

Weld Set Reference: Z204740
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"	Pinch	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)
			0.040"	Pinch	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)	
	0.045"		Pinch	98%Ar 2%CO ₂	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"	Pinch	90%Ar 10%CO ₂	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"	90%Ar 10%CO ₂	UltimArc®	75 — 815 ipm (1.91 — 20.7 m/min)
			0.040"	90%Ar 10%CO ₂	UltimArc®	75 — 800 ipm (1.91 — 20.32 m/min)
			0.045"	90%Ar 10%CO ₂	UltimArc®	100 — 800 ipm (2.54 — 20.32 m/min)

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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)
			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)
			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)
		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)
				90%He 7.5%Ar 2.5%CO ₂		100 – 350 ipm (2.54 – 8.89 m/min)
			0.040"	98%Ar 2%CO ₂	UltimArc®	100 – 300 ipm (2.54 – 7.62 m/min)
				98%Ar 2%O ₂		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)
	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)		
		90%He 7.5%Ar 2.5%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)
			0.040"	90%Ar 10%CO ₂	UltimArc®	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)
		0.045"	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)
				90%He 7.5%Ar 2.5%CO ₂		125 – 800 ipm (3.18 – 20.32 m/min)
0.040"			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)	
0.045"		98%Ar 2%CO ₂	UltimArc®	100 – 750 ipm (2.54 – 19.05 m/min)		
		98%Ar 2%O ₂		100 – 750 ipm (2.54 – 19.05 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)		
HyperFill ¹	Steel	0.035"		100 – 535 ipm (2.54 – 13.59 m/min)		
		0.040"		100 – 415 ipm (2.54 – 10.54 m/min)		
	Metal Core	0.045"		100 – 415 ipm (2.54 – 10.54 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

¹**HyperFill® & 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.