	6 ga 0.162"	4 ga 0.204"	3 ga 0.229"
ALUMINUM 5XXX	ARGON	F1	300 W	480 W	600 W	900 W	1200 W	1350 W*	1500 W*
ALUMINUM 6XXX	ARGON	F4	300 W	480 W	600 W	900 W	1200 W	1400 W*	-
ALUMINUM 3XXX	ARGON	F7	350 W	530 W	650 W	1000 W	1200 W	1350 W*	1500 W*
COPPER	NITROGEN	J1	900 W	1200 W	1400 W	-	-	-	-

*Adjust wobble frequency value to -50

TACK WELDING

METAL	SHIELDING GAS	PROGRAM	18 ga 0.040"	14 ga 0.064"	12 ga 0.081"	8 ga 0.129"	6 ga 0.162"	4 ga 0.204"	3 ga 0.229"
ALUMINUM 5XXX	ARGON	F0	350 W*	500 W	600 W	900 W	1200 W	-	-
ALUMINUM 6XXX	ARGON	F3	350 W*	500 W	600 W	900 W	1200 W	-	-
ALUMINUM 3XXX	ARGON	F6	350 W*	530 W	600 W	1050 W	1500 W	-	-

*Adjust wobble frequency (tack time) value to -50

CLEANING

METAL	INTENSITY		
	LOW	MEDIUM	HIGH
ALUMINUM	H0	H1	H2

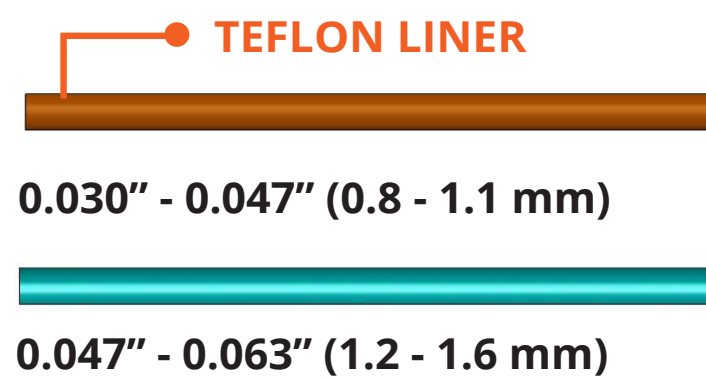
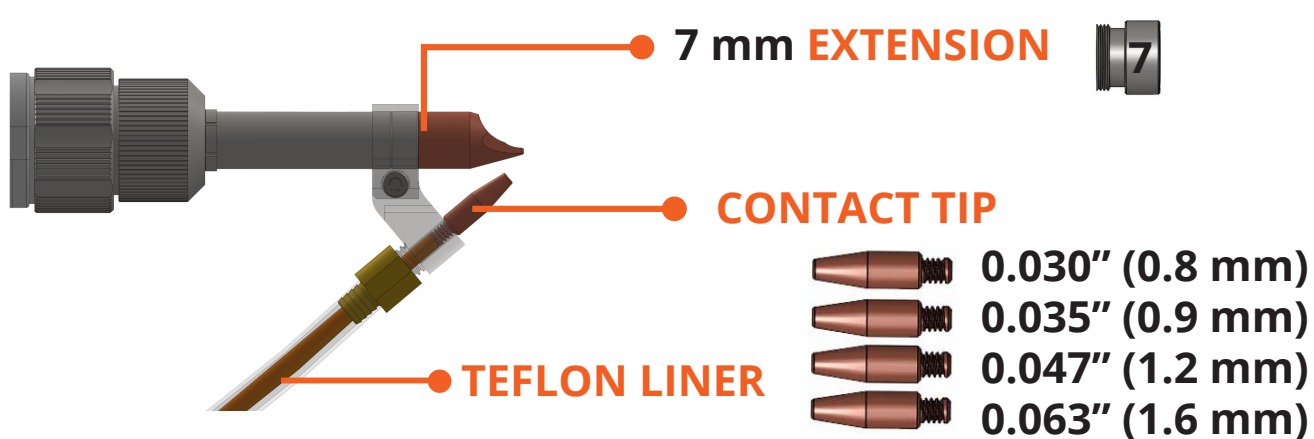
SOFT WIRE WELDING

METAL	SHIELDING GAS	WIRE ALLOY	WIRE SIZE	PROGRAM	18 ga 0.040"	14 ga 0.064"	12 ga 0.081"	8 ga 0.129"	6 ga 0.162"	3 ga 0.204"
ALUMINUM 5XXX	ARGON	ER5356	0.047"	F2	400 W	580 W	700 W	1050 W	1300 W	1500 W*
					20 ipm	20 ipm	20 ipm	20 ipm	18 ipm	14 ipm
ALUMINUM 6XXX	ARGON	ER5356	0.047"	F5	400 W	580 W	700 W	1050 W	1300 W	1500 W
					20 ipm	20 ipm	20 ipm	20 ipm	18 ipm	14 ipm
COPPER	NITROGEN	ERCu	0.045"	J2	1000 W	1300 W	1500 W	-	-	-
					18 ipm	16 ipm	14 ipm	-	-	-

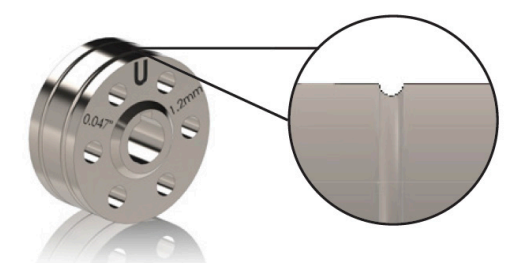
*Adjust wobble frequency value to -50

SOFT WIRE WELDING CONFIGURATION

SOFT WIRE



Wire Feeder Programs require LightWELD Wire Feeder.



U - Groove

