SUPRAMIG HD® Ø 1.32 MM
HIGH PRODUCTIVITY GMAW SOLUTION

www.lincolnelectriceurope.com
SUPRAMIG® HD + Ø 1.32 mm

**ADVANCED PROCESSES**

- High current capacity
- Low silicates
- Superior deposition rate
- Tight and controlled chemistry

- Unique waveforms for cost reduction and quality improvements

**EQUIPMENT PACKAGES TO SATISFY YOUR REQUIREMENTS**

- Basic Platform
- Technical Platform
- Advanced Platform

**TOTAL SOLUTION FOR GMAW HIGH DEPOSITION APPLICATIONS**

- Complete wire feed system solution for bulk packaging
- Increases operating factor
- Reduces the welder’s workload
- Takes full control of welding process

**SOFTWARE SOLUTIONS**

- Weld Sequencer
- True Energy®

**WIDE RANGE OF MECHANIZED SOLUTIONS**

- Rapid-X waveform

- Rapid Arc® waveform
- Low Fume Pulse™
THE RIGHT CHOICE OF GMAW WIRE COMBINED WITH THE RIGHT SOLUTION IMPROVES PRODUCTIVITY AND PROFITABILITY

What is your production cost composed of?

- Overhead & Labour: 85%
- Wire: 6%
- Equipment: 4%
- Energy: 2%
- Shielding Gas: 4%

Increase your efficiency, reduce your labour cost by adopting the right solutions.
SUPRAMIG® HD + Ø 1.32 mm – THE OPTIMAL WIRE AND DIAMETER FOR HIGH DEPOSITION APPLICATIONS

For customers typically welding 6–12 mm sized fillets with amperages above 260 A (WFS>8 m/min), Supramig® HD 1.32 mm has demonstrated the highest overall performance in repeated test conditions.

**Effect of wire diameter on deposition rate. (*)**

<table>
<thead>
<tr>
<th>Wire diameter (mm)</th>
<th>WFS (m/min)</th>
<th>Deposition rate (kg/h)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Competitor wire ER 70S-6, Ø 1.2 mm</td>
<td>8</td>
<td>4.30</td>
</tr>
<tr>
<td>Supramig® HD 1.32 mm</td>
<td>8</td>
<td>5.20</td>
</tr>
</tbody>
</table>

(*) Based on WFS of 10.5 m/min

**Cost reduction in €/kg (**) and effect of Rapid Arc® on heat input.**

<table>
<thead>
<tr>
<th>Wire diameter (mm)</th>
<th>WFS (m/min)</th>
<th>Deposition rate (kg/h)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Competitor wire ER 70S-6, Ø 1.2 mm (WFS=10.5 m/min)</td>
<td>8</td>
<td>5.20</td>
</tr>
<tr>
<td>Supramig® HD 1.32 mm (WFS=13.5 m/min)</td>
<td>8</td>
<td>5.80</td>
</tr>
<tr>
<td>Supramig® HD 1.32 mm Rapid Arc® (WFS=13.5 m/min)</td>
<td>8</td>
<td>6.40</td>
</tr>
</tbody>
</table>

(*) Based on labour cost of 40 €/kg, operating factor 25%

**Increase your productivity by 20% without capital investment. OUR ADVANCED EQUIPMENT WILL CONTRIBUTE TO REDUCING YOUR WELD METAL COST UP TO 30%.

- Higher productivity and efficiency
- Better distribution of arc energy to weld pool
- Low silicate, less spatter & cleaning
- Best bead appearance
- More comfortable arc operability for the welder

**SUPRAMIG® HD + Ø 1.32mm**

EVEN IN TRADITIONAL CV MODE WIRE DIAMETER CHANGE ALLOWS PRODUCTIVITY IMPROVEMENT

**Common 1.2 mm wire**

<table>
<thead>
<tr>
<th>Wire diameter (mm)</th>
<th>WFS (m/min)</th>
<th>Deposition rate (kg/h)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.2</td>
<td>8</td>
<td>4.30</td>
</tr>
<tr>
<td>1.2</td>
<td>9</td>
<td>4.80</td>
</tr>
<tr>
<td>1.2</td>
<td>10</td>
<td>5.30</td>
</tr>
<tr>
<td>1.2</td>
<td>11</td>
<td>5.80</td>
</tr>
<tr>
<td>1.2</td>
<td>12</td>
<td>6.40</td>
</tr>
<tr>
<td>1.2</td>
<td>13</td>
<td>6.90</td>
</tr>
</tbody>
</table>

**Supramig® HD 1.32 mm**

<table>
<thead>
<tr>
<th>Wire diameter (mm)</th>
<th>WFS (m/min)</th>
<th>Deposition rate (kg/h)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.32</td>
<td>8</td>
<td>5.20</td>
</tr>
<tr>
<td>1.32</td>
<td>9</td>
<td>5.80</td>
</tr>
<tr>
<td>1.32</td>
<td>10</td>
<td>6.40</td>
</tr>
<tr>
<td>1.32</td>
<td>11</td>
<td>7.00</td>
</tr>
<tr>
<td>1.32</td>
<td>12</td>
<td>7.70</td>
</tr>
</tbody>
</table>

**Cost benefit**

- Increase in deposition rate (%) | Savings per kg of weld metal (€) | Reduction in cost per kg of deposited weld metal (%)
- 20.80 | 6.40 | -1700
- 20.80 | 5.80 | -1700
- 20.80 | 5.20 | -1650
- 20.70 | 4.70 | -1640
- 15.60 | 3.50 | -1300
- 11.60 | 2.40 | -1000

Based on the labour cost of 40 €/h; Operating factor of 25%, in CV mode.
WE CARE ABOUT THE OPERATOR’S ENVIRONMENT

INCREASE THE OPERATING FACTOR WHILE PUTTING YOUR WELDER IN A MORE COMFORTABLE ENVIRONMENT

Tests using the same deposition rate but with different wire diameters have been conducted to compare welder appeal versus performance. Supramig® HD 1.32 mm demonstrated being the best solution.

Particularly, it has been noticed welders preferred Supramig® HD 1.32 mm due to:
- Same deposition rate with lower WFS
- Less vibration in the torch and no feeding problems
- Possibility to weld at higher parameters with no trouble, to finish the job more quickly
- Arc consistency and easier molten puddle control even at higher energy

Welder appeal based on customer trials

Increasing welding time by 3 minutes per hour reduces the welding cost by 10%.

Reduction at the source

Unlike traditional Constant Voltage (CV mode) MIG, Low Fume Pulse™ utilizes patented Waveform Control Technology® for advanced arc performance, minimizing heat input and reducing weld fume generation directly at the arc.

Standard Waveform vs. Advanced Waveform (Low Fume Pulse™)

66% reduction in welding fume generation*

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LOW FUME PULSE™
Advanced Waveform available with Power Wave®

Increasing welding time by 3 minutes per hour reduces the welding cost by 10%.

www.lincolnelectriceurope.com

High Productivity GMAW Solution

* 66% Fume Generation Reduction (grams/minute) based on Supramig® HD Ø 1.32 mm, at WFS = 10 m/min – same gas, same contact-tip-to-work-piece distance.
SUPRAMIG® HD – WITH CONTROLLED CHEMICAL COMPOSITION AT TIGHT TOLERANCE WITH AN ENGINEERED SURFACE CONDITION

The Supramig® HD family of solid wires is made for welding applications requiring high deposition rates, as they can be found in the areas of heavy fabrication, manufacturing of earth moving, mining and agricultural equipment. The weld metal is transferred to the weld pool in small droplets under high current condition. The result is a concave weld shape supporting higher levels of fatigue life essential in the heavy fabrication sector.

PREMIUM PRODUCT

- Detachable silicate island
- Optimal bead profile
- Higher productivity, higher deposition rate

STEEL

- Steel comprises of many elements, some of which are undesirable for welding
- We fix tighter ranges on our steel components and control more elements than required by EN ISO
- Steel is the highest contributing factor to MIG wire performance
- Not all steel mills know how to produce quality wire rod for drawing a welding wire
- We choose only the very best mills that provide a guarantee of quality throughout the steel making and rolling process to achieve good surface condition and preparation for drawing

CONSISTENCY + PREMIUM WIRE = CONFIDENCE

SUPRAMIG® HD – WITH CONTROLLED CHEMICAL COMPOSITION AT TIGHT TOLERANCE WITH AN ENGINEERED SURFACE CONDITION

EN ISO RANGES

<table>
<thead>
<tr>
<th>C</th>
<th>Mn</th>
<th>Si</th>
<th>S</th>
<th>P</th>
<th>Cr</th>
<th>Ni</th>
<th>Mo</th>
<th>V</th>
<th>Cu</th>
<th>Al</th>
<th>Ti+Zr</th>
</tr>
</thead>
</table>

LINCOLN ELECTRIC RANGES

<table>
<thead>
<tr>
<th>C</th>
<th>Mn</th>
<th>Si</th>
<th>S</th>
<th>P</th>
<th>Cr</th>
<th>Ni</th>
<th>Mo</th>
<th>V</th>
<th>Cu</th>
<th>Al</th>
<th>Ti+Zr</th>
</tr>
</thead>
</table>

We fix tighter ranges in the chemical composition and control more elements than required by AWS & ISO.

VERY STRICT QUALITY CONTROL SYSTEM

Quality MIG wire start with quality of raw materials

- Steel comprises of many elements, some of which are undesirable for welding
- We fix tighter ranges on our steel components and control more elements than required by EN ISO
- Steel is the highest contributing factor to MIG wire performance
- Not all steel mills know how to produce quality wire rod for drawing a welding wire
- We choose only the very best mills that provide a guarantee of quality throughout the steel making and rolling process to achieve good surface condition and preparation for drawing

We reject coils that do not meet our rigorous standards.

- Coils dedicated to produce Supramig® HD
- Coils are accepted because they are in the range of EN ISO but NOT used to produce Supramig® HD
PREMIUM WIRE

UNIQUE ENGINEERED SURFACE CONDITION THAT IMPROVES ARC STABILITY

A unique engineered process is applied from start to finish in manufacturing to deliver a superior surface condition for welding:

- Stable arc and excellent starting behaviour
- Reduced friction of the wire in the liners to support high speed feeding performance
- Reduced wear of expensive contact tips
- Optimal spray arc mode voltage

WIRE DIAMETER CAST AND HELIX

Wire tested for adequate feedability, arc stability and performance:

- Control of the wire diameter is essential in arc stability.
- A varying wire diameter will cause varying amperages and potentially varying weld penetrations.
- Cast and Helix are essential variables for wire feedability in Mild Steel MIG Wire

UNIQUE ENGINEERED SURFACE CONDITION THA T IMPROVES ARC STABILITY

A bad Cast and Helix can produce differences in arc shape and penetration profiles

Cast and Helix are tightly controlled to ensure correct positioning of the wire as it comes out of the contact tip

ROBOT APPLICATION

Supramig® HD 1.32 mm geometrical characteristic and tight controlled chemistry, in combination with Accu-Trak® drums represents the best solution for robotic applications.

- Perfect and repeated wire placement on welding point
- No defects due to inconsistent wire positioning
- No spatter
- No wasting time for reparation and cleaning
- WFS up to 15 m/min
- Deposition rate up to 10 kg/h

Example of bad wire placement

Example of good wire placement

Wire Placement Accuracy Test*

Impact area: 1.35 mm²
Impact area: 0.067 mm²

*Test measuring the wire placement area during 10 min of welding.

95% reduction of wire deviation with Lincoln Electric wire

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Extra Flexible Conduits allow for a tighter radius on the conduit setup and have a low friction coefficient, ideal for robotic setups. Recommended to use together with the Strain Relief Connector attached to the Direct Pull Kit.

Stationary or Polymeric Conduits have a very low friction coefficient, less than steel lined conduits and are suited in stationary or moving feed units. Recommended to use with Compression Connectors.

### ECO Carton Cover
Supplied with the drum, can be ordered individually if required.

<table>
<thead>
<tr>
<th>Drum type</th>
<th>250 kg</th>
<th>500 kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>ROUND ECO DRUM</td>
<td>AD1329-176</td>
<td>AD1329-211</td>
</tr>
<tr>
<td>ROUND FIBER DRUM</td>
<td>AD1329-208</td>
<td>-</td>
</tr>
</tbody>
</table>

### Drum Cart
Can be adjusted to the outside diameter of the drum and re-used for different drum sizes, having only one reference to manage in inventory. Can be used up to 500 kg of loading capacity.

### Move from Spools to Drums:
**Save Money and Improve Productivity**

- For conduits up to 3 m use the eco carton cover
- For conduits from 4 to 5 m use the hood cover (eco/fiber)
- For conduits longer than 5 m use the hood cover (eco/fiber) plus the wire feed assist

Fibre Hood Cover
to be used with pneumatic feed assist
Ordered Separately

**ECO Carton Cover**

**Drum Cart**

**RELIABLE FEEDING SYSTEM**

**MOVE FROM SPOOLS TO DRUMS:**

**SAVE MONEY AND IMPROVE PRODUCTIVITY**

- For conduits up to 3 m use the eco carton cover
- For conduits from 4 to 5 m use the hood cover (eco/fiber)
- For conduits longer than 5 m use the hood cover (eco/fiber) plus the wire feed assist

**REDUCE YOUR DOWNTIME, IMPROVE YOUR COST SAVING:**

Move from spools to Accu-Trak® 250 kg or 500 kg, save money and improve productivity.

- Move to infinity solution
- 24/7 working time
  - 0 downtime for packaging changing (*)

* Full set of accessories for joining wire available. Ask for more information

**Savings**

**-21%**  
(-5,940 €)

<table>
<thead>
<tr>
<th>CONSUMABLE COST</th>
<th>Wire [€/kg]</th>
<th>1.70</th>
<th>1.75</th>
</tr>
</thead>
<tbody>
<tr>
<td>Labour cost</td>
<td>[€/h]</td>
<td>40</td>
<td>40</td>
</tr>
<tr>
<td>Change over time</td>
<td>[min]</td>
<td>15</td>
<td>30</td>
</tr>
<tr>
<td># of change over</td>
<td></td>
<td>750</td>
<td>48</td>
</tr>
<tr>
<td>Consumption per year</td>
<td>[kg]</td>
<td>12,000</td>
<td></td>
</tr>
<tr>
<td>TOTAL</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Change over time</td>
<td>[h]</td>
<td>187.50</td>
<td>24</td>
</tr>
<tr>
<td>Change over cost</td>
<td>[€]</td>
<td>7,500</td>
<td>960</td>
</tr>
<tr>
<td>Consumable cost</td>
<td>[€]</td>
<td>20,400</td>
<td>21,000</td>
</tr>
<tr>
<td>Total cost</td>
<td>[€]</td>
<td>27,900</td>
<td>21,960</td>
</tr>
<tr>
<td>Time saving</td>
<td>[h]</td>
<td>164 h</td>
<td></td>
</tr>
<tr>
<td>Cost saving</td>
<td>[€]</td>
<td>-5,940 €</td>
<td></td>
</tr>
<tr>
<td>Cost saving</td>
<td></td>
<td>-21%</td>
<td></td>
</tr>
</tbody>
</table>

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Wire Feed Assist

By using the Pneumatic Feed Assist (PFA) you can bridge distances up to 30 meters.

This opens lots of opportunities to place the drum at long distance to avoid substantial loss of time by replacing and handling the drums. It is even possible to leave the drum on the pallet and not to move it at all.
THREE RECOMMENDED EQUIPMENT SOLUTIONS

1 BASIC
CV-510 with Linc Feed 33
- Robustness
- High power
- Low investment

2 TECHNICAL
Speedtec® SP series with PF 42, 44 or 46
- High productivity with possibility of pulsed mode

3 ADVANCED
Power Wave® S series with PF46 or Power Feed® 84
- High productivity with possibility to use advanced arc processes and software for a complete weld control
  - STT®
  - Rapid X®
  - Rapid Arc®
  - Low Fume Pulse™

SELECT THE RIGHT EQUIPMENT FOR YOUR JOB

Investing in waveforms (Rapid Arc®, Rapid X®, Low Fume Pulse™) gives you the possibility of increasing productivity, allowing faster travel speed, minimizing spatter and realizing quick ROI.

WIRE FEEDER SUGGESTIONS

<table>
<thead>
<tr>
<th>Equipment</th>
<th>Linc Feed 33</th>
<th>Wire Feeders</th>
<th>PF 42</th>
<th>PF 46</th>
<th>Power Feed® 84</th>
</tr>
</thead>
<tbody>
<tr>
<td>CV-510</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Speedtec® 505SP</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Power Wave®</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

(1) available as dual too, (2) allows the use of Weld Sequencer
RAPID X®

High-speed pulse modes designed with an extreme short arc length and short circuit response to minimize spatter and improve travel speed. Rapid X® represents the new generation of Rapid Arc®.

- Extremely fast travel speed
- Clean welds and lower heat input

EXAMPLE OF COST SAVING USING RAPID X® AND SUPRAMIG® HD 1.32 mm

For this test, a complete metallic frame with different types of joints has been welded (see picture):

- Supramig® HD Ø 1.2 mm in CV mode
- Supramig® HD Ø 1.32 mm with Rapid X®

<table>
<thead>
<tr>
<th></th>
<th>GMAW semi-automatic solid wire</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Supramig® HD</td>
</tr>
<tr>
<td>Electrode diameter</td>
<td>[mm]</td>
</tr>
<tr>
<td>WFS</td>
<td>[m/min]</td>
</tr>
<tr>
<td>Travel speed</td>
<td>[cm/min]</td>
</tr>
<tr>
<td>Operating factor</td>
<td>[%]</td>
</tr>
<tr>
<td>Time to lay 1 m</td>
<td>[h/m]</td>
</tr>
<tr>
<td>LABOUR COSTS AND OVERHEAD</td>
<td></td>
</tr>
<tr>
<td>Labour &amp; OH rate</td>
<td>[£/h]</td>
</tr>
<tr>
<td>Total labour &amp; OH</td>
<td>[£/m]</td>
</tr>
<tr>
<td>COST OF CONSUMABLES</td>
<td></td>
</tr>
<tr>
<td>Price of welding electrode</td>
<td>[£/kg]</td>
</tr>
<tr>
<td>Total material cost per meter of welding</td>
<td>[£/m]</td>
</tr>
<tr>
<td>TOTAL WELDING COST per meter of welding</td>
<td>[£/m]</td>
</tr>
<tr>
<td>Savings per 1 m of welding</td>
<td>[£]</td>
</tr>
<tr>
<td>Customer’s saving per 1000 m of welding</td>
<td>[£]</td>
</tr>
</tbody>
</table>

Supramig® HD Ø 1.2 mm
Average travel speed: 25 cm/min

Supramig® HD Ø 1.32 mm
Average travel speed: 30 cm/min

Savings per meter of welding 16%
WELD SEQUENCER

Changing what was done with written instructions to an operator guided complete welding system.

It is no longer difficult to train operators, interpret work instructions and prints, or execute and verify welds.

- Guide operators step-by-step
- Easy to follow graphical interface
- Clearly define each assembly step
- Clearly define each weld placement

INFORMATION THAT LEADS TO SOLUTIONS®

Understanding the true cost, true performance and true quality of your welding operation is vital. Your customers expect it and your business profitability demands it. Yet relying on traditional methods to collect and analyse operator metrics takes up valuable man-hours and often does not provide a true representation of your entire welding process.

Power Wave’s® advanced production monitoring technology allows you to break away from these old methods with an intelligent, IoT driven platform. Delivering a complete, real-time view of your entire welding operation, the Power Wave® platform provides the precise information you need to deliver data-driven decision-making and process improvements.

CHECKPOINT®

Data Collection
- Every operation – big or small strives for making the best weld, in an efficient way, with zero defects, while meeting demand
- The challenge is – how do you know?
- Hard to determine without TRUE picture of welding operation

With Checkpoint® you can:
- Identify the TRUE COST of welding
- Evaluate the TRUE QUALITY of welding
- Deliver the TRUE PERFORMANCE of welding

Powerful Data Visualization
- Full visibility of your welding operation
- Real-time dashboard snapshots
- In-depth weld analytics

Easy Data Exporting
- Export the raw data
- Crunch the numbers the way YOU want

TRUE ENERGY®

When replacing 1.2 mm solid wire with Supramig® HD 1.32 mm, the first operator observation is about the increase in current. Larger wire diameter enables to weld faster (higher deposition rate) while keeping heat input almost unchanged.

True Energy® is a proprietary Lincoln Electric technology that uses the digital control system embedded in each Power Wave® arc welding power source to measure and calculate the instantaneous amount of energy put into a weld. Customers can then use this value, in conjunction with the length of the weld, to get the heat input. Heat input calculations are used extensively in the welding industry, and the accurate calculation of these values is of utmost importance.

- Built in to all Lincoln Electric Power Wave® power sources.
- No extra equipment or measuring tools necessary.
- Easily comply with heat input calculations per ASME code

Traditional Heat Input Calculation

\[
\text{HEAT INPUT} = \frac{V \times A \times 60}{\text{Travel Speed}} = \text{kJ/mm}
\]

True Energy® Heat Input Calculation

\[
\text{HEAT INPUT} = \frac{\text{True Energy® Value}}{\text{Distance Traveled}} = \text{kJ/mm}
\]
**MIG GUN**

**LGS2 505W**

Simple and reliable water-cooled heavy-duty torch (500 A @ 100%) for high productivity in steel industry with Supramig® HD 1.32 mm

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**WST2**

**FUME ASPIRATION TORCHES**

Improve the welder environment using a fume aspiration torch. WST2 is the ideal choice. Fume extraction at high rate thanks to an advanced air flow design.

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**CUSTOMER FEEDBACK**

"We tested the solution with several clients active in heavy fabrication and structural steel. We were trying it with different processes: semi-automatic, mechanized and with robots. They were all impressed by the easy way to increase the productivity along with the improvement in arc stability, feeding properties and quality of the weld."

**Lorenzo Coato**

Industrial Segment Manager EMEAR

---

To order

<table>
<thead>
<tr>
<th>LGS2 505W</th>
</tr>
</thead>
<tbody>
<tr>
<td>3 m</td>
</tr>
<tr>
<td>4 m</td>
</tr>
<tr>
<td>5 m</td>
</tr>
</tbody>
</table>

To order

<table>
<thead>
<tr>
<th>WST2 5W</th>
</tr>
</thead>
<tbody>
<tr>
<td>3 m</td>
</tr>
<tr>
<td>4 m</td>
</tr>
<tr>
<td>5 m</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Contact tip for Ø 1.32 wire</th>
</tr>
</thead>
<tbody>
<tr>
<td>M8 x 30</td>
</tr>
</tbody>
</table>
EXAMPLES OF MECHANIZED APPLICATIONS

Effective mechanization enables productivity improvement, increasing the duty cycle up to 70%.

WELD CAR AND SUPRAMIG® HD 1.32 mm

- Operating factor up to 70%
- Faster travel speed
- In combination with Rapid Arc® / Rapid X® processes, reduced cleaning time due to less spatter

![Image of a welding machine](image1)

Long seam welds in structural steelwork / transport equipment

WELDING PROCESS DATA

<table>
<thead>
<tr>
<th>PROCESS DESCRIPTION</th>
<th>GMAW Solid wire</th>
</tr>
</thead>
<tbody>
<tr>
<td>TEST Nº</td>
<td>1</td>
</tr>
<tr>
<td>Filler metal</td>
<td>Supramig® HD</td>
</tr>
<tr>
<td>Welding mode</td>
<td>CV – manual welding</td>
</tr>
<tr>
<td>Electrode diameter</td>
<td>[mm]</td>
</tr>
<tr>
<td>WFS</td>
<td>[m/min]</td>
</tr>
<tr>
<td>Deposition rate</td>
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</tr>
<tr>
<td>Operating factor</td>
<td>[%]</td>
</tr>
<tr>
<td>LABOUR COSTS AND OVERHEAD</td>
<td>[€/h]</td>
</tr>
<tr>
<td>COST OF CONSUMABLES</td>
<td>[€/kg]</td>
</tr>
<tr>
<td>TOTAL WELDING COST</td>
<td>[€/kg]</td>
</tr>
<tr>
<td>Savings per kg of deposited material</td>
<td>[€]</td>
</tr>
<tr>
<td>Saving per year considering a consumption of 10,000 kg</td>
<td>[€]</td>
</tr>
<tr>
<td>TOTAL WELDING COST PER METER</td>
<td>[€/m]</td>
</tr>
<tr>
<td>Savings per 1 m of welding</td>
<td>[€]</td>
</tr>
<tr>
<td>Customer’s saving per 10,000 m of welding</td>
<td>[€]</td>
</tr>
</tbody>
</table>

CB MATIC

Take the gun out of the welder’s hand, increase daily production, reduce cycle time and welder effort by combining Supramig® HD 1.32 mm with CB MATIC and PowerWave® S500.

Typical configuration

1.2 x 1.2 or 1.8 x 1.8 m column and boom for GMAW circumferential welding.
- Easy set-up for pipe welding or tube / flange welding
- Power Wave® S500 with STT®
- Single or dual feeder Power Feed® 84
- Positioner Posmatic
- Supramig® HD Ø 1.0 mm for root pass in STT® technology
- Supramig® HD Ø 1.32 mm for filling / fillet weld with advanced waveforms

![Image of a welding machine](image2)

VISIT WEB PAGE

TAKE THE NEXT STEP
TECHNICAL SPECIFICATIONS SUPRAMIG® HD

SUPRAMIG® HD

AWS 5.18: ER70S-6
ISO 14341-A: G 46 4 M 3Si1 / G 42 3 C 3Si1

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SUPRAMIG® ULTRA HD

AWS 5.18: ER70S-6
ISO 14341-A: G 50 5 M 4Si1 / G 46 3 C 4Si1

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