



Power Wave 455M/STT-CE

Weld Set Reference: Z06E041i

Steel		
Procedure	Gas Type	Mode
0.8mm Wire Size		
CV	CO ₂	93
CV	Argon Mix	94
Pulse	Argon Mix	95
1.0mm Wire Size		
CV	CO ₂	10
CV	Argon Mix	11
Pulse	Argon Mix	12
Pulse RapidArc	Argon CO ₂	13
STT	Argon CO ₂	112
STT Open Root	CO ₂	113
1.2mm Wire Size		
CV	CO ₂	20
CV	Argon Mix	21
Pulse	Argon Mix	22
Pulse RapidArc	Argon CO ₂	18
STT	Argon CO ₂	118
STT Open Root	CO ₂	119

Stainless		
Procedure	Gas Type	Mode
0.8mm Wire Size		
CV	Argon Mix	61
CV	Ar He CO ₂	63
Pulse	Ar He CO ₂	64
Pulse	Argon CO ₂	66
1.0mm Wire Size		
CV	Argon Mix	31
CV	Ar He CO ₂	33
Pulse	Ar He CO ₂	34
Pulse	Argon CO ₂	36
STT	Argon CO ₂	131
1.2mm Wire Size		
CV	Argon Mix	41
CV	Ar He CO ₂	43
Pulse	Ar He CO ₂	44
Pulse	Argon CO ₂	46
STT	Argon CO ₂	133

Aluminum AISi		
Procedure	Gas Type	Mode
1.0mm Wire Size		
CV	Argon	148
Pulse	Argon	149
Pulse on Pulse	Argon	98
1.2mm Wire Size		
CV	Argon	71
Pulse	Argon	72
Pulse on Pulse	Argon	99
1.6mm Wire Size		
CV	Argon	73
Pulse	Argon	74
Pulse on Pulse	Argon	100

Aluminum AlMg		
Procedure	Gas Type	Mode
1.0mm Wire Size		
CV	Argon	151
Pulse	Argon	152
Pulse on Pulse	Argon	101
1.2mm Wire Size		
CV	Argon	75
Pulse	Argon	76
Pulse on Pulse	Argon	102
1.6mm Wire Size		
CV	Argon	77
Pulse	Argon	78
Pulse on Pulse	Argon	103

General		
Stick/Tig/Gouge		
Stick Soft		1
Stick Crisp		2
Touch Start TIG	Argon	3
Gouging		9
Wire Welding (Non Synergic)		
CV MIG		5
FCAW-SS	Self Shielded	6
Power mode		40
STT II (1.0 mm)		123
STT II (1.2 mm)		124

Metal Core		
1.2mm Wire Size		
CV	Argon CO ₂	81
Pulse	Argon CO ₂	82
1.4mm Wire Size		
CV	Argon CO ₂	83
Pulse	Argon CO ₂	84
1.6mm Wire Size		
CV	Argon CO ₂	85
Pulse	Argon CO ₂	86

Flux Core		
1.2mm Wire Size		
CV	CO ₂	90
CV	Argon CO ₂	91
Nickel Alloy		
1.0mm Wire Size		
Pulse	Ar He	170
1.2mm Wire Size		
Pulse	Ar He	175
Silicon Bronze		
1.0mm Wire Size		
Pulse	Argon	192



CONTENTS OF WELDING SOFTWARE Z06E041i

Mode	Process	Procedure	Wire Size	Wire Type	Gas	ArcControl	
1	SMAW	Stick Soft				Arc Force	N.A., N.B
2	SMAW	Stick Crisp				Arc Force	N.A., N.B
3	GTAW	Touch Start TIG			Argon Blends	n/a	N.A., N.B
5	GMAW	CV MIG (NonSyn)				Pinch	N.A., N.B
6	FCAW-SS	FCAW-SS (NonSyn)			Self Shielded	Pinch	N.A., N.B
9	GOUGE	Gouging			Air	Arc Force	
10	GMAW	CV	1.0mm	Steel	CO2	Pinch	
11	GMAW	CV	1.0mm	Steel	Argon Blends	Pinch	
12	GMAW-P	Pulse	1.0mm	Steel	Argon Blends	Wave Control	
13	GMAW-P	Pulse - RapidArc	1.0mm	Steel	Argon CO2 Blends	Wave Control	
18	GMAW-P	Pulse - RapidArc	1.2mm	Steel	Argon CO2 Blends	Wave Control	
20	GMAW	CV	1.2mm	Steel	CO2	Pinch	
21	GMAW	CV	1.2mm	Steel	Argon Blends	Pinch	
22	GMAW-P	Pulse	1.2mm	Steel	Argon Blends	Wave Control	
31	GMAW	CV	1.0mm	Stainless	Argon Blends	Pinch	
33	GMAW	CV	1.0mm	Stainless	Argon Helium CO2	Pinch	
34	GMAW-P	Pulse	1.0mm	Stainless	Argon Helium CO2	Wave Control	
36	GMAW-P	Pulse	1.0mm	Stainless	Argon Blends	Wave Control	
40	GMAW	Power Mode (NonSyn)				Pinch	N.A., N.B
41	GMAW	CV	1.2mm	Stainless	Argon Blends	Pinch	
43	GMAW	CV	1.2mm	Stainless	Argon Helium CO2	Pinch	
44	GMAW-P	Pulse	1.2mm	Stainless	Argon Helium CO2	Wave Control	
46	GMAW-P	Pulse	1.2mm	Stainless	Argon CO2 Blends	Wave Control	
61	GMAW	CV	0.8mm	Stainless	Argon Blends	Pinch	
63	GMAW	CV	0.8mm	Stainless	Argon Helium CO2	Pinch	
64	GMAW-P	Pulse	0.8mm	Stainless	Argon Helium CO2	Wave Control	
66	GMAW-P	Pulse	0.8mm	Stainless	Argon CO2 Blends	Wave Control	
71	GMAW	CV	1.2mm	Aluminum (AlSi)	Argon	Pinch	
72	GMAW-P	Pulse	1.2mm	Aluminum (AlSi)	Argon	Wave Control	
73	GMAW	CV	1.6mm	Aluminum (AlSi)	Argon	Pinch	
74	GMAW-P	Pulse	1.6mm	Aluminum (AlSi)	Argon	Wave Control	
75	GMAW	CV	1.2mm	Aluminum (AlMg)	Argon	Pinch	
76	GMAW-P	Pulse	1.2mm	Aluminum (AlMg)	Argon	Wave Control	
77	GMAW	CV	1.6mm	Aluminum (AlMg)	Argon	Pinch	
78	GMAW-P	Pulse	1.6mm	Aluminum (AlMg)	Argon	Wave Control	
81	GMAW	CV	1.2mm	Metal Core	Argon CO2 Blends	Pinch	
82	GMAW-P	Pulse	1.2mm	Metal Core	Argon CO2 Blends	Wave Control	
83	GMAW	CV	1.4mm	Metal Core	Argon CO2 Blends	Pinch	
84	GMAW-P	Pulse	1.4mm	Metal Core	Argon CO2 Blends	Wave Control	
85	GMAW	CV	1.6mm	Metal Core	Argon CO2 Blends	Pinch	
86	GMAW-P	Pulse	1.6mm	Metal Core	Argon CO2 Blends	Wave Control	
90	FCAW-GS	Flux Core	1.2mm	Gas Shield	CO2	Pinch	
91	FCAW-GS	Flux Core	1.2mm	Gas Shield	Argon CO2 Blends	Pinch	
93	GMAW	CV	0.8mm	Steel	CO2	Pinch	
94	GMAW	CV	0.8mm	Steel	Argon Blends	Pinch	
95	GMAW-P	Pulse	0.8mm	Steel	Argon Blends	Wave Control	
98	GMAW-P	Pulse on Pulse	1.0mm	Aluminum (AlSi)	Argon	Modulation Freq	
99	GMAW-P	Pulse on Pulse	1.2mm	Aluminum (AlSi)	Argon	Modulation Freq	
100	GMAW-P	Pulse on Pulse	1.6mm	Aluminum (AlSi)	Argon	Modulation Freq	
101	GMAW-P	Pulse on Pulse	1.0mm	Aluminum (AlMg)	Argon	Modulation Freq	
102	GMAW-P	Pulse on Pulse	1.2mm	Aluminum (AlMg)	Argon	Modulation Freq	
103	GMAW-P	Pulse on Pulse	1.6mm	Aluminum (AlMg)	Argon	Modulation Freq	
112	GMAW	Synergic STT	1.0mm	Steel	GMAW	Peak	
113	GMAW	Synergic STT	1.0mm	Steel	GMAW	Peak	
118	GMAW	Synergic STT	1.2mm	Steel	GMAW	Peak	
119	GMAW	Synergic STT	1.2mm	Steel	GMAW	Peak	
123	GMAW	STT II (Non Syn)	1.0mm	Steel, Stainless	CO2, Argon CO2	STT II Controls	N.A., N.B., N.C.
124	GMAW	STT II (Non Syn)	1.2mm	Steel, Stainless	CO2, Argon CO2	STT II Controls	N.A., N.B., N.C.
131	GMAW	Synergic STT	1.0mm	Stainless	GMAW	Peak	
133	GMAW	Synergic STT	1.2mm	Stainless	GMAW	Peak	
148	GMAW	CV	1.0mm	Aluminum (AlSi)	Argon	Pinch	
149	GMAW-P	Pulse	1.0mm	Aluminum (AlSi)	Argon	Wave Control	
151	GMAW	CV	1.0mm	Aluminum (AlMg)	Argon	Pinch	
152	GMAW-P	Pulse	1.0mm	Aluminum (AlMg)	Argon	Wave Control	
170	GMAW-P	Pulse - NonAdaptive	1.0mm	Ni Alloy	Argon Helium	Wave Control	
175	GMAW-P	Pulse - NonAdaptive	1.2mm	Ni Alloy	Argon Helium	Wave Control	
192	GMAW-P	Pulse	1.0mm	Si Bronze	Argon	Wave Control	

Notes:

- N.A. May not be available on machines equipped with analog interface.
- N.B. Not fully supported by Fanuc/DeviceNet implementation.
- N.C. Peak, Background, Tailout and Hot Start set via Wave Controls 1-4.
Not supported by wire feeders with MSP3 panel or by Fanuc/ArcLink prior to Fanuc ArcTool Version 6.4.



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