

Weld Set Reference: Z193615
PipeFab® (Imperial units)



Process	MIG Type	Wire Type	Wire Diameter	Gas Type	Arc Control	Range
GMAW	CV	Steel	0.035"	90% Ar 10% CO ₂	Pinch	100 — 815 ipm (2.54 — 20.7 m/min)
				85% Ar 15% CO ₂		100 — 815 ipm (2.54 — 20.7 m/min)
				80% Ar 20% CO ₂		100 — 815 ipm (2.54 — 20.7 m/min)
				75% Ar 25% CO ₂		100 — 815 ipm (2.54 — 20.7 m/min)
				100% CO ₂		75 — 800 ipm (1.91 — 20.32 m/min)
			0.045"	90% Ar 10% CO ₂	50 — 615 ipm (1.27 — 15.62 m/min)	
				85% Ar 15% CO ₂	50 — 615 ipm (1.27 — 15.62 m/min)	
				80% Ar 20% CO ₂	50 — 615 ipm (1.27 — 15.62 m/min)	
				75% Ar 25% CO ₂	50 — 780 ipm (1.27 — 19.81 m/min)	
				100% CO ₂	50 — 800 ipm (1.27 — 20.32 m/min)	
		Stainless 3XX	0.035"	98% Ar 2% CO ₂	Pinch	100 — 800 ipm (2.54 — 20.32 m/min)
				98% Ar 2% O ₂		100 — 800 ipm (2.54 — 20.32 m/min)
				Tri-Helium		100 — 815 ipm (2.54 — 20.7 m/min)
			0.045"	98% Ar 2% CO ₂	Pinch	75 — 595 ipm (1.91 — 15.11 m/min)
				98% Ar 2% O ₂		75 — 595 ipm (1.91 — 15.11 m/min)
				Tri-Helium		75 — 800 ipm (1.91 — 20.32 m/min)
	Metal Core	0.045"	90% Ar 10% CO ₂	Pinch	100 — 610 ipm (2.54 — 15.49 m/min)	
			85% Ar 15% CO ₂		100 — 610 ipm (2.54 — 15.49 m/min)	
			80% Ar 20% CO ₂		100 — 610 ipm (2.54 — 15.49 m/min)	
			75% Ar 25% CO ₂		100 — 610 ipm (2.54 — 15.49 m/min)	
			75% Ar 25% CO ₂		100 — 650 ipm (2.54 — 16.51 m/min)	
	Low Fume Pulse™	Steel	0.035"	UltimArc®	75 — 815 ipm (1.91 — 20.7 m/min)	
			0.045"		100 — 800 ipm (2.54 — 20.32 m/min)	
	STT® (Root Pass)	Steel	0.035"	90% Ar 10% CO ₂	UltimArc®	100 — 350 ipm (2.54 — 8.89 m/min)
				85% Ar 15% CO ₂		100 — 350 ipm (2.54 — 8.89 m/min)
				80% Ar 20% CO ₂		100 — 350 ipm (2.54 — 8.89 m/min)
				75% Ar 25% CO ₂		100 — 350 ipm (2.54 — 8.89 m/min)
				75% Ar 25% CO ₂		100 — 350 ipm (2.54 — 8.89 m/min)
			0.045"	90% Ar 10% CO ₂	UltimArc®	90 — 250 ipm (2.29 — 6.35 m/min)
				85% Ar 15% CO ₂		90 — 250 ipm (2.29 — 6.35 m/min)
				80% Ar 20% CO ₂		90 — 250 ipm (2.29 — 6.35 m/min)
				75% Ar 25% CO ₂		90 — 250 ipm (2.29 — 6.35 m/min)
75% Ar 25% CO ₂				90 — 250 ipm (2.29 — 6.35 m/min)		
Stainless 3XX		0.035"	98% Ar 2% CO ₂	UltimArc®	100 — 350 ipm (2.54 — 8.89 m/min)	
			98% Ar 2% O ₂		100 — 350 ipm (2.54 — 8.89 m/min)	
			Tri-Helium		100 — 350 ipm (2.54 — 8.89 m/min)	
		0.045"	98% Ar 2% CO ₂	UltimArc®	90 — 250 ipm (2.29 — 6.35 m/min)	
			98% Ar 2% O ₂		90 — 250 ipm (2.29 — 6.35 m/min)	
			Tri-Helium		90 — 250 ipm (2.29 — 6.35 m/min)	
Metal Core	0.045"	85% Ar 15% CO ₂	UltimArc®	90 — 225 ipm (2.29 — 5.72 m/min)		
		80% Ar 20% CO ₂		90 — 225 ipm (2.29 — 5.72 m/min)		
		75% Ar 25% CO ₂		90 — 225 ipm (2.29 — 5.72 m/min)		

Process	MIG Type	Wire Type	Wire Diameter	Gas Type	Arc Control	Range
GMAW	Smart Pulse™	Steel	0.035"	90% Ar 10% CO ₂	UltimArc®	100 — 800 ipm (2.54 — 20.32 m/min)
				85% Ar 15% CO ₂		100 — 800 ipm (2.54 — 20.32 m/min)
				80% Ar 20% CO ₂		100 — 800 ipm (2.54 — 20.32 m/min)
			0.045"	90% Ar 10% CO ₂	UltimArc®	100 — 700 ipm (2.54 — 17.78 m/min)
				85% Ar 15% CO ₂		100 — 700 ipm (2.54 — 17.78 m/min)
				80% Ar 20% CO ₂		100 — 700 ipm (2.54 — 17.78 m/min)
		Stainless 3XX	0.035"	98% Ar 2% CO ₂	UltimArc®	125 — 800 ipm (3.18 — 20.32 m/min)
				98% Ar 2% O ₂		125 — 800 ipm (3.18 — 20.32 m/min)
				Tri-Helium		125 — 800 ipm (3.18 — 20.32 m/min)
		0.045"	98% Ar 2% CO ₂	UltimArc®	100 — 780 ipm (2.54 — 19.81 m/min)	
			98% Ar 2% O ₂		100 — 780 ipm (2.54 — 19.81 m/min)	
			Tri-Helium		100 — 800 ipm (2.54 — 20.32 m/min)	
Metal Core	0.045"	90% Ar 10% CO ₂	UltimArc®	100 — 620 ipm (2.54 — 15.75 m/min)		
		85% Ar 15% CO ₂		100 — 620 ipm (2.54 — 15.75 m/min)		
		80% Ar 20% CO ₂		100 — 620 ipm (2.54 — 15.75 m/min)		

Process	FCAW Type	Wire Type	Wire Diameter	Gas Type	Arc Control	Range
FCAW	CV	Steel	0.045"	75% Ar 25% CO ₂	Pinch	175 — 600 ipm (4.45 — 15.24 m/min)
				100% CO ₂		175 — 600 ipm (4.45 — 15.24 m/min)
			0.052"	75% Ar 25% CO ₂	Pinch	150 — 500 ipm (3.81 — 12.7 m/min)
				100% CO ₂		150 — 500 ipm (3.81 — 12.7 m/min)
			1/16"	75% Ar 25% CO ₂	Pinch	125 — 400 ipm (3.18 — 10.16 m/min)
				100% CO ₂		125 — 400 ipm (3.18 — 10.16 m/min)

Process	Electrode	Type	Size	Gas Type	Arc Control	Range
SMAW	E7018	Steel	All	N/A	Pinch	15 — 405 A
	E6010	Steel	All	N/A	Pinch	15 — 405 A

Process	Procedure	Type	Size	Gas Type	Arc Control	Range
GTAW	HF	N/A	All	Ar / He		5 — 405 A
	Touch Start	N/A	All	Ar / He		5 — 405 A