

Weld Set Reference: Z143312

Power Wave® S350/i400/S500 SI

| Steel | | | Stainless | | | AISI 4043 | | | General | | |
|------------------------|-----------------|------|------------------------|-----------------------|------|------------------------|-----------------|------|------------------------------------|----------------|------|
| Process | Gas Type | Mode | Process | Gas Type | Mode | Process | Gas Type | Mode | Process | Gas Type | Mode |
| 0.8mm Wire Size | | | 0.8mm Wire Size | | | 1.0mm Wire Size | | | Stick/Tig/Gouge | | |
| CV | CO ₂ | 93 | CV | Argon Mix | 61 | Pulse on Pulse® | Argon | 98 | Stick Soft | | 1 |
| CV | Argon Mix | 94 | CV | Ar He CO ₂ | 63 | 1.2mm Wire Size | | | Stick Crisp | | 2 |
| Pulse | Argon Mix | 95 | Pulse | Ar He CO ₂ | 64 | CV | Argon | 71 | Stick Pipe | | 4 |
| Precision Pulse™ | Argon Mix | 410 | Pulse | Argon Mix | 66 | Pulse | Argon | 72 | Tig | Argon | 3 |
| 0.9mm Wire Size | | | 0.9mm Wire Size | | | 1.6mm Wire Size | | | Tig - Pulse | Argon | 8 |
| CV | CO ₂ | 138 | CV | Argon Mix | 29 | CV | Argon | 73 | Gouging | Compressed Air | 9 |
| CV | Argon Mix | 139 | Pulse | Argon Mix | 30 | Pulse | Argon | 74 | Wire Welding (Non-Synergic) | | |
| Pulse | Argon Mix | 140 | Precision Pulse™ | Argon Mix | 421 | Pulse on Pulse® | Argon | 100 | CV | Gas Shielded | 5 |
| RapidArc® | Argon Mix | 141 | 1.0mm Wire Size | | | AIMg 5356 | | | FCAW-S | Self Shielded | 6 |
| Precision Pulse™ | Argon Mix | 411 | CV | Argon Mix | 31 | 1.0mm Wire Size | | | FCAW-G | Gas Shielded | 7 |
| 1.0mm Wire Size | | | CV | Ar He CO ₂ | 33 | 1.0mm Wire Size | | | Power Mode® | Gas Shielded | 40 |
| CV | CO ₂ | 10 | Pulse | Ar He CO ₂ | 34 | 1.0mm Wire Size | | | Nickel Alloy | | |
| CV | Argon Mix | 11 | Pulse | Argon Mix | 36 | CV | Argon | 151 | 1.0mm Wire Size | | |
| Pulse | Argon Mix | 12 | Precision Pulse™ | Argon Mix | 422 | Pulse | Argon | 152 | Pulse | Argon Helium | 170 |
| RapidArc® | Argon Mix | 13 | 1.2mm Wire Size | | | 1.2mm Wire Size | | | 1.2mm Wire Size | | |
| Precision Pulse™ | Argon Mix | 412 | CV | Argon Mix | 41 | Pulse on Pulse® | Argon | 101 | Pulse | Argon Helium | 175 |
| 1.2mm Wire Size | | | CV | Ar He CO ₂ | 43 | 1.2mm Wire Size | | | Copper | | |
| CV | CO ₂ | 20 | Pulse | Ar He CO ₂ | 44 | 1.2mm Wire Size | | | 1.0mm Wire Size | | |
| CV | Argon Mix | 21 | Pulse | Argon Mix | 46 | CV | Argon | 75 | Pulse | Argon Helium | 198 |
| Pulse | Argon Mix | 22 | Precision Pulse™ | Argon Mix | 423 | Pulse | Argon | 76 | 1.2mm Wire Size | | |
| RapidArc® | Argon Mix | 18 | Metal Core | | | 1.6mm Wire Size | | | 1.2mm Wire Size | | |
| Precision Pulse™ | Argon Mix | 413 | 1.2mm Wire Size | | | 1.6mm Wire Size | | | Pulse | Argon Helium | 196 |
| 1.4mm Wire Size | | | CV | Argon Mix | 81 | 1.6mm Wire Size | | | Silicon Bronze | | |
| CV | CO ₂ | 24 | Pulse | Argon Mix | 82 | 1.6mm Wire Size | | | 1.0mm Wire Size | | |
| CV | Argon Mix | 25 | 1.4mm Wire Size | | | 1.6mm Wire Size | | | Pulse | Argon | 192 |
| Pulse | Argon Mix | 26 | Pulse | Argon Mix | 84 | 1.6mm Wire Size | | | Flux Core | | |
| RapidArc® | Argon Mix | 27 | 1.6mm Wire Size | | | 1.2mm Wire Size | | | 1.2mm Wire Size | | |
| 1.6mm Wire Size | | | CV | Argon Mix | 85 | 1.2mm Wire Size | | | 1.2mm Wire Size | | |
| CV | Argon Mix | 107 | Pulse | Argon Mix | 86 | CV | CO ₂ | 90 | 1.0mm Wire Size | | |
| Pulse | Argon Mix | 108 | 1.6mm Wire Size | | | CV | Argon Mix | 91 | 1.0mm Wire Size | | |
| 1.6mm Wire Size | | | 1.6mm Wire Size | | | 1.6mm Wire Size | | | 1.0mm Wire Size | | |
| 1.6mm Wire Size | | | 1.6mm Wire Size | | | 1.6mm Wire Size | | | 1.0mm Wire Size | | |



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4/25/2014

Weld Set Reference: Z143312*

Power Wave® S350/S500 SI

*Modes listed on this page are only available on power sources compatible with either the Power Wave STT® Module or Power Wave® Advanced Module

| Steel STT® | | | Stainless STT® | | |
|------------------------|-----------------|------|------------------------|-----------------------|------|
| Process | Gas Type | Mode | Process | Gas Type | Mode |
| 0.9mm Wire Size | | | 0.9mm Wire Size | | |
| STT® - Non-Synergic | CO ₂ | 304 | STT® - Non-Synergic | Argon Mix | 344 |
| STT® - Non-Synergic | Argon Mix | 305 | STT® - Non-Synergic | He Ar CO ₂ | 345 |
| STT® - Synergic | CO ₂ | 324 | STT® - Synergic | Argon Mix | 364 |
| STT® - Synergic | Argon Mix | 325 | STT® - Synergic | He Ar CO ₂ | 365 |
| 1.0mm Wire Size | | | 1.0mm Wire Size | | |
| STT® - Non-Synergic | CO ₂ | 306 | STT® - Non-Synergic | Argon Mix | 346 |
| STT® - Non-Synergic | Argon Mix | 307 | STT® - Non-Synergic | He Ar CO ₂ | 347 |
| STT® - Synergic | CO ₂ | 326 | STT® - Synergic | Argon Mix | 366 |
| STT® - Synergic | Argon Mix | 327 | STT® - Synergic | He Ar CO ₂ | 367 |

| Rapid X™ | | | | | | | | |
|--------------|-----------|------|--------------|-----------|------|--------------|-----------|------|
| Steel | | | Stainless | | | Metal Core | | |
| Process | Gas Type | Mode | Process | Gas Type | Mode | Process | Gas Type | Mode |
| 1.0mm | | | 1.0mm | | | 1.2mm | | |
| Rapid X™ | Argon Mix | 273 | Rapid X™ | Argon Mix | 283 | Rapid X™ | Argon Mix | 294 |
| 1.2mm | | | 1.2mm | | | | | |
| Rapid X™ | Argon Mix | 274 | Rapid X™ | Argon Mix | 284 | | | |



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Power Wave® Advanced Module

*Modes listed on this page are only available on power sources compatible with the Power Wave® Advanced Module

| AISi 4043 | | |
|------------------------|----------|------|
| Process | Gas Type | Mode |
| 1.2mm Wire Size | | |
| AC Pulse | Argon | 393 |
| 1.6mm Wire Size | | |
| AC Pulse | Argon | 394 |
| AlMg 5356 | | |
| 1.2mm Wire Size | | |
| AC Pulse | Argon | 398 |
| 1.6mm Wire Size | | |
| AC Pulse | Argon | 399 |

| General | | |
|------------------------|----------|------|
| Process | Gas Type | Mode |
| Stick/Tig/Gouge | | |
| HF Start Tig | Argon | 375 |
| HF Start Tig - Pulse | Argon | 376 |
| Touch Start AC GTAW | Argon | 377 |
| HF Start AC GTAW | Argon | 378 |



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Power Wave® Tandem MIG™

*Modes listed on this page are only available on power sources compatible with the Autodrive 19® Tandem controller.

| Synchronized Tandem MIG™ | | |
|---------------------------------|-----------|------|
| Steel | | |
| Process | Gas Type | Mode |
| 1.0mm Wire Size | | |
| Synchronized Pulse Lead | Argon Mix | 402 |
| Synchronized Pulse Trail | Argon Mix | 403 |
| 1.2mm Wire Size | | |
| Synchronized Pulse Lead | Argon Mix | 404 |
| Synchronized Pulse Trail | Argon Mix | 405 |
| 1.4mm Wire Size | | |
| Synchronized Pulse Lead | Argon Mix | 406 |
| Synchronized Pulse Trail | Argon Mix | 407 |

| Hot Wire Tandem MIG™ | | |
|-----------------------------|-----------|------|
| Steel | | |
| Process | Gas Type | Mode |
| 1.0mm Wire Size | | |
| Synchronized Pulse Trail | Argon Mix | 461 |
| 1.2mm Wire Size | | |
| Synchronized Pulse Trail | Argon Mix | 462 |
| 1.4mm Wire Size | | |
| Synchronized Pulse Trail | Argon Mix | 463 |



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CONTENTS OF WELDING SOFTWARE Z143312

| Mode | Process | Procedure | Wire Size | Wire Type | Gas Type | Arc Control |
|------|---------|------------------|-----------|------------|-----------------------|----------------------------------|
| 1 | SMAW | Stick Soft | | | | Arc Force, Hot Start |
| 2 | SMAW | Stick Crisp | | | | Arc Force, Hot Start |
| 3 | GTAW | Touch Start TIG | | | Argon | Hot Start |
| 4 | SMAW | Stick Pipe | | | | Arc Force |
| 5 | GMAW | CV | | | Gas Shielded | Pinch |
| 6 | FCAW-S | CV | | | Self Shielded | Pinch |
| 7 | FCAW-G | CV | | | Gas Shielded | Pinch |
| 8 | GTAW-P | Tig - Pulse | | | Argon | Frequency, Background, Hot Start |
| 9 | CAG | Gouging | | | Compressed Air | |
| 10 | GMAW | CV | 1.0 | Steel | CO ₂ | Pinch |
| 11 | GMAW | CV | 1.0 | Steel | Argon Mix | Pinch |
| 12 | GMAW-P | Pulse | 1.0 | Steel | Argon Mix | UltimArc™ |
| 13 | GMAW-P | RapidArc® | 1.0 | Steel | Argon Mix | UltimArc™ |
| 18 | GMAW-P | RapidArc® | 1.2 | Steel | Argon Mix | UltimArc™ |
| 20 | GMAW | CV | 1.2 | Steel | CO ₂ | Pinch |
| 21 | GMAW | CV | 1.2 | Steel | Argon Mix | Pinch |
| 22 | GMAW-P | Pulse | 1.2 | Steel | Argon Mix | UltimArc™ |
| 24 | GMAW | CV | 1.4 | Steel | CO ₂ | Pinch |
| 25 | GMAW | CV | 1.4 | Steel | Argon Mix | Pinch |
| 26 | GMAW-P | Pulse | 1.4 | Steel | Argon Mix | UltimArc™ |
| 27 | GMAW-P | RapidArc® | 1.4 | Steel | Argon Mix | UltimArc™ |
| 29 | GMAW | CV | 0.9 | Stainless | Argon Mix | Pinch |
| 30 | GMAW-P | Pulse | 0.9 | Stainless | Argon Mix | UltimArc™ |
| 31 | GMAW | CV | 1.0 | Stainless | Argon Mix | Pinch |
| 33 | GMAW | CV | 1.0 | Stainless | Ar He CO ₂ | Pinch |
| 34 | GMAW-P | Pulse | 1.0 | Stainless | Ar He CO ₂ | UltimArc™ |
| 36 | GMAW-P | Pulse | 1.0 | Stainless | Argon Mix | UltimArc™ |
| 40 | GMAW | Power Mode® | | | Gas Shielded | Pinch |
| 41 | GMAW | CV | 1.2 | Stainless | Argon Mix | Pinch |
| 43 | GMAW | CV | 1.2 | Stainless | Ar He CO ₂ | Pinch |
| 44 | GMAW-P | Pulse | 1.2 | Stainless | Ar He CO ₂ | UltimArc™ |
| 46 | GMAW-P | Pulse | 1.2 | Stainless | Argon Mix | UltimArc™ |
| 61 | GMAW | CV | 0.8 | Stainless | Argon Mix | Pinch |
| 63 | GMAW | CV | 0.8 | Stainless | Ar He CO ₂ | Pinch |
| 64 | GMAW-P | Pulse | 0.8 | Stainless | Ar He CO ₂ | UltimArc™ |
| 66 | GMAW-P | Pulse | 0.8 | Stainless | Argon Mix | UltimArc™ |
| 71 | GMAW | CV | 1.2 | AlSi | Argon | Pinch |
| 72 | GMAW-P | Pulse | 1.2 | AlSi | Argon | UltimArc™ |
| 73 | GMAW | CV | 1.6 | AlSi | Argon | Pinch |
| 74 | GMAW-P | Pulse | 1.6 | AlSi | Argon | UltimArc™ |
| 75 | GMAW | CV | 1.2 | AlMg | Argon | Pinch |
| 76 | GMAW-P | Pulse | 1.2 | AlMg | Argon | UltimArc™ |
| 77 | GMAW | CV | 1.6 | AlMg | Argon | Pinch |
| 78 | GMAW-P | Pulse | 1.6 | AlMg | Argon | UltimArc™ |
| 81 | GMAW | CV | 1.2 | Metal Core | Argon Mix | Pinch |
| 82 | GMAW-P | Pulse | 1.2 | Metal Core | Argon Mix | UltimArc™ |
| 84 | GMAW-P | Pulse | 1.4 | Metal Core | Argon Mix | UltimArc™ |
| 85 | GMAW | CV | 1.6 | Metal Core | Argon Mix | Pinch |
| 86 | GMAW-P | Pulse | 1.6 | Metal Core | Argon Mix | UltimArc™ |
| 90 | FCAW-G | CV | 1.2 | | CO ₂ | Pinch |
| 91 | FCAW-G | CV | 1.2 | | Argon Mix | Pinch |
| 93 | GMAW | CV | 0.8 | Steel | CO ₂ | Pinch |
| 94 | GMAW | CV | 0.8 | Steel | Argon Mix | Pinch |
| 95 | GMAW-P | Pulse | 0.8 | Steel | Argon Mix | UltimArc™ |
| 98 | GMAW-P | Pulse on Pulse® | 1.0 | AlSi | Argon | Frequency |
| 99 | GMAW-P | Pulse on Pulse® | 1.2 | AlSi | Argon | Frequency |
| 100 | GMAW-P | Pulse on Pulse® | 1.6 | AlSi | Argon | Frequency |
| 101 | GMAW-P | Pulse on Pulse® | 1.0 | AlMg | Argon | Frequency |
| 102 | GMAW-P | Pulse on Pulse® | 1.2 | AlMg | Argon | Frequency |
| 103 | GMAW-P | Pulse on Pulse® | 1.6 | AlMg | Argon | Frequency |
| 107 | GMAW | CV | 1.6 | Steel | Argon Mix | Pinch |
| 108 | GMAW-P | Pulse | 1.6 | Steel | Argon Mix | UltimArc™ |
| 138 | GMAW | CV | 0.9 | Steel | CO ₂ | Pinch |
| 139 | GMAW | CV | 0.9 | Steel | Argon Mix | Pinch |
| 140 | GMAW-P | Pulse | 0.9 | Steel | Argon Mix | UltimArc™ |
| 141 | GMAW-P | RapidArc® | 0.9 | Steel | Argon Mix | UltimArc™ |
| 151 | GMAW | CV | 1.0 | AlMg | Argon | Pinch |
| 152 | GMAW-P | Pulse | 1.0 | AlMg | Argon | UltimArc™ |
| 170 | GMAW-P | Pulse | 1.0 | Ni Chrome | Argon Helium | UltimArc™ |
| 175 | GMAW-P | Pulse | 1.2 | Ni Chrome | Argon Helium | UltimArc™ |
| 192 | GMAW-P | Pulse | 1.0 | Si Bronze | Argon | UltimArc™ |
| 196 | GMAW-P | Pulse | 1.2 | Copper | Argon Helium | UltimArc™ |
| 198 | GMAW-P | Pulse | 1.0 | Copper | Argon Helium | UltimArc™ |
| 410 | GMAW-P | Precision Pulse™ | 0.8 | Steel | Argon Mix | UltimArc™ |
| 411 | GMAW-P | Precision Pulse™ | 0.9 | Steel | Argon Mix | UltimArc™ |
| 412 | GMAW-P | Precision Pulse™ | 1.0 | Steel | Argon Mix | UltimArc™ |
| 413 | GMAW-P | Precision Pulse™ | 1.2 | Steel | Argon Mix | UltimArc™ |
| 421 | GMAW-P | Precision Pulse™ | 0.9 | Stainless | Argon Mix | UltimArc™ |
| 422 | GMAW-P | Precision Pulse™ | 1.0 | Stainless | Argon Mix | UltimArc™ |
| 423 | GMAW-P | Precision Pulse™ | 1.2 | Stainless | Argon Mix | UltimArc™ |

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CONTENTS OF WELDING SOFTWARE Z143312*

*Modes listed on this page are only available on power sources compatible with either the Power Wave STT[®] Module
or Power Wave[®] Advanced Module

| Mode | Process | Procedure | Wire Size | Wire Type | Gas Type | Arc Control |
|------|------------------|-------------------------------|-----------|------------|-----------------------|--------------------------------------|
| 273 | GMAW-P | Rapid X [™] | 1.0 | Steel | Argon Mix | UltimArc [™] |
| 274 | GMAW-P | Rapid X [™] | 1.2 | Steel | Argon Mix | UltimArc [™] |
| 283 | GMAW-P | Rapid X [™] | 1.0 | Stainless | Argon Mix | UltimArc [™] |
| 284 | GMAW-P | Rapid X [™] | 1.2 | Stainless | Argon Mix | UltimArc [™] |
| 294 | GMAW-P | Rapid X [™] | 1.2 | Metal Core | Argon Mix | UltimArc [™] |
| 304 | STT [®] | Non Synergic STT [®] | 0.9 | Steel | CO ₂ | Peak, Background, Tailout, Hot Start |
| 305 | STT [®] | Non Synergic STT [®] | 0.9 | Steel | Argon Mix | Peak, Background, Tailout, Hot Start |
| 306 | STT [®] | Non Synergic STT [®] | 1.0 | Steel | CO ₂ | Peak, Background, Tailout, Hot Start |
| 307 | STT [®] | Non Synergic STT [®] | 1.0 | Steel | Argon Mix | Peak, Background, Tailout, Hot Start |
| 308 | STT [®] | Non Synergic STT [®] | 1.2 | Steel | CO ₂ | Peak, Background, Tailout, Hot Start |
| 309 | STT [®] | Non Synergic STT [®] | 1.2 | Steel | Argon Mix | Peak, Background, Tailout, Hot Start |
| 324 | STT [®] | Synergic STT [®] | 0.9 | Steel | CO ₂ | UltimArc [™] , Hot Start |
| 325 | STT [®] | Synergic STT [®] | 0.9 | Steel | Argon Mix | UltimArc [™] , Hot Start |
| 326 | STT [®] | Synergic STT [®] | 1.0 | Steel | CO ₂ | UltimArc [™] , Hot Start |
| 327 | STT [®] | Synergic STT [®] | 1.0 | Steel | Argon Mix | UltimArc [™] , Hot Start |
| 328 | STT [®] | Synergic STT [®] | 1.2 | Steel | CO ₂ | UltimArc [™] , Hot Start |
| 329 | STT [®] | Synergic STT [®] | 1.2 | Steel | Argon Mix | UltimArc [™] , Hot Start |
| 344 | STT [®] | Non Synergic STT [®] | 0.9 | Stainless | Argon Mix | Peak, Background, Tailout, Hot Start |
| 345 | STT [®] | Non Synergic STT [®] | 0.9 | Stainless | He Ar CO ₂ | Peak, Background, Tailout, Hot Start |
| 346 | STT [®] | Non Synergic STT [®] | 1.0 | Stainless | Argon Mix | Peak, Background, Tailout, Hot Start |
| 347 | STT [®] | Non Synergic STT [®] | 1.0 | Stainless | He Ar CO ₂ | Peak, Background, Tailout, Hot Start |
| 348 | STT [®] | Non Synergic STT [®] | 1.2 | Stainless | Argon Mix | Peak, Background, Tailout, Hot Start |
| 349 | STT [®] | Non Synergic STT [®] | 1.2 | Stainless | He Ar CO ₂ | Peak, Background, Tailout, Hot Start |
| 364 | STT [®] | Synergic STT [®] | 0.9 | Stainless | Argon Mix | UltimArc [™] , Hot Start |
| 365 | STT [®] | Synergic STT [®] | 0.9 | Stainless | He Ar CO ₂ | UltimArc [™] , Hot Start |
| 366 | STT [®] | Synergic STT [®] | 1.0 | Stainless | Argon Mix | UltimArc [™] , Hot Start |
| 367 | STT [®] | Synergic STT [®] | 1.0 | Stainless | He Ar CO ₂ | UltimArc [™] , Hot Start |
| 368 | STT [®] | Synergic STT [®] | 1.2 | Stainless | Argon Mix | UltimArc [™] , Hot Start |
| 369 | STT [®] | Synergic STT [®] | 1.2 | Stainless | He Ar CO ₂ | UltimArc [™] , Hot Start |



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CONTENTS OF WELDING SOFTWARE Z143312*

*Modes listed on this page are only available on power sources compatible with the Power Wave® Advanced Module.

| Mode | Process | Procedure | Wire Size | Wire Type | Gas Type | Arc Control |
|------|-----------|---------------------|-----------|-----------|----------|--|
| 375 | GTAW | HF Start GTAW | | | Argon | Hot Start |
| 376 | GTAW-P | HF Start GTAW-P | | | Argon | Frequency, Background, Hot Start |
| 377 | AC GTAW | Touch Start AC GTAW | | | Argon | AC Frequency, AC Balance, DC Offset, Hot Start |
| 378 | AC GTAW | HF Start AC GTAW | | | Argon | AC Frequency, AC Balance, DC Offset, Hot Start |
| | | | | | | |
| 393 | AC GMAW-P | AC Pulse | 1.2 | AlSi | Argon | UltimArc™ |
| 394 | AC GMAW-P | AC Pulse | 1.6 | AlSi | Argon | UltimArc™ |
| 398 | AC GMAW-P | AC Pulse | 1.2 | AlMg | Argon | UltimArc™ |
| 399 | AC GMAW-P | AC Pulse | 1.6 | AlMg | Argon | UltimArc™ |



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CONTENTS OF WELDING SOFTWARE Z143312*

*Modes listed on this page are only available on power sources compatible with the Autodrive 19® Tandem controller.

| Mode | Process | Procedure | Wire Size | Wire Type | Gas Type | Arc Control |
|------|---------|--------------------------|-----------|-----------|-----------|-------------|
| 402 | GMAW-P | Synchronized Pulse Lead | 1.0 | Steel | Argon Mix | UltimArc™ |
| 403 | GMAW-P | Synchronized Pulse Trail | 1.0 | Steel | Argon Mix | UltimArc™ |
| 404 | GMAW-P | Synchronized Pulse Lead | 1.2 | Steel | Argon Mix | UltimArc™ |
| 405 | GMAW-P | Synchronized Pulse Trail | 1.2 | Steel | Argon Mix | UltimArc™ |
| 406 | GMAW-P | Synchronized Pulse Lead | 1.4 | Steel | Argon Mix | UltimArc™ |
| 407 | GMAW-P | Synchronized Pulse Trail | 1.4 | Steel | Argon Mix | UltimArc™ |
| 461 | HW-GMAW | Synchronized Pulse Trail | 1.0 | Steel | Argon Mix | |
| 462 | HW-GMAW | Synchronized Pulse Trail | 1.2 | Steel | Argon Mix | |
| 463 | HW-GMAW | Synchronized Pulse Trail | 1.4 | Steel | Argon Mix | |



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