

**Maximum Range is limited by power source rating*

	Type	Size	Procedure	Waveform	Gas Type	Mode #	Arc Control	Max. Range (*)	
		All	All	GMAW CV	STD CV		5	Pinch	10 - 45 V
			GMAW Power	Power Mode®		40	Pinch	0.1 - 9 kW	
GMAW	Steel	0.030	GMAW CV	CV	CO ₂	93	Pinch	75 - 700 ipm	
					Argon Mix	94		75 - 700 ipm	
			GMAW Pulse	Pulse	Argon Mix	95	UltimArc®	65 - 700 ipm	
			0.035	GMAW CV	CV	CO ₂	10	Pinch	50 - 700 ipm
					Argon Mix	11	50 - 700 ipm		
		GMAW Pulse		Pulse	Argon Mix	12	UltimArc®	60 - 700 ipm	
			RapidArc®	Argon Mix	13	60 - 700 ipm			
			Precision Pulse™	Argon Mix	411	100 - 600 ipm			
			0.040	GMAW CV	CV	CO ₂	138	Pinch	50 - 700 ipm
					Argon Mix	139	50 - 650 ipm		
		GMAW Pulse		Pulse	Argon Mix	140	UltimArc®	60 - 700 ipm	
				RapidArc®	Argon Mix	141		60 - 700 ipm	
		Precision Pulse™	Argon Mix	412	75 - 600 ipm				
		0.045	GMAW CV	CV	CO ₂	20	Pinch	50 - 402 ipm	
				Argon Mix	21	50 - 393 ipm			
	GMAW Pulse		Pulse	Argon Mix	22	UltimArc®	50 - 437 ipm		
		RapidArc®	Argon Mix	18	75 - 535 ipm				
		Precision Pulse™	Argon Mix	413	75 - 483 ipm				
		Stainless	0.030	GMAW CV	CV	Argon Mix	61	Pinch	100 - 700 ipm
					He Ar CO ₂	63	100 - 700 ipm		
GMAW Pulse	Pulse			He Ar CO ₂	64	UltimArc®	90 - 700 ipm		
				Argon Mix	66		80 - 700 ipm		
	Precision Pulse™			Argon Mix	420		100 - 700 ipm		
			He Ar CO ₂	430	UltimArc®	100 - 700 ipm			
	0.035		GMAW CV	CV	Argon Mix	31	Pinch	75 - 700 ipm	
				He Ar CO ₂	33	75 - 700 ipm			
GMAW Pulse			Pulse	He Ar CO ₂	34	UltimArc®	75 - 700 ipm		
				Argon Mix	36		60 - 700 ipm		
	Precision Pulse™		Argon Mix	421	UltimArc®		100 - 600 ipm		
			He Ar CO ₂	431		100 - 700 ipm			
	0.045	GMAW CV	CV	Argon Mix	41	Pinch	75 - 394 ipm		
			He Ar CO ₂	43	75 - 480 ipm				
GMAW Pulse		Pulse	He Ar CO ₂	44	UltimArc®	75 - 510 ipm			
			Argon Mix	46		50 - 418 ipm			
		Precision Pulse™	Argon Mix	423		UltimArc®	50 - 400 ipm		
		He Ar CO ₂	433	60 - 400 ipm					
	Metal Core	0.045	GMAW CV	CV	Argon Mix	81	Pinch	100 - 504 ipm	
			GMAW Pulse	Pulse	Argon Mix	82		UltimArc®	50 - 540 ipm
			RapidArc®	Argon Mix	87	75 - 625 ipm			
		GMAW CV	CV	Argon Mix	83	Pinch	50 - 350 ipm		
		0.052	GMAW Pulse	Pulse	Argon Mix	84	UltimArc®	50 - 372 ipm	
			RapidArc®	Argon Mix	88	60 - 372 ipm			

Weld Set Reference: Z163923
Power Wave® C300

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	Type	Size	Procedure	Waveform	Gas Type	Mode #	Arc Control	Max. Range (*)
GMAW	Aluminum 4XXX	0.035	GMAW CV	CV	Argon	148	Pinch	150 - 700 ipm
			GMAW Pulse	Pulse	Argon	149	UltimArc®	125 - 700 ipm
				CC Pulse	Argon	150		125 - 700 ipm
		GMAW Pulse on Pulse®	Pulse on Pulse®	Argon	98	Frequency	125 - 700 ipm	
		3/64	GMAW CV	CV	Argon	71	Pinch	125 - 500 ipm
			GMAW Pulse	Pulse	Argon	72	UltimArc®	85 - 567 ipm
	CC Pulse			Argon	69	85 - 567 ipm		
	GMAW Pulse on Pulse®	Pulse on Pulse®	Argon	99	Frequency	85 - 500 ipm		
	Aluminum 5XXX	0.035	GMAW CV	CV	Argon	151	Pinch	175 - 700 ipm
			GMAW Pulse	Pulse	Argon	152	UltimArc®	150 - 700 ipm
				CC Pulse	Argon	153		150 - 700 ipm
		GMAW Pulse on Pulse®	Pulse on Pulse®	Argon	101	Frequency	140 - 700 ipm	
		3/64	GMAW CV	CV	Argon	75	Pinch	125 - 700 ipm
			GMAW Pulse	Pulse	Argon	76	UltimArc®	85 - 700 ipm
	CC Pulse			Argon	70	85 - 700 ipm		
	GMAW Pulse on Pulse®	Pulse on Pulse®	Argon	102	Frequency	100 - 600 ipm		
	SiBr	0.035	GMAW Pulse	Pulse	Argon	192	UltimArc®	80 - 700 ipm
		0.045	GMAW Pulse	Pulse	Argon	191	UltimArc®	50 - 470 ipm
	Cu	0.035	GMAW Pulse	Pulse	Argon Helium	198	UltimArc®	100 - 643 ipm
		0.045	GMAW Pulse	Pulse	Argon Helium	196	UltimArc®	75 - 433 ipm
	Ni Alloy	0.035	GMAW Pulse	Pulse	Ar He	170	UltimArc®	80 - 700 ipm
Precision Pulse™				Ar He	451	UltimArc®	75 - 600 ipm	
0.045		GMAW Pulse	Pulse	Ar He	175	UltimArc®	75 - 465 ipm	
			Precision Pulse™	Ar He	453	UltimArc®	75 - 524 ipm	
FCAW	Flux Core	All	FCAW-S	STD CV	NA	6	Pinch	10 - 45 V
			FCAW-G	STD CV		7	Pinch	10 - 45 V
	0.045	FCAW-G	CV	CO ₂		90	Pinch	175 - 600 ipm
				Argon Mix		91		175 - 600 ipm
SMAW	All	All	DCEP SMAW	SMAW Soft	NA	1	Arc Force, Hot Start	15 - 300 A
				SMAW Crisp	NA	2	Arc Force, Hot Start	15 - 300 A
				SMAW Pipe	NA	4	Arc Force	50 - 250 A
GTAW	NA	NA	DCEN GTAW	GTAW Touch Start	Argon	3	Hot Start	5 - 300 A
				GTAW-P	Argon	8	Hot Start, Frequency, Background	5 - 300 A
CAG	NA	NA	CAG	CAG	Air	9		60 - 300 A