

Weld Set Reference: Z123334

Power Wave® AC/DC 1000SD™

	Single Arc Mild Steel								TwinArc® Mild Steel			Single Arc Stainless				Single Arc Cored			Single Arc Nickel			Buried Arc Mild Steel				Buried Arc Stainless			Modified Series Arc				
	1/4"	7/32"	3/16"	5/32"	1/8"	3/32"	5/64"	1/16"	3/32"	5/64"	1/16"	5/32"	1/8"	3/32"	5/64"	5/32"	1/8"	3/32"	3/32"		1/16"	5/32"	1/8"	3/32"	5/64"		1/8"			3/16" & 1/8"			
CC 60Hz Sine	12	22	32	42	52	62																											
CC 50Hz Sine	13	23	33	43	53	63																										301	
CV DC-	14	24	34	44	54	64	74	84	164	174	184	344	354	364	374	444	454	464	564		584												
CV DC+	15	25	35	45	55	65	75	85	165	175	185	345	355	365	375	445	455	465	565		585	602	603	604	605		608						
CV Square Wave	16	26	36	46	56	66	76	86	166	176	186	346	356	366	376	446	456	466	566		586												
CC DC-	17	27	37	47	57	67	77	87	167	177	187	347	357	367	377	447	457	467	567		587												
CC DC+	18	28	38	48	58	68	78	88	168	178	188	348	358	368	378	448	458	468	568		588												
CC Square Wave	19	29	39	49	59	69	79	89	169	179	189	349	359	369	379	449	459	469	569		589											300	



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Mode	Wire Type	Wire Size	Process	Range	Units	Voltage	Frequency	Offset	Balance
12	Steel	1/4in	CC 60Hz Sine	200 - 3000	A	20.0 - 60.0	60	-25 to +25	50
13	Steel	1/4in	CC 50Hz Sine	200 - 3000	A	20.0 - 60.0	50	-25 to +25	50
14	Steel	1/4in	CV DC-	30 - 256	IPM	20.0 - 60.0			
15	Steel	1/4in	CV DC+	18 - 256	IPM	20.0 - 60.0			
16	Steel	1/4in	CV Square Wave	25 - 310	IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
17	Steel	1/4in	CC DC-	200 - 3000	A	20.0 - 60.0			
18	Steel	1/4in	CC DC+	200 - 3000	A	20.0 - 60.0			
19	Steel	1/4in	CC Square Wave	200 - 3000	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
23	Steel	7/32in	CC 50Hz Sine	200 - 3000	A	20.0 - 60.0	50	-25 to +25	50
24	Steel	7/32in	CV DC-	30 - 256	IPM	20.0 - 60.0			
25	Steel	7/32in	CV DC+	18 - 256	IPM	20.0 - 60.0			
26	Steel	7/32in	CV Square Wave	25 - 310	IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
27	Steel	7/32in	CC DC-	200 - 3000	A	20.0 - 60.0			
28	Steel	7/32in	CC DC+	200 - 3000	A	20.0 - 60.0			
29	Steel	7/32in	CC Square Wave	200 - 3000	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
32	Steel	3/16in	CC 60Hz Sine	200 - 3000	A	20.0 - 60.0	60	-25 to +25	50
33	Steel	3/16in	CC 50Hz Sine	200 - 3000	A	20.0 - 60.0	50	-25 to +25	50
34	Steel	3/16in	CV DC-	30 - 256	IPM	20.0 - 60.0			
35	Steel	3/16in	CV DC+	25 - 256	IPM	20.0 - 60.0			
36	Steel	3/16in	CV Square Wave	25 - 310	IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
37	Steel	3/16in	CC DC-	200 - 3000	A	20.0 - 60.0			
38	Steel	3/16in	CC DC+	200 - 3000	A	20.0 - 60.0			
39	Steel	3/16in	CC Square Wave	200 - 3000	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
42	Steel	5/32in	CC 60Hz Sine	200 - 2000	A	20.0 - 60.0	60	-25 to +25	50
43	Steel	5/32in	CC 50Hz Sine	200 - 2000	A	20.0 - 60.0	50	-25 to +25	50
45	Steel	5/32in	CV DC+	30 - 256	IPM	20.0 - 60.0			
46	Steel	5/32in	CV Square Wave	25 - 310	IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
47	Steel	5/32in	CC DC-	200 - 2000	A	20.0 - 60.0			
48	Steel	5/32in	CC DC+	200 - 2000	A	20.0 - 60.0			
49	Steel	5/32in	CC Square Wave	200 - 2000	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
52	Steel	1/8in	CC 60Hz Sine	200 - 2000	A	20.0 - 60.0	60	-25 to +25	50
53	Steel	1/8in	CC 50Hz Sine	200 - 2000	A	20.0 - 60.0	50	-25 to +25	50
54	Steel	1/8in	CV DC-	30 - 256	IPM	20.0 - 60.0			
55	Steel	1/8in	CV DC+	30 - 256	IPM	20.0 - 60.0			
56	Steel	1/8in	CV Square Wave	25 - 310	IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
57	Steel	1/8in	CC DC-	200 - 2000	A	20.0 - 60.0			
58	Steel	1/8in	CC DC+	200 - 2000	A	20.0 - 60.0			
59	Steel	1/8in	CC Square Wave	200 - 2000	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
62	Steel	3/32in	CC 60Hz Sine	200 - 2000	A	20.0 - 60.0	60	-25 to +25	50
63	Steel	3/32in	CC 50Hz Sine	200 - 2000	A	20.0 - 60.0	50	-25 to +25	50
64	Steel	3/32in	CV DC-	30 - 280	IPM	20.0 - 60.0			
65	Steel	3/32in	CV DC+	30 - 256	IPM	20.0 - 60.0			
66	Steel	3/32in	CV Square Wave	30 - 310	IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
67	Steel	3/32in	CC DC-	200 - 1000	A	20.0 - 60.0			
68	Steel	3/32in	CC DC+	200 - 1000	A	20.0 - 60.0			
69	Steel	3/32in	CC Square Wave	200 - 1000	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
74	Steel	5/64in	CV DC-	30 - 306	IPM	20.0 - 60.0			
75	Steel	5/64in	CV DC+	30 - 256	IPM	20.0 - 60.0			
76	Steel	5/64in	CV Square Wave	30 - 310	IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
77	Steel	5/64in	CC DC-	200 - 2000	A	20.0 - 60.0			
78	Steel	5/64in	CC DC+	200 - 2000	A	20.0 - 60.0			
79	Steel	5/64in	CC Square Wave	200 - 2000	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
84	Steel	1/16in	CV DC-	30 - 500	IPM	20.0 - 60.0			
85	Steel	1/16in	CV DC+	30 - 500	IPM	20.0 - 60.0			
86	Steel	1/16in	CV Square Wave	30 - 500	IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
87	Steel	1/16in	CC DC-	200 - 2000	A	20.0 - 60.0			
88	Steel	1/16in	CC DC+	200 - 2000	A	20.0 - 60.0			
89	Steel	1/16in	CC Square Wave	30 - 500	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75



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Mode	Wire Type	Wire Size	Process	Range	Units	Voltage	Frequency	Offset	Balance
164	Steel	3/32in	CV DC- Twin	61 - 500	IPM	20.0 - 60.0			
165	Steel	3/32in	CV DC+ Twin	47 - 500	IPM	20.0 - 60.0			
166	Steel	3/32in	CV Sq Wave Twin	65 - 500	IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
167	Steel	3/32in	CC DC- Twin	200 - 2000	A	20.0 - 60.0			
168	Steel	3/32in	CC DC+ Twin	200 - 2000	A	20.0 - 60.0			
169	Steel	3/32in	CC Sq WaveTwin	300 - 2000	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
174	Steel	5/64in	CV DC- Twin	61 - 500	IPM	20.0 - 60.0			
175	Steel	5/64in	CV DC+ Twin	47 - 500	IPM	20.0 - 60.0			
176	Steel	5/64in	CV Sq Wave Twin	65 - 500	IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
177	Steel	5/64in	CC DC- Twin	200 - 2000	A	20.0 - 60.0			
178	Steel	5/64in	CC DC+ Twin	200 - 2000	A	20.0 - 60.0			
179	Steel	5/64in	CC Sq WaveTwin	200 - 2000	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
184	Steel	1/16in	CV DC- Twin	65 - 500	IPM	20.0 - 60.0			
185	Steel	1/16in	CV DC+ Twin	65 - 500	IPM	20.0 - 60.0			
186	Steel	1/16in	CV Sq Wave Twin	65 - 500	IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
187	Steel	1/16in	CC DC- Twin	200 - 2000	A	20.0 - 60.0			
188	Steel	1/16in	CC DC+ Twin	200 - 2000	A	20.0 - 60.0			
189	Steel	1/16in	CC Sq WaveTwin	200 - 2000	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
300	MSA Steel	3/16in & 1/8in	CC Square Wave	200 - 3000	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
301	MSA Steel	3/16in & 1/8in	CC 50Hz Sine	200 - 3000	A	20.0 - 60.0	50	-25 to +25	50
344	Stainless	5/32in	CV DC-	30 - 256	IPM	20.0 - 60.0			
345	Stainless	5/32in	CV DC+	30 - 256	IPM	20.0 - 60.0			
346	Stainless	5/32in	CV Square Wave	30 - 310	IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
347	Stainless	5/32in	CC DC-	200 - 2000	A	20.0 - 60.0			
348	Stainless	5/32in	CC DC+	200 - 2000	A	20.0 - 60.0			
349	Stainless	5/32in	CC Square Wave	200 - 2000	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
354	Stainless	1/8in	CV DC-	30 - 256	IPM	20.0 - 60.0			
355	Stainless	1/8in	CV DC+	30 - 256	IPM	20.0 - 60.0			
356	Stainless	1/8in	CV Square Wave	30 - 310	IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
357	Stainless	1/8in	CC DC-	200 - 2000	A	20.0 - 60.0			
358	Stainless	1/8in	CC DC+	200 - 2000	A	20.0 - 60.0			
359	Stainless	1/8in	CC Square Wave	200 - 2000	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
364	Stainless	3/32in	CV DC-	55 - 500	IPM	20.0 - 60.0			
365	Stainless	3/32in	CV DC+	50 - 500	IPM	20.0 - 60.0			
366	Stainless	3/32in	CV Square Wave	65 - 500	IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
367	Stainless	3/32in	CC DC-	200 - 2000	A	20.0 - 60.0			
368	Stainless	3/32in	CC DC+	200 - 2000	A	20.0 - 60.0			
369	Stainless	3/32in	CC Square Wave	200 - 2000	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
374	Stainless	5/64in	CV DC-	55-500	IPM	20.0 - 60.0			
375	Stainless	5/64in	CV DC+	50-500	IPM	20.0 - 60.0			
376	Stainless	5/64in	CV Square Wave	65-500	IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
377	Stainless	5/64in	CC DC-	200 - 2000	A	20.0 - 60.0			
378	Stainless	5/64in	CC DC+	200 - 2000	A	20.0 - 60.0			
379	Stainless	5/64in	CC Square Wave	300 - 2000	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75



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Mode	Wire Type	Wire Size	Process	Range	Units	Voltage	Frequency	Offset	Balance
444	Cored	5/32in	CV DC-	30 - 256	IPM	20.0 - 60.0			
445	Cored	5/32in	CV DC+	30 - 256	IPM	20.0 - 60.0			
446	Cored	5/32in	CV Square Wave	30 - 310	IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
447	Cored	5/32in	CC DC-	200 - 2000	A	20.0 - 60.0			
448	Cored	5/32in	CC DC+	200 - 2000	A	20.0 - 60.0			
449	Cored	5/32in	CC Square Wave	200 - 2000	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
454	Cored	1/8in	CV DC-	30 - 256	IPM	20.0 - 60.0			
455	Cored	1/8in	CV DC+	30 - 256	IPM	20.0 - 60.0			
456	Cored	1/8in	CV Square Wave	30 - 310	IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
457	Cored	1/8in	CC DC-	200 - 2000	A	20.0 - 60.0			
458	Cored	1/8in	CC DC+	200 - 2000	A	20.0 - 60.0			
459	Cored	1/8in	CC Square Wave	200 - 2000	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
464	Cored	3/32in	CV DC-	55 - 500	IPM	20.0 - 60.0			
465	Cored	3/32in	CV DC+	50 - 500	IPM	20.0 - 60.0			
466	Cored	3/32in	CV Square Wave	88 - 500	IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
467	Cored	3/32in	CC DC-	200 - 2000	A	20.0 - 60.0			
468	Cored	3/32in	CC DC+	200 - 2000	A	20.0 - 60.0			
469	Cored	3/32in	CC Square Wave	200 - 2000	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
564	Nickel	3/32in	CV DC-	30-500	IPM	20.0 - 60.0			
565	Nickel	3/32in	CV DC+	30-500	IPM	20.0 - 60.0			
566	Nickel	3/32in	CV Square Wave	30-500	IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
567	Nickel	3/32in	CC DC-	200 - 2000	A	20.0 - 60.0			
568	Nickel	3/32in	CC DC+	200 - 2000	A	20.0 - 60.0			
569	Nickel	3/32in	CC Square Wave	300 - 2000	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
584	Nickel	1/16in	CV DC-	30 - 500	IPM	20.0 - 60.0			
585	Nickel	1/16in	CV DC+	30 - 500	IPM	20.0 - 60.0			
586	Nickel	1/16in	CV Square Wave	30 - 500	IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
587	Nickel	1/16in	CC DC-	200 - 2000	A	20.0 - 60.0			
588	Nickel	1/16in	CC DC+	200 - 2000	A	20.0 - 60.0			
589	Nickel	1/16in	CC Square Wave	200 - 2000	A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
602	Steel	5/32in	CV DC+	30 - 325	IPM	15.0 - 45.0			
603	Steel	1/8in	CV DC+	30 - 325	IPM	15.0 - 45.0			
604	Steel	3/32in	CV DC+	30 - 325	IPM	15.0 - 45.0			
605	Steel	5/64in	CV DC+	30 - 500	IPM	15.0 - 45.0			
608	Stainless	1/8in	CV DC+	30 - 325	IPM	15.0 - 45.0			



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