

Weld Set Reference: Z204717
PipeFab® (Imperial units)



Process	MIG Type	Wire Type	Wire Diameter	Gas Type	Arc Control	Range
MIG	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)
			0.040"	90%Ar 10%CO ₂	Pinch	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)
				75%Ar 25%CO ₂		100 – 760 ipm (2.54 – 19.3 m/min)
				100%CO ₂		100 – 800 ipm (2.54 – 20.32 m/min)
			0.045"	90%Ar 10%CO ₂	Pinch	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)
				90%He 7.5%Ar 2.5%CO ₂		100 – 800 ipm (2.54 – 20.32 m/min)
			0.040"	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)
				90%He 7.5%Ar 2.5%CO ₂		100 – 800 ipm (2.54 – 20.32 m/min)
	0.045"		98%Ar 2%CO ₂	Pinch	75 – 745 ipm (1.91 – 18.92 m/min)	
			98%Ar 2%O ₂		75 – 745 ipm (1.91 – 18.92 m/min)	
			90%He 7.5%Ar 2.5%CO ₂		75 – 645 ipm (1.91 – 16.38 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 – 650 ipm (2.54 – 16.51 m/min)			
Low Fume Pulse	Steel	0.035"	UltimArc®	75 – 815 ipm (1.91 – 20.7 m/min)		
		0.040"	UltimArc®	75 – 800 ipm (1.91 – 20.32 m/min)		
		0.045"	UltimArc®	100 – 800 ipm (2.54 – 20.32 m/min)		

Process	MIG Type	Wire Type	Wire Diameter	Gas Type	Arc Control	Range		
MIG	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)		
			0.040"	90%Ar 10%CO ₂	UltimArc®	100 – 275 ipm (2.54 – 6.99 m/min)		
				85%Ar 15%CO ₂		100 – 275 ipm (2.54 – 6.99 m/min)		
				80%Ar 20%CO ₂		100 – 275 ipm (2.54 – 6.99 m/min)		
				75%Ar 25%CO ₂		100 – 275 ipm (2.54 – 6.99 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)		
		Stainless 3XX	0.035"	98%Ar 2%CO ₂	98%Ar 2%O ₂	UltimArc®	100 – 350 ipm (2.54 – 8.89 m/min)	
					90%He 7.5%Ar 2.5%CO ₂		100 – 350 ipm (2.54 – 8.89 m/min)	
					98%Ar 2%CO ₂		100 – 300 ipm (2.54 – 7.62 m/min)	
				0.040"	98%Ar 2%O ₂	UltimArc®	100 – 300 ipm (2.54 – 7.62 m/min)	
					90%He 7.5%Ar 2.5%CO ₂		100 – 300 ipm (2.54 – 7.62 m/min)	
					98%Ar 2%CO ₂		90 – 250 ipm (2.29 – 6.35 m/min)	
			0.045"	98%Ar 2%O ₂	UltimArc®	90 – 250 ipm (2.29 – 6.35 m/min)		
				90%He 7.5%Ar 2.5%CO ₂		90 – 250 ipm (2.29 – 6.35 m/min)		
				98%Ar 2%CO ₂		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)
	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)		
				90%Ar 10%CO ₂		100 – 750 ipm (2.54 – 19.05 m/min)		
				85%Ar 15%CO ₂		100 – 750 ipm (2.54 – 19.05 m/min)		
				80%Ar 20%CO ₂		100 – 750 ipm (2.54 – 19.05 m/min)		
			0.040"	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)		
				90%Ar 10%CO ₂		125 – 800 ipm (3.18 – 20.32 m/min)		
				85%Ar 15%CO ₂		125 – 800 ipm (3.18 – 20.32 m/min)		
				80%Ar 20%CO ₂		125 – 800 ipm (3.18 – 20.32 m/min)		
		0.045"	98%Ar 2%CO ₂	UltimArc®	100 – 800 ipm (2.54 – 20.32 m/min)			
			98%Ar 2%O ₂		100 – 800 ipm (2.54 – 20.32 m/min)			
			90%He 7.5%Ar 2.5%CO ₂		100 – 800 ipm (2.54 – 20.32 m/min)			
			98%Ar 2%CO ₂		100 – 800 ipm (2.54 – 20.32 m/min)			
			98%Ar 2%O ₂		100 – 800 ipm (2.54 – 20.32 m/min)			
			90%He 7.5%Ar 2.5%CO ₂		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)		
				90%Ar 10%CO ₂		100 – 535 ipm (2.54 – 13.59 m/min)		
				90%Ar 10%CO ₂		100 – 415 ipm (2.54 – 10.54 m/min)		
				90%Ar 10%CO ₂		100 – 330 ipm (2.54 – 8.38 m/min)		

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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
Stick	Soft (EXX18)	Steel	All	N/A	Arc Force	15 — 405 A
	Crisp (EXX10)	Steel	All	N/A	Arc Force	15 — 405 A
	Stainless 3XX	Stainless 3XX	All	N/A	Arc Force	15 — 405 A

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