

Welding & Cleaning Programs for STEEL, TITANIUM, NICKEL ALLOYS

FUSION WELDING											
METAL	SHIELDING GAS	PROGRAM	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"	1 ga 0.281"	0 ga 0.313"
STAINLESS STEEL	NITROGEN	A1	250 W	400 W	500 W	800 W	1000 W	1300 W	1500 W*	1750 W*	2000 W*
MILD STEEL	NITROGEN	A4	250 W	400 W	500 W	800 W	1000 W	1300 W	1500 W*	1750 W*	2000 W*
GALVANIZED STEEL	NITROGEN	A7	250 W	400 W	500 W	800 W	1000 W	1300 W	1500 W*	1750 W*	2000 W*
TITANIUM	ARGON	E1	250 W	400 W	500 W	800 W	1100 W	1500 W*	1900 W*	-	-
NICKEL ALLOYS	NITROGEN	E4	300 W	480 W	600 W	900 W	1100 W	1400 W*	1650 W*	2000 W*	-

*Adjust wobble frequency value to -50

TACK WELDING											
METAL	SHIELDING GAS	PROGRAM	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"	1ga 0.281"	0 ga 0.313"
STAINLESS STEEL	NITROGEN	A0	220 W	360 W	450 W	750 W	1000 W	1350 W	1650 W	2000 W	-
MILD STEEL	NITROGEN	A3	220 W	390 W	500 W	800 W	1050 W	1400 W	1700 W	-	-
TITANIUM	ARGON	E0	220 W	360 W	450 W	750 W	1000 W	1350 W	1750 W	-	-
NICKEL ALLOYS	NITROGEN	E3	250 W	430 W	550 W	850 W	1150 W	1500 W	1950 W	-	-

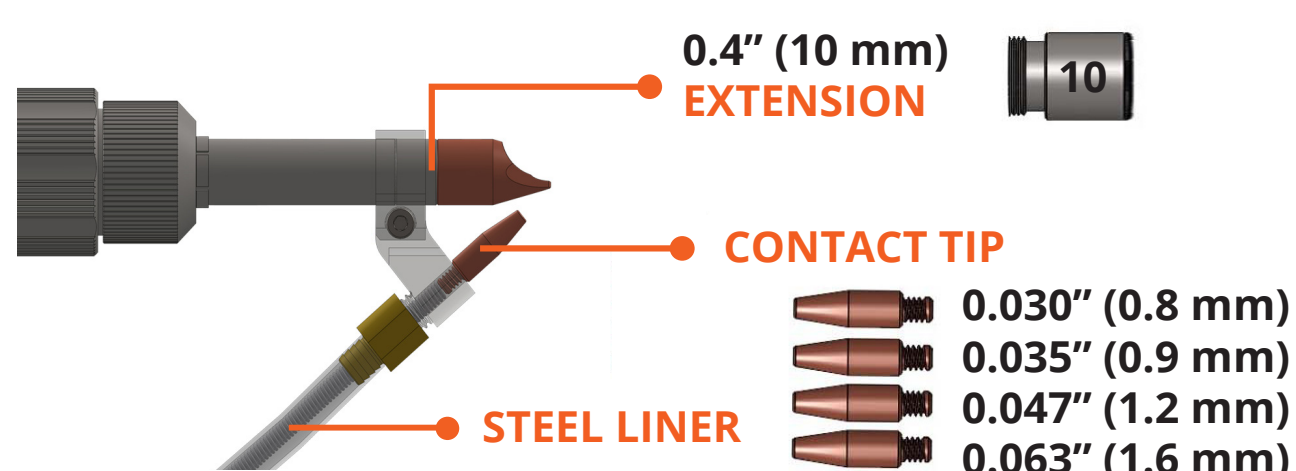
CLEANING			
METAL	INTENSITY		
	LOW	MEDIUM	HIGH
STEELS, TITANIUM, NICKEL ALLOYS	C0	C1	C2

HARD WIRE WELDING											
METAL	SHIELDING GAS	WIRE ALLOY	WIRE SIZE	PROGRAM	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"
STAINLESS STEEL	NITROGEN	308LSi	0.045"	A2	350 W	530 W	650 W	950 W	1250 W	1500 W*	1800W*
					16 ipm	15 ipm	14 ipm	12 ipm	12 ipm	10 ipm	8 ipm
MILD STEEL	NITROGEN	ER70S-6	0.045"	A5	350 W	530 W	650 W	950 W	1250 W	1500 W*	1800 W*
					14 ipm	13 ipm	12 ipm	10 ipm	10 ipm	8 ipm	6 ipm
NICKEL ALLOYS	NITROGEN	ERNi-1	0.045"	E5	400 W	610 W	750 W	1100 W	1450 W	1850 W	-
					18 ipm	17 ipm	16 ipm	14 ipm	12 ipm	10 ipm	-

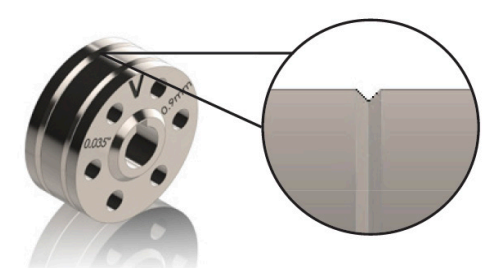
*Adjust wobble frequency to -50

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"	1 ga 0.289"	0 ga 0.325"
ALUMINUM 5XXX	ARGON	F1	300 W	480 W	600 W	900 W	1200 W	1350 W*	1500 W*	1750 W*	2000 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*	1750 W*	2000 W*
COPPER	NITROGEN	J1	900 W	1200 W	1400 W	2000 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"	1 ga 0.289"	0 ga 0.325"
ALUMINUM 5XXX	ARGON	F0	350 W*	500 W	600 W	900 W	1200 W	1600 W	2000 W	-	-
ALUMINUM 6XXX	ARGON	F3	350 W*	500 W	600 W	900 W	1200 W	1600 W	2000 W	-	-
ALUMINUM 3XXX	ARGON	F6	350 W*	530 W	650 W	1050 W	1500 W	2000 W	-	-	-

*Adjust wobble frequency value to -50

CLEANING

METAL	INTENSITY		
	LOW	MEDIUM	HIGH
ALUMINUM	H0	H1	H2

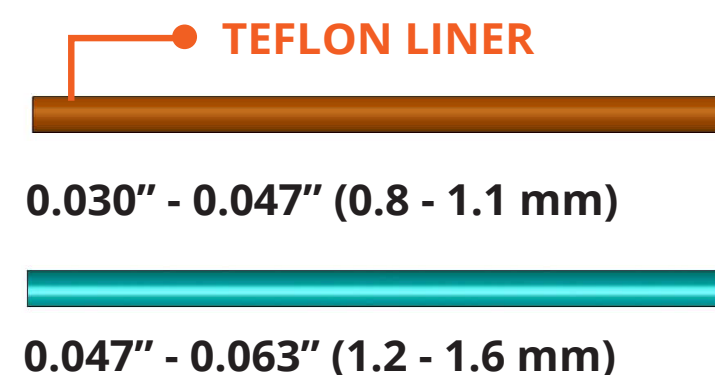
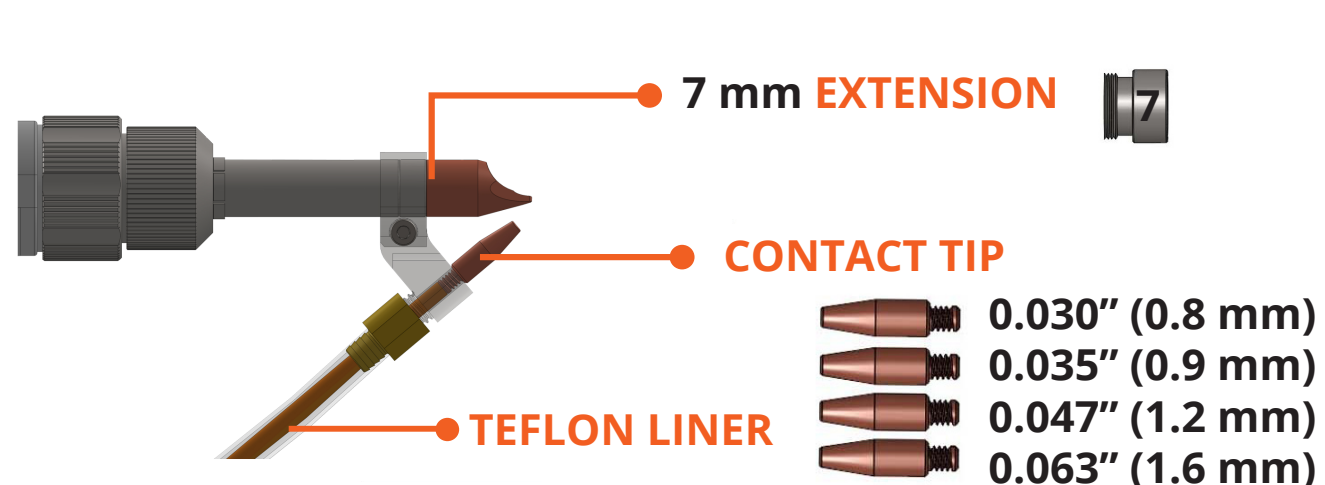
SOFT WIRE WELDING

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"	4 ga 0.204"	3 ga 0.229"
ALUMINUM 5XXX	ARGON	ER5356	0.047"	F2	400 W	580 W	700 W	1050 W	1300 W	1500 W*	1800W*
					20 ipm	20 ipm	20 ipm	20 ipm	18 ipm	14 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	2000 W	-	-	-
					18 ipm	16 ipm	14 ipm	10 ipm	-	-	-

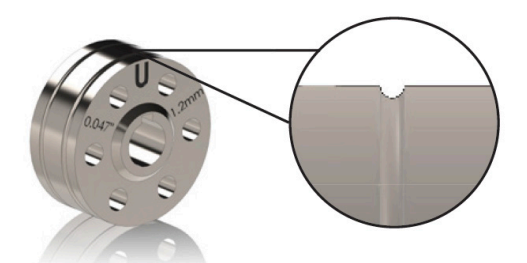
*Adjust wobble frequency (tack time) value to -50

SOFT WIRE WELDING CONFIGURATION

SOFT WIRE



Wire Feeder Programs require LightWELD Wire Feeder.



U - Groove

