

□ HyperFill Key Required

◆ HDT Key Required

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Type	Size	Procedure	Waveform	Gas Type	Mode #	Arc Control	Max. Range (*)		
All	All	GMAW CV	STD CV		5	Pinch	10 — 55	V	
		GMAW Power	Power Mode®		40	Pinch	0.1 — 40	kW	
		GMAW Power	Process HDT® ¹		635	Pinch	0.1 — 40	kW	
Steel	0.8 mm	GMAW CV	CV	CO ₂	93	Pinch	75 — 1200	ipm (1.91 — 30.48 m/min)	
		GMAW Pulse	Pulse	Argon Mix	94		75 — 1200	ipm (1.91 — 30.48 m/min)	
	0.9 mm	GMAW CV	CV	CO ₂	138	Pinch	75 — 1200	ipm (1.91 — 30.48 m/min)	
		GMAW Pulse	Pulse	Argon Mix	95		65 — 1200	ipm (1.65 — 30.48 m/min)	
		GMAW Pulse	Pulse	Argon Mix	410	UltimArc®	100 — 600	ipm (2.54 — 15.24 m/min)	
			Precision Pulse™	Argon Mix	411		100 — 600	ipm (2.54 — 15.24 m/min)	
	1.0 mm	GMAW CV	CV	CO ₂	10	Pinch	50 — 1200	ipm (1.27 — 30.48 m/min)	
		GMAW Pulse	Pulse	Argon Mix	11		50 — 1200	ipm (1.27 — 30.48 m/min)	
		GMAW Pulse	Pulse	Argon Mix	12	UltimArc®	75 — 1200	ipm (1.91 — 30.48 m/min)	
			Precision Pulse™	Argon Mix	412		60 — 1200	ipm (1.52 — 30.48 m/min)	
	1.2 mm	GMAW CV	CV	CO ₂	20	Pinch	50 — 800	ipm (1.27 — 20.32 m/min)	
		GMAW Pulse	Pulse	Argon Mix	21		50 — 800	ipm (1.27 — 20.32 m/min)	
		GMAW Pulse	Pulse	Argon Mix	22	UltimArc®	60 — 800	ipm (1.52 — 20.32 m/min)	
			Precision Pulse™	Argon Mix	413		60 — 800	ipm (1.52 — 20.32 m/min)	
	1.32 mm	GMAW CV	CV	Argon Mix	540	Pinch	50 — 550	ipm (1.27 — 13.97 m/min)	
		GMAW Pulse	Pulse	Argon Mix	541		60 — 1000	ipm (1.52 — 25.4 m/min)	
	1.4 mm	GMAW CV	CV	CO ₂	24	Pinch	50 — 650	ipm (1.27 — 16.51 m/min)	
		GMAW Pulse	Pulse	Argon Mix	25		50 — 550	ipm (1.27 — 13.97 m/min)	
		GMAW Pulse	Pulse	Argon Mix	26	UltimArc®	50 — 600	ipm (1.27 — 15.24 m/min)	
			Precision Pulse™	Argon Mix	27		60 — 1000	ipm (1.52 — 25.4 m/min)	
1.6 mm	GMAW CV	CV	Argon Mix	107	Pinch	50 — 350	ipm (1.27 — 8.89 m/min)		
	GMAW Pulse	Pulse	Argon Mix	108		50 — 400	ipm (1.27 — 10.16 m/min)		
Stainless	0.8 mm	GMAW CV	CV	Argon Mix	61	Pinch	100 — 1200	ipm (2.54 — 30.48 m/min)	
		GMAW Pulse	Pulse	Ar He CO ₂	63		100 — 1200	ipm (2.54 — 30.48 m/min)	
	0.9 mm	GMAW CV	CV	Argon Mix	64	UltimArc®	100 — 1200	ipm (2.54 — 30.48 m/min)	
		GMAW Pulse	Pulse	Argon Mix	66		100 — 1200	ipm (2.54 — 30.48 m/min)	
		GMAW CV	CV	Argon Mix	29	Pinch	75 — 1200	ipm (1.91 — 30.48 m/min)	
			GMAW Pulse	Pulse	Argon Mix		30	60 — 1200	ipm (1.52 — 30.48 m/min)
	1.0 mm	GMAW Pulse	Pulse	Argon Mix	421	UltimArc®	100 — 600	ipm (2.54 — 15.24 m/min)	
			Precision Pulse™	Argon Mix	422		60 — 600	ipm (1.52 — 15.24 m/min)	
		GMAW CV	CV	Argon Mix	31	Pinch	75 — 1200	ipm (1.91 — 30.48 m/min)	
			GMAW Pulse	Pulse	Ar He CO ₂		33	75 — 1000	ipm (1.91 — 25.4 m/min)
	1.2 mm	GMAW Pulse	Pulse	Argon Mix	34	UltimArc®	60 — 1200	ipm (1.52 — 30.48 m/min)	
			Precision Pulse™	Argon Mix	36		60 — 1200	ipm (1.52 — 30.48 m/min)	
		GMAW CV	CV	Argon Mix	41	Pinch	75 — 700	ipm (1.91 — 17.78 m/min)	
			GMAW Pulse	Pulse	Ar He CO ₂		43	75 — 700	ipm (1.91 — 17.78 m/min)
	1.6 mm	GMAW Pulse	Pulse	Argon Mix	44	UltimArc®	50 — 700	ipm (1.27 — 17.78 m/min)	
			Precision Pulse™	Argon Mix	46		50 — 800	ipm (1.27 — 20.32 m/min)	
		GMAW CV	CV	Argon Mix	423	UltimArc®	50 — 400	ipm (1.27 — 10.16 m/min)	
			GMAW Pulse	Pulse	Argon Mix		51	50 — 600	ipm (1.27 — 15.24 m/min)
	Metal Core	1.2 mm	GMAW CV	CV	Argon Mix	56	UltimArc®	50 — 700	ipm (1.27 — 17.78 m/min)
			GMAW Pulse	Pulse	Argon Mix	81		50 — 700	ipm (1.27 — 17.78 m/min)
1.4 mm		GMAW CV	CV	Argon Mix	82	Pinch	50 — 700	ipm (1.27 — 17.78 m/min)	
		GMAW Pulse	Pulse	Argon Mix	83		50 — 1200	ipm (1.27 — 30.48 m/min)	
1.6 mm		GMAW CV	CV	Argon Mix	84	Pinch	50 — 600	ipm (1.27 — 15.24 m/min)	
		GMAW Pulse	Pulse	Argon Mix	88		60 — 1000	ipm (1.52 — 25.4 m/min)	
1.6 mm		GMAW CV	CV	Argon Mix	85	Pinch	50 — 450	ipm (1.27 — 11.43 m/min)	
		GMAW Pulse	Pulse	Argon Mix	86		50 — 450	ipm (1.27 — 11.43 m/min)	

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	Type	Size	Procedure	Waveform	Gas Type	Mode #	Arc Control	Max. Range (*)	
GMAW	Aluminum (AlSi)	1.0 mm	GMAW CV	CV	Argon	148	Pinch	125 — 800 ipm (3.18 — 20.32 m/min)	
			GMAW Pulse	Pulse	Argon	149	UltimArc®	125 — 800 ipm (3.18 — 20.32 m/min)	
				CC Pulse	Argon	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)	
		1.2 mm	GMAW CV	CV	Argon	71	Pinch	125 — 700 ipm (3.18 — 17.78 m/min)	
			GMAW Pulse	Pulse	Argon	72	UltimArc®	85 — 600 ipm (2.16 — 15.24 m/min)	
				CC Pulse	Argon	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)	
		1.6 mm	GMAW CV	CV	Argon	73	Pinch	75 — 375 ipm (1.91 — 9.53 m/min)	
	GMAW Pulse		Pulse	Argon	74	UltimArc®	75 — 350 ipm (1.91 — 8.89 m/min)		
			CC Pulse	Argon	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)		
	Aluminum (AlMg)	1.0 mm	GMAW CV	CV	Argon	151	Pinch	175 — 750 ipm (4.45 — 19.05 m/min)	
			GMAW Pulse	Pulse	Argon	152	UltimArc®	125 — 700 ipm (3.18 — 17.78 m/min)	
				CC Pulse	Argon	153		125 — 700 ipm (3.18 — 17.78 m/min)	
			GMAW Pulse on Pulse	Pulse on Pulse	Argon	101	Frequency	140 — 800 ipm (3.56 — 20.32 m/min)	
		1.2 mm	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)	
			GMAW Pulse on Pulse	Pulse on Pulse	Argon	102	Frequency	100 — 600 ipm (2.54 — 15.24 m/min)	
		1.6 mm	GMAW CV	CV	Argon	77	Pinch	125 — 500 ipm (3.18 — 12.7 m/min)	
	GMAW Pulse		Pulse	Argon	78	UltimArc®	100 — 500 ipm (2.54 — 12.7 m/min)		
			CC Pulse	Argon	80		100 — 450 ipm (2.54 — 11.43 m/min)		
		GMAW Pulse on Pulse	Pulse on Pulse	Argon	103	Frequency	75 — 350 ipm (1.91 — 8.89 m/min)		
	SiBr	1.0mm	GMAW Pulse	Pulse	Argon	192	UltimArc®	80 — 1000 ipm (2.03 — 25.4 m/min)	
		1.2mm	GMAW Pulse	Pulse	Argon	191	UltimArc®	50 — 600 ipm (1.27 — 15.24 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)		
FCAW	Flux Core	All	FCAW-S	Self Shield CV	NA	6	Pinch	10 — 45 V	
			FCAW-G	Gas Shield CV		7	Pinch	10 — 45 V	
	Cored Wire	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	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	FCAW-G	CV	CO ₂	189	Pinch	125 — 400 ipm (3.18 — 10.16 m/min)			
			Argon Mix	190		125 — 400 ipm (3.18 — 10.16 m/min)			
SMAW	NA	NA	SMAW Soft		NA	1	Arc Force, Hot Start	15 — 900 A	
			DCEP SMAW	SMAW Crisp		NA	2	Arc Force, Hot Start	15 — 900 A
			SMAW Pipe		NA	4	Arc Force	50 — 250 A	
GTAW	NA	NA	DCEN GTAW	Touch Start TIG	Ar / He	3	Hot Start	5 — 900 A	
				Touch Start TIG Pulse	Ar / He	8	Frequency, Background, Hot Start	5 — 800 A	
CAG	NA	NA	CAG	Arc Gouge	Compressed Air	9		60 — 900 A	

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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 ipm	(3.81 — 20.32 m/min)
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 — 700 ipm	(2.54 — 17.78 m/min)	
			Sync Pulse Trail	Argon Mix	405	UltimArc®	100 — 700 ipm	(2.54 — 17.78 m/min)	
			HotWire Pulse Trail	Argon Mix	462	75 — 800 ipm	(1.91 — 20.32 m/min)		
1.4 mm		GMAW Tandem (Δ)	Sync Pulse Lead	Argon Mix	406	UltimArc®, Phase Angle	100 — 600 ipm	(2.54 — 15.24 m/min)	
			Sync Pulse Trail	Argon Mix	407	UltimArc®	100 — 600 ipm	(2.54 — 15.24 m/min)	
			HotWire Pulse Trail	Argon Mix	463	50 — 800 ipm	(1.27 — 20.32 m/min)		
1.6 mm		GMAW Tandem (Δ)	Sync Pulse Lead	Argon Mix	408	UltimArc®, Phase Angle	100 — 500 ipm	(2.54 — 12.7 m/min)	
			Sync Pulse Trail	Argon Mix	409	UltimArc®	100 — 500 ipm	(2.54 — 12.7 m/min)	
			HotWire Pulse Trail	Argon Mix	464	50 — 500 ipm	(1.27 — 12.7 m/min)		

GMAW-HyperFill ¹	Type	Size	Procedure	Waveform	Gas Type	Mode #	Arc Control	Max. Range (*)	
	Steel	0.9mm	GMAW	HyperFill	Argon Mix	601	100 — 800 ipm	(2.54 — 20.32 m/min)	
		1.0mm	GMAW	HyperFill	Argon Mix	602	100 — 700 ipm	(2.54 — 17.78 m/min)	
		1.2mm	GMAW	HyperFill	Argon Mix	603	100 — 465 ipm	(2.54 — 11.81 m/min)	
	Metal Core	1.2mm	GMAW	HyperFill	Argon Mix	608	100 - 515 ipm	(2.54 - 13.08 m/min)	

¹HyperFill® & Process HDT™ Waveform Activation Capability with Power Wave® and PIPEFAB™ Systems

Your purchase of a Lincoln Power Wave or PIPEFAB Welding System comes with (i) a license to use Lincoln Electric standard Power Wave / PIPEFAB waveforms, and (ii) HyperFill & Process HDT waveform capability, which requires a separate license. Without the separate license, the HyperFill and Process HDT waveforms are not available for use on these machines, and only the standard Power Wave / PIPEFAB waveforms are usable.