

§ Advanced Module Required

o External HF Starter Required

* Range is limited by power source rating, module rating, or feeder configuration

‡ STT® or Advanced Module Required

Δ Tandem Controller Required

| 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 - 11 kW | |
| Type | Size | Procedure | Waveform | Gas Type | Mode # | Arc Control | Max. Range (*) | |
| GMAW | 0.8 mm | GMAW CV | CV | CO ₂ | 93 | Pinch | 75 - 1200 ipm (1.91 - 30.48 m/min) | |
| | | | Argon Mix | 94 | 75 - 1200 ipm (1.91 - 30.48 m/min) | | | |
| | | GMAW Pulse | Pulse | Argon Mix | 95 | UltimArc® | 65 - 1200 ipm (1.65 - 30.48 m/min) | |
| | | | Precision Pulse™ | Argon Mix | 410 | | 100 - 600 ipm (2.54 - 15.24 m/min) | |
| | 0.9 mm | GMAW CV | CV | CO ₂ | 138 | Pinch | 50 - 1200 ipm (1.27 - 30.48 m/min) | |
| | | | Argon Mix | 139 | 50 - 1075 ipm (1.27 - 27.31 m/min) | | | |
| | | | Pulse | Argon Mix | 140 | | UltimArc® | 60 - 1075 ipm (1.52 - 27.31 m/min) |
| | | | RapidArc® | Argon Mix | 141 | | | 60 - 1200 ipm (1.52 - 30.48 m/min) |
| | | GMAW Pulse | Precision Pulse™ | Argon Mix | 411 | 100 - 600 ipm (2.54 - 15.24 m/min) | | |
| | | | Rapid X™(‡) | Argon Mix | 272 | 75 - 800 ipm (1.91 - 20.32 m/min) | | |
| | | GMAW STT® | Synergic STT®(‡) | CO ₂ | 324 | UltimArc®, Hot Start | 100 - 225 ipm (2.54 - 5.72 m/min) | |
| | | | Argon Mix | 325 | 100 - 225 ipm (2.54 - 5.72 m/min) | | | |
| | NonSynergic STT®(‡) | | CO ₂ | 304 | 100 - 300 ipm (2.54 - 7.62 m/min) | | | |
| | 1.0 mm | GMAW CV | CV | CO ₂ | 10 | Pinch | 50 - 775 ipm (1.27 - 19.69 m/min) | |
| | | | Argon Mix | 11 | 50 - 610 ipm (1.27 - 15.49 m/min) | | | |
| | | | Pulse | Argon Mix | 12 | | UltimArc® | 75 - 590 ipm (1.91 - 14.99 m/min) |
| | | | RapidArc® | Argon Mix | 13 | | | 60 - 825 ipm (1.52 - 20.96 m/min) |
| | | GMAW Pulse | Precision Pulse™ | Argon Mix | 412 | 75 - 600 ipm (1.91 - 15.24 m/min) | | |
| | | | Rapid X™(‡) | Argon Mix | 273 | 75 - 800 ipm (1.91 - 20.32 m/min) | | |
| | | GMAW STT® | Synergic STT®(‡) | CO ₂ | 326 | UltimArc®, Hot Start | 90 - 225 ipm (2.29 - 5.72 m/min) | |
| | | | Argon Mix | 327 | 90 - 225 ipm (2.29 - 5.72 m/min) | | | |
| | NonSynergic STT®(‡) | | CO ₂ | 306 | 90 - 225 ipm (2.29 - 5.72 m/min) | | | |
| | 1.2 mm | GMAW CV | CV | CO ₂ | 20 | Pinch | 50 - 540 ipm (1.27 - 13.72 m/min) | |
| | | | Argon Mix | 21 | 50 - 440 ipm (1.27 - 11.18 m/min) | | | |
| | | | Pulse | Argon Mix | 22 | | UltimArc® | 60 - 475 ipm (1.52 - 12.07 m/min) |
| | | | RapidArc® | Argon Mix | 18 | | | 60 - 605 ipm (1.52 - 15.37 m/min) |
| | | GMAW Pulse | Precision Pulse™ | Argon Mix | 413 | 75 - 600 ipm (1.91 - 15.24 m/min) | | |
| | | | Rapid X™(‡) | Argon Mix | 274 | 100 - 690 ipm (2.54 - 17.53 m/min) | | |
| | | GMAW STT® | Synergic STT®(‡) | CO ₂ | 328 | UltimArc®, Hot Start | 90 - 200 ipm (2.29 - 5.08 m/min) | |
| | | | Argon Mix | 329 | 90 - 200 ipm (2.29 - 5.08 m/min) | | | |
| | NonSynergic STT®(‡) | | CO ₂ | 308 | 90 - 225 ipm (2.29 - 5.72 m/min) | | | |
| | 1.4 mm | GMAW CV | CV | CO ₂ | 24 | Pinch | 50 - 310 ipm (1.27 - 7.87 m/min) | |
| | | | Argon Mix | 25 | 50 - 290 ipm (1.27 - 7.37 m/min) | | | |
| | | | Pulse | Argon Mix | 26 | | UltimArc® | 50 - 300 ipm (1.27 - 7.62 m/min) |
| | | | RapidArc® | Argon Mix | 27 | | | 60 - 335 ipm (1.52 - 8.51 m/min) |
| | | GMAW Pulse | Rapid X™(‡) | Argon Mix | 275 | 75 - 395 ipm (1.91 - 10.03 m/min) | | |
| GMAW STT® | | | Synergic STT®(‡) | CO ₂ | 328 | UltimArc®, Hot Start | 90 - 200 ipm (2.29 - 5.08 m/min) | |
| | | Argon Mix | 329 | 90 - 200 ipm (2.29 - 5.08 m/min) | | | | |
| | | NonSynergic STT®(‡) | CO ₂ | 308 | 90 - 225 ipm (2.29 - 5.72 m/min) | | | |
| 1.6 mm | GMAW CV | CV | Argon Mix | 107 | Pinch | 50 - 225 ipm (1.27 - 5.72 m/min) | | |
| | GMAW Pulse | Pulse | Argon Mix | 108 | UltimArc® | 50 - 255 ipm (1.27 - 6.48 m/min) | | |
| Metal Core | 0.9mm | GMAW Rapid Z™ | Rapid Z™(§) | Argon Mix | 472 | UltimArc® | 75 - 900 ipm (1.91 - 22.86 m/min) | |
| | 1.0mm | GMAW Rapid Z™ | Rapid Z™(§) | Argon Mix | 473 | UltimArc® | 70 - 700 ipm (1.78 - 17.78 m/min) | |
| | 1.2 mm | GMAW CV | CV | Argon Mix | 81 | Pinch | 50 - 555 ipm (1.27 - 14.1 m/min) | |
| | | GMAW Pulse | Pulse | Argon Mix | 82 | UltimArc® | 50 - 530 ipm (1.27 - 13.46 m/min) | |
| | Rapid X™(‡) | Argon Mix | 294 | 75 - 700 ipm (1.91 - 17.78 m/min) | | | | |
| | 1.4 mm | GMAW Pulse | Pulse | Argon Mix | 84 | UltimArc® | 50 - 335 ipm (1.27 - 8.51 m/min) | |
| | | Rapid X™(‡) | Argon Mix | 295 | 60 - 420 ipm (1.52 - 10.67 m/min) | | | |
| | 1.6 mm | GMAW CV | CV | Argon Mix | 85 | Pinch | 50 - 310 ipm (1.27 - 7.87 m/min) | |
| GMAW Pulse | | Pulse | Argon Mix | 86 | UltimArc® | 50 - 360 ipm (1.27 - 9.14 m/min) | | |
| Rapid X™(‡) | Argon Mix | 296 | 75 - 360 ipm (1.91 - 9.14 m/min) | | | | | |
| Stainless Metal Core EC4XX | 1.2 mm | GMAW Pulse | Rapid X™(‡) | Argon Mix | 290 | UltimArc® | 75 - 665 ipm (1.91 - 16.89 m/min) | |

§ Advanced Module Required

o External HF Starter Required

* Range is limited by power source rating, module rating, or feeder configuration

‡ STT® or Advanced Module Required

Δ Tandem Controller Required

| | GMAW | | Type | Size | Procedure | Waveform | Gas Type | Mode # | Arc Control | Max. Range (*) |
|----------------------|---------------------|-----------------------|-----------------------|--------------------------------------|------------------------------------|--------------------------------------|------------------------------------|-------------------------------------|-------------|-------------------------------------|
| | | | | | | | | | | |
| GMAW | Stainless | 0.8 mm | GMAW CV | CV | Argon Mix | CV | Argon Mix | 61 | Pinch | 100 - 1120 ipm (2.54 - 28.45 m/min) |
| | | | | | | | Ar He CO ₂ | 63 | | 100 - 1200 ipm (2.54 - 30.48 m/min) |
| | | | GMAW Pulse | Pulse | Ar He CO ₂ | 64 | UltimArc® | 100 - 1200 ipm (2.54 - 30.48 m/min) | | |
| | | | | | Argon Mix | 66 | | 100 - 1200 ipm (2.54 - 30.48 m/min) | | |
| | | 0.9 mm | GMAW CV | CV | Argon Mix | 29 | Pinch | 75 - 1200 ipm (1.91 - 30.48 m/min) | | |
| | | | | | Ar He CO ₂ | 30 | | 60 - 1110 ipm (1.52 - 28.19 m/min) | | |
| | | | GMAW Pulse | Pulse | Argon Mix | 30 | UltimArc® | 60 - 1110 ipm (1.52 - 28.19 m/min) | | |
| | | | | | Precision Pulse™ | 421 | | 100 - 600 ipm (2.54 - 15.24 m/min) | | |
| | | | GMAW STT® | Synergic STT®(‡) | Argon Mix | 364 | UltimArc®, Hot Start | 100 - 300 ipm (2.54 - 7.62 m/min) | | |
| | | | | | Ar He CO ₂ | 365 | | 100 - 250 ipm (2.54 - 6.35 m/min) | | |
| | | GMAW STT® | NonSynergic STT®(‡) | Argon Mix | 344 | Peak, Background, Tailout, Hot Start | 100 - 300 ipm (2.54 - 7.62 m/min) | | | |
| | | | | Ar He CO ₂ | 345 | | 100 - 300 ipm (2.54 - 7.62 m/min) | | | |
| | 1.0 mm | GMAW CV | CV | Argon Mix | 31 | Pinch | 75 - 920 ipm (1.91 - 23.37 m/min) | | | |
| | | | | Ar He CO ₂ | 33 | | 75 - 710 ipm (1.91 - 18.03 m/min) | | | |
| | | | GMAW Pulse | Pulse | Ar He CO ₂ | 34 | UltimArc® | 60 - 835 ipm (1.52 - 21.21 m/min) | | |
| | | | | | Argon Mix | 36 | | 60 - 910 ipm (1.52 - 23.11 m/min) | | |
| | | GMAW Pulse | Precision Pulse™ | Argon Mix | 422 | UltimArc® | 60 - 600 ipm (1.52 - 15.24 m/min) | | | |
| | | | | Rapid X™(‡) | 283 | | 100 - 800 ipm (2.54 - 20.32 m/min) | | | |
| | | GMAW STT® | Synergic STT®(‡) | Argon Mix | 366 | UltimArc®, Hot Start | 100 - 300 ipm (2.54 - 7.62 m/min) | | | |
| | | | | Ar He CO ₂ | 367 | | 100 - 250 ipm (2.54 - 6.35 m/min) | | | |
| | | GMAW STT® | NonSynergic STT®(‡) | Argon Mix | 346 | Peak, Background, Tailout, Hot Start | 100 - 300 ipm (2.54 - 7.62 m/min) | | | |
| | | | | Ar He CO ₂ | 347 | | 100 - 300 ipm (2.54 - 7.62 m/min) | | | |
| | 1.2 mm | GMAW CV | CV | Argon Mix | 41 | Pinch | 75 - 460 ipm (1.91 - 11.68 m/min) | | | |
| | | | | Ar He CO ₂ | 43 | | 75 - 435 ipm (1.91 - 11.05 m/min) | | | |
| | | | GMAW Pulse | Pulse | Ar He CO ₂ | 44 | UltimArc® | 50 - 450 ipm (1.27 - 11.43 m/min) | | |
| | | | | | Argon Mix | 46 | | 50 - 560 ipm (1.27 - 14.22 m/min) | | |
| | | GMAW Pulse | Precision Pulse™ | Argon Mix | 423 | UltimArc® | 50 - 400 ipm (1.27 - 10.16 m/min) | | | |
| | | | | Rapid X™(‡) | 284 | | 100 - 780 ipm (2.54 - 19.81 m/min) | | | |
| GMAW STT® | | Synergic STT®(‡) | Argon Mix | 368 | UltimArc®, Hot Start | 90 - 200 ipm (2.29 - 5.08 m/min) | | | | |
| | | | Ar He CO ₂ | 369 | | 90 - 200 ipm (2.29 - 5.08 m/min) | | | | |
| GMAW STT® | NonSynergic STT®(‡) | Argon Mix | 348 | Peak, Background, Tailout, Hot Start | 90 - 225 ipm (2.29 - 5.72 m/min) | | | | | |
| | | Ar He CO ₂ | 349 | | 90 - 225 ipm (2.29 - 5.72 m/min) | | | | | |
| 1.6 mm | GMAW CV | CV | Argon Mix | 51 | Pinch | 50 - 215 ipm (1.27 - 5.46 m/min) | | | | |
| | GMAW Pulse | Pulse | Argon Mix | 56 | UltimArc® | 50 - 235 ipm (1.27 - 5.97 m/min) | | | | |
| SiBr | 1.0mm | GMAW Pulse | Pulse | Argon | 192 | UltimArc® | 80 - 775 ipm (2.03 - 19.69 m/min) | | | |
| | 1.2mm | GMAW Pulse | Pulse | Argon | 191 | UltimArc® | 50 - 555 ipm (1.27 - 14.1 m/min) | | | |
| Cu | 1.0mm | GMAW Pulse | Pulse | Argon Helium | 198 | UltimArc® | 75 - 500 ipm (1.91 - 12.7 m/min) | | | |
| | 1.2mm | GMAW Pulse | Pulse | Argon Helium | 196 | UltimArc® | 75 - 500 ipm (1.91 - 12.7 m/min) | | | |
| NiCr | 1.0mm | GMAW Pulse | Pulse | Ar/ Ar He | 502 | UltimArc® | 75 - 800 ipm (1.91 - 20.32 m/min) | | | |
| | 1.2mm | GMAW Pulse | Pulse | Ar/ Ar He | 504 | UltimArc® | 75 - 600 ipm (1.91 - 15.24 m/min) | | | |
| GMAW | Aluminum (AlSi) | 1.0 mm | GMAW CV | CV | Argon | 148 | Pinch | 125 - 800 ipm (3.18 - 20.32 m/min) | | |
| | | | | | Argon | 149 | UltimArc® | 125 - 800 ipm (3.18 - 20.32 m/min) | | |
| | | | GMAW Pulse | Pulse | Argon | 150 | UltimArc® | 125 - 800 ipm (3.18 - 20.32 m/min) | | |
| | | | | | CC Pulse | 150 | | 125 - 800 ipm (3.18 - 20.32 m/min) | | |
| | | | GMAW Pulse on Pulse* | Pulse on Pulse* | Argon | 98 | Frequency | 100 - 500 ipm (2.54 - 12.7 m/min) | | |
| | | GMAW AC Pulse | AC Pulse (§) | Argon | 392 | UltimArc® | 125 - 700 ipm (3.18 - 17.78 m/min) | | | |
| | | 1.2 mm | GMAW CV | CV | Argon | 71 | Pinch | 125 - 590 ipm (3.18 - 14.99 m/min) | | |
| | | | | | Argon | 72 | UltimArc® | 85 - 600 ipm (2.16 - 15.24 m/min) | | |
| | | | GMAW Pulse | Pulse | Argon | 69 | UltimArc® | 85 - 600 ipm (2.16 - 15.24 m/min) | | |
| | | | | | CC Pulse | 69 | | 85 - 600 ipm (2.16 - 15.24 m/min) | | |
| | | GMAW Pulse on Pulse* | Pulse on Pulse* | Argon | 99 | Frequency | 85 - 500 ipm (2.16 - 12.7 m/min) | | | |
| | | GMAW AC Pulse | AC Pulse (§) | Argon | 393 | UltimArc® | 100 - 500 ipm (2.54 - 12.7 m/min) | | | |
| | | 1.6 mm | GMAW CV | CV | Argon | 73 | Pinch | 75 - 340 ipm (1.91 - 8.64 m/min) | | |
| | | | | | Argon | 74 | UltimArc® | 75 - 350 ipm (1.91 - 8.89 m/min) | | |
| | | | GMAW Pulse | Pulse | Argon | 79 | UltimArc® | 75 - 350 ipm (1.91 - 8.89 m/min) | | |
| | | | | | CC Pulse | 79 | | 75 - 350 ipm (1.91 - 8.89 m/min) | | |
| GMAW Pulse on Pulse* | Pulse on Pulse* | | Argon | 100 | Frequency | 80 - 400 ipm (2.03 - 10.16 m/min) | | | | |
| GMAW AC Pulse | AC Pulse (§) | Argon | 394 | UltimArc® | 100 - 400 ipm (2.54 - 10.16 m/min) | | | | | |

§ Advanced Module Required

o External HF Starter Required

* Range is limited by power source rating, module rating, or feeder configuration

‡ STT® or Advanced Module Required

Δ Tandem Controller Required

| GMAW | Aluminum (AlMg) | Size | Procedure | Waveform | Gas Type | Mode # | Arc Control | Max. Range (*) | |
|----------|----------------------|-----------------|---------------|--------------------------|-----------|-----------|--------------------------|----------------|--------------------------|
| | | | GMAW CV | CV | Argon | 151 | Pinch | 175 - 750 | ipm (4.45 - 19.05 m/min) |
| 1.0 mm | GMAW Pulse | Pulse | Argon | 152 | UltimArc® | 125 - 700 | ipm (3.18 - 17.78 m/min) | | |
| | | | CC Pulse | Argon | | | | 153 | |
| 1.2 mm | GMAW Pulse on Pulse* | Pulse on Pulse* | Argon | 101 | Frequency | 140 - 800 | ipm (3.56 - 20.32 m/min) | | |
| | | | GMAW AC Pulse | AC Pulse (§) | Argon | 397 | UltimArc® | 100 - 800 | ipm (2.54 - 20.32 m/min) |
| | | | GMAW CV | CV | Argon | 75 | Pinch | 125 - 750 | ipm (3.18 - 19.05 m/min) |
| | | | GMAW Pulse | Pulse | Argon | 76 | UltimArc® | 85 - 700 | ipm (2.16 - 17.78 m/min) |
| CC Pulse | Argon | 70 | 85 - 700 | ipm (2.16 - 17.78 m/min) | | | | | |
| 1.6 mm | GMAW Pulse on Pulse* | Pulse on Pulse* | Argon | 102 | Frequency | 100 - 600 | ipm (2.54 - 15.24 m/min) | | |
| | | | GMAW AC Pulse | AC Pulse (§) | Argon | 398 | UltimArc® | 85 - 600 | ipm (2.16 - 15.24 m/min) |
| | | | GMAW CV | CV | Argon | 77 | Pinch | 125 - 470 | ipm (3.18 - 11.94 m/min) |
| | | | GMAW Pulse | Pulse | Argon | 78 | UltimArc® | 100 - 460 | ipm (2.54 - 11.68 m/min) |
| CC Pulse | Argon | 80 | 100 - 450 | ipm (2.54 - 11.43 m/min) | | | | | |
| 1.6 mm | GMAW Pulse on Pulse* | Pulse on Pulse* | Argon | 103 | Frequency | 75 - 350 | ipm (1.91 - 8.89 m/min) | | |
| | | | GMAW AC Pulse | AC Pulse (§) | Argon | 399 | UltimArc® | 100 - 400 | ipm (2.54 - 10.16 m/min) |

| FCAW | Type | Size | Procedure | Waveform | Gas Type | Mode # | Arc Control | Max. Range (*) | | | |
|------------|-----------|--------|-----------|-----------------|-----------------|--------|-----------------|-------------------------|--------------------------|-----------|-------------------------|
| | Flux Core | All | All | FCAW-S | Self Shield CV | NA | 6 | Pinch | 10 - 45 V | | |
| FCAW-G | | | | Gas Shield CV | NA | 7 | Pinch | 10 - 45 V | | | |
| Cored Wire | 1.2 mm | 1.2 mm | FCAW-G | CV | CO ₂ | 90 | Pinch | 175 - 600 | ipm (4.45 - 15.24 m/min) | | |
| | | | | | Argon Mix | 91 | | 175 - 600 | ipm (4.45 - 15.24 m/min) | | |
| | | | 1.4 mm | 1.4 mm | FCAW-G | CV | CO ₂ | 187 | Pinch | 150 - 500 | ipm (3.81 - 12.7 m/min) |
| | | | | | | | Argon Mix | 188 | | 150 - 500 | ipm (3.81 - 12.7 m/min) |
| 1.6 mm | 1.6 mm | FCAW-G | CV | CO ₂ | 189 | Pinch | 125 - 390 | ipm (3.18 - 9.91 m/min) | | | |
| | | | | Argon Mix | 190 | | 125 - 360 | ipm (3.18 - 9.14 m/min) | | | |

| SMAW | Type | Size | Procedure | Waveform | Gas Type | Mode # | Arc Control | Max. Range (*) |
|------------|------|------|-----------|--------------|-----------|--------|---------------------------------|----------------------|
| | NA | NA | NA | DCEP SMAW | SMAW Soft | NA | 1 | Arc Force, Hot Start |
| SMAW Crisp | | | | | NA | 2 | Arc Force, Hot Start | 15 - 350 A |
| SMAW Pipe | | | | | NA | 4 | Arc Force | 50 - 250 A |
| DCEN SMAW | | | | SMAW DC- (§) | NA | 379 | Arc Force, Hot Start | 15 - 350 A |
| AC SMAW | | | | AC SMAW (§) | NA | 374 | Arc Force, Hot Start, Frequency | 15 - 350 A |

| GTAW | Type | Size | Procedure | Waveform | Gas Type | Mode # | Arc Control | Max. Range (*) |
|-----------------------|------|------|-----------|------------------------|-----------------|---------|--|----------------|
| | NA | NA | NA | DCEN GTAW | Touch Start TIG | Ar / He | 3 | Hot Start |
| Touch Start TIG Pulse | | | | | Ar / He | 8 | Frequency, Background, Hot Start | 5 - 350 A |
| HF TIG (Ø) | | | | | Ar / He | 375 | Hot Start | 5 - 350 A |
| HF TIG Pulse (Ø) | | | | | Ar / He | 376 | Frequency, Background, Hot Start | 5 - 350 A |
| AC GTAW | | | | Touch Start AC TIG (§) | Ar / He | 377 | AC Frequency, AC Balance, DC Offset, Hot Start | 10 - 350 A |
| | | | | HF Start AC TIG (§) | Ar / He | 378 | AC Frequency, AC Balance, DC Offset, Hot Start | 10 - 350 A |

| CAG | Type | Size | Procedure | Waveform | Gas Type | Mode # | Arc Control | Max. Range (*) |
|-----|------|------|-----------|-----------|----------------|--------|-------------|----------------|
| | NA | NA | CAG | Arc Gouge | Compressed Air | 9 | | 60 - 350 A |

| GMAW-Tandem | Type | Size | Procedure | Waveform | Gas Type | Mode # | Arc Control | Max. Range (*) |
|---------------------|-------|-----------------|---------------------|-----------------|-----------|------------------------|------------------------|--------------------------|
| | Steel | 1.0 mm | GMAW Tandem (Δ) | Sync Pulse Lead | Argon Mix | 402 | UltimArc®, Phase Angle | 150 - 800 |
| Sync Pulse Trail | | | | Argon Mix | 403 | UltimArc® | 150 - 800 | ipm (3.81 - 20.32 m/min) |
| HotWire Pulse Trail | | | | Argon Mix | 461 | | 80 - 800 | ipm (2.03 - 20.32 m/min) |
| 1.2 mm | | GMAW Tandem (Δ) | Sync Pulse Lead | Argon Mix | 404 | UltimArc®, Phase Angle | 100 - 655 | ipm (2.54 - 16.64 m/min) |
| | | | Sync Pulse Trail | Argon Mix | 405 | UltimArc® | 100 - 655 | ipm (2.54 - 16.64 m/min) |
| | | | HotWire Pulse Trail | Argon Mix | 462 | | 75 - 610 | ipm (1.91 - 15.49 m/min) |
| 1.4 mm | | GMAW Tandem (Δ) | Sync Pulse Lead | Argon Mix | 406 | UltimArc®, Phase Angle | 100 - 455 | ipm (2.54 - 11.56 m/min) |
| | | | Sync Pulse Trail | Argon Mix | 407 | UltimArc® | 100 - 455 | ipm (2.54 - 11.56 m/min) |
| | | | HotWire Pulse Trail | Argon Mix | 463 | | 50 - 445 | ipm (1.27 - 11.3 m/min) |