

Weld Set Reference: Z213712
Power Wave® 300C (Metric units)



(§) Requires Advanced machine

| Process type | Wire type | Wire size | Waveform | Gas Type | Workpoint Limits | Wave Control 1 | Wave Control 2 | Wave Control 3 |
|----------------------|--------------------------------------|----------------------|--------------------------------------|--------------------------------------|---------------------|---------------------|----------------|----------------|
| GMAW | 3XX Stainless | 1.0 mm | CV | 98% Ar 2% CO ₂ | 2.54 to 17.53 m/min | Pinch -10.0 to 10.0 | N/A | N/A |
| | | | | 98% Ar 2% O ₂ | | | | |
| | | | | Ar-Mix | | | | |
| | | | Precision Pulse™ | 62.2% Ar 35% He 2.8% CO ₂ | 1.52 to 15.24 m/min | | | |
| | | | | 98% Ar 2% CO ₂ | | | | |
| | | | | 98% Ar 2% O ₂ | | | | |
| | | | | Ar-Mix | | | | |
| | | | | Tri-Mix (Ar) | | | | |
| | | | | Tri-Mix (Ar) | | | | |
| | | | Smart Pulse™ (§) | 62.2% Ar 35% He 2.8% CO ₂ | 2.54 to 19.30 m/min | | | |
| | | | | 98% Ar 2% CO ₂ | | | | |
| | | | | 98% Ar 2% O ₂ | | | | |
| | | Ar-Mix | | | | | | |
| | | Tri-Mix (Ar) | | | | | | |
| | | Tri-Mix (Ar) | | | | | | |
| | | STT® (Root Pass) (§) | 62.2% Ar 35% He 2.8% CO ₂ | 2.54 to 7.62 m/min | | | | |
| | | | 98% Ar 2% CO ₂ | | | | | |
| | | | 98% Ar 2% O ₂ | | | | | |
| | | | Ar-Mix | | | | | |
| | | | Tri-Mix (Ar) | | | | | |
| | | | Tri-Mix (Ar) | | | | | |
| | | 1.2 mm | CV | 98% Ar 2% CO ₂ | 1.91 to 14.61 m/min | Pinch -10.0 to 10.0 | | |
| | | | | 98% Ar 2% O ₂ | | | | |
| | | | | Ar-Mix | | | | |
| Precision Pulse™ | 62.2% Ar 35% He 2.8% CO ₂ | | 1.27 to 11.18 m/min | | | | | |
| | 98% Ar 2% CO ₂ | | | | | | | |
| | 98% Ar 2% O ₂ | | | | | | | |
| | Ar-Mix | | | | | | | |
| | Tri-Mix (Ar) | | | | | | | |
| | Tri-Mix (Ar) | | | | | | | |
| Smart Pulse™ (§) | 62.2% Ar 35% He 2.8% CO ₂ | | 2.54 to 13.46 m/min | | | | | |
| | 98% Ar 2% CO ₂ | | | | | | | |
| | 98% Ar 2% O ₂ | | | | | | | |
| | Ar-Mix | | | | | | | |
| | Tri-Mix (Ar) | | | | | | | |
| | Tri-Mix (Ar) | | | | | | | |
| STT® (Root Pass) (§) | 62.2% Ar 35% He 2.8% CO ₂ | 2.29 to 5.72 m/min | | | | | | |
| | 98% Ar 2% CO ₂ | 2.29 to 6.35 m/min | | | | | | |
| | 98% Ar 2% O ₂ | | | | | | | |
| | Ar-Mix | | | | | | | |
| | Tri-Mix (Ar) | | 2.29 to 5.72 m/min | | | | | |

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|----------------------------|---------------------|----------------|----------------------------|----------------------------|-------------------------|---------------------|----------------|----------------|
| GMAW | Al 4XXX | 1.0 mm | CV | 100% Ar | 3.18 to 20.32 m/min | Pinch -10.0 to 10.0 | N/A | N/A |
| | | 1.2 mm | | | 3.18 to 14.99 m/min | | | |
| | | 1.6 mm | | | 1.91 to 8.64 m/min | | | |
| | Al 5XXX | 1.0 mm | CV | 100% Ar | 4.45 to 19.05 m/min | Pinch -10.0 to 10.0 | N/A | N/A |
| | | 1.2 mm | | | 3.18 to 19.05 m/min | | | |
| | | 1.6 mm | | | 3.18 to 11.94 m/min | | | |
| | Manual CV | None | Manual CV | Any Shielding Gas | 10.0 to 45.0 V | Pinch -10.0 to 10.0 | N/A | N/A |
| | Metal Core | 1.2 mm | CV | 75% Ar 25% CO ₂ | 2.54 to 13.34 m/min | Pinch -10.0 to 10.0 | N/A | N/A |
| | | | | 80% Ar 20% CO ₂ | | | | |
| | | | | 82% Ar 18% CO ₂ | | | | |
| | | | | 85% Ar 15% CO ₂ | | | | |
| | | | | 90% Ar 10% CO ₂ | | | | |
| | | | | 92% Ar 8% CO ₂ | | | | |
| | | | Ar-Mix | 2.54 to 12.45 m/min | | | | |
| | | | 80% Ar 20% CO ₂ | | | | | |
| | | | 82% Ar 18% CO ₂ | | | | | |
| | | | 85% Ar 15% CO ₂ | | | | | |
| | | | 90% Ar 10% CO ₂ | | | | | |
| | | | 92% Ar 8% CO ₂ | | | | | |
| | | | Ar-Mix | 1.91 to 12.45 m/min | | | | |
| | | | 80% Ar 20% CO ₂ | | | | | |
| | | | 82% Ar 18% CO ₂ | | | | | |
| | | | 85% Ar 15% CO ₂ | | | | | |
| 90% Ar 10% CO ₂ | | | | | | | | |
| 92% Ar 8% CO ₂ | | | | | | | | |
| Ar-Mix | 2.54 to 12.95 m/min | | | | | | | |
| 80% Ar 20% CO ₂ | | | | | | | | |
| 82% Ar 18% CO ₂ | | | | | | | | |
| 85% Ar 15% CO ₂ | | | | | | | | |
| 90% Ar 10% CO ₂ | | | | | | | | |
| 92% Ar 8% CO ₂ | | | | | | | | |
| Ar-Mix | 2.29 to 5.72 m/min | | | | | | | |
| 75% Ar 25% CO ₂ | | | | | | | | |
| 80% Ar 20% CO ₂ | | | | | | | | |
| 82% Ar 18% CO ₂ | | | | | | | | |
| 85% Ar 15% CO ₂ | | | | | | | | |
| Ar-Mix | | | | | | | | |
| Si Bronze | 1.0 mm | STT® Braze (§) | 100% Ar | 3.05 to 8.89 m/min | Ultimarc® -10.0 to 10.0 | N/A | N/A | |
| | 1.2 mm | | | 2.29 to 7.62 m/min | | | | |
| Steel | 0.8 mm | CV | 100% CO ₂ | 3.18 to 20.32 m/min | Pinch -10.0 to 10.0 | N/A | N/A | |
| | | | 75% Ar 25% CO ₂ | | | | | |
| | | | 80% Ar 20% CO ₂ | | | | | |
| | | | 82% Ar 18% CO ₂ | | | | | |
| | | | 85% Ar 15% CO ₂ | | | | | |
| | | | 90% Ar 10% CO ₂ | | | | | |
| | | | 92% Ar 8% CO ₂ | | | | | |
| | | | Ar-Mix | | | | | |

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|---------------------------|----------------------------|----------------------------|----------------------------|----------------------------|---------------------|-------------------------|----------------|----------------|
| GMAW | Steel | 0.8 mm | Precision Pulse™ | 80% Ar 20% CO ₂ | 3.18 to 15.24 m/min | Ultimarc® -10.0 to 10.0 | N/A | N/A |
| | | | | 82% Ar 18% CO ₂ | | | | |
| | | | | 85% Ar 15% CO ₂ | | | | |
| | | | | 90% Ar 10% CO ₂ | | | | |
| | | | | 92% Ar 8% CO ₂ | | | | |
| | | | | Ar-Mix | | | | |
| | | | Smart Pulse™ (§) | 80% Ar 20% CO ₂ | 3.18 to 20.32 m/min | | | |
| | | | | 82% Ar 18% CO ₂ | | | | |
| | | | | 85% Ar 15% CO ₂ | | | | |
| | | 90% Ar 10% CO ₂ | | | | | | |
| | | 92% Ar 8% CO ₂ | | | | | | |
| | | Ar-Mix | | | | | | |
| | | STT® (Root Pass) (§) | 75% Ar 25% CO ₂ | 3.18 to 10.16 m/min | | | | |
| | | | 80% Ar 20% CO ₂ | | | | | |
| | | | 82% Ar 18% CO ₂ | | | | | |
| | | | 85% Ar 15% CO ₂ | | | | | |
| | | | 90% Ar 10% CO ₂ | | | | | |
| | | | 92% Ar 8% CO ₂ | | | | | |
| | 1.0 mm | CV | 100% CO ₂ | 2.54 to 18.42 m/min | Pinch -10.0 to 10.0 | | | |
| | | | 75% Ar 25% CO ₂ | 2.54 to 15.11 m/min | | | | |
| | | | 80% Ar 20% CO ₂ | 2.54 to 15.62 m/min | | | | |
| | | | 82% Ar 18% CO ₂ | | | | | |
| | | | 85% Ar 15% CO ₂ | | | | | |
| | | | 90% Ar 10% CO ₂ | | | | | |
| 92% Ar 8% CO ₂ | | | | | | | | |
| Ar-Mix | | | | | | | | |
| Low Fume Pulse™ (§) | | Ar-Mix | 1.91 to 20.70 m/min | Ultimarc® -10.0 to 10.0 | | | | |
| Precision Pulse™ | | 80% Ar 20% CO ₂ | 1.91 to 14.61 m/min | | | | | |
| | | 82% Ar 18% CO ₂ | | | | | | |
| | | 85% Ar 15% CO ₂ | | | | | | |
| | | 90% Ar 10% CO ₂ | | | | | | |
| | | 92% Ar 8% CO ₂ | | | | | | |
| Ar-Mix | | | | | | | | |
| Smart Pulse™ (§) | 80% Ar 20% CO ₂ | 2.54 to 18.80 m/min | | | | | | |
| | 82% Ar 18% CO ₂ | | | | | | | |
| | 85% Ar 15% CO ₂ | | | | | | | |
| | 90% Ar 10% CO ₂ | | | | | | | |
| | 92% Ar 8% CO ₂ | | | | | | | |
| Ar-Mix | | | | | | | | |

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|----------------------|----------------------------|--------------------|----------------------------|----------------------------|-------------------------|-------------------------|----------------|----------------|
| GMAW | Steel | 1.0 mm | STT® (Root Pass) (§) | 75% Ar 25% CO ₂ | 2.54 to 6.99 m/min | Ultimarc® -10.0 to 10.0 | | |
| | | | | 80% Ar 20% CO ₂ | | | | |
| | | | | 82% Ar 18% CO ₂ | | | | |
| | | | | 85% Ar 15% CO ₂ | | | | |
| | | | | 90% Ar 10% CO ₂ | | | | |
| | | | | 92% Ar 8% CO ₂ | | | | |
| | | | | Ar-Mix | | | | |
| | | 1.2 mm | CV | 100% CO ₂ | 2.54 to 11.56 m/min | Pinch -10.0 to 10.0 | | |
| | | | | 75% Ar 25% CO ₂ | 2.54 to 12.83 m/min | | | |
| | | | | 80% Ar 20% CO ₂ | 2.54 to 10.92 m/min | | | |
| | | | | 82% Ar 18% CO ₂ | | | | |
| | | | | 85% Ar 15% CO ₂ | | | | |
| | | | | 90% Ar 10% CO ₂ | | | | |
| | | | | 92% Ar 8% CO ₂ | | | | |
| | | | Ar-Mix | | | | | |
| | | | Low Fume Pulse™ (§) | Ar-Mix | 1.52 to 17.78 m/min | N/A | N/A | |
| | | | Precision Pulse™ | 80% Ar 20% CO ₂ | 1.91 to 14.10 m/min | | | |
| | | | | 82% Ar 18% CO ₂ | | | | |
| | | | | 85% Ar 15% CO ₂ | | | | |
| | | | | 90% Ar 10% CO ₂ | | | | |
| | | | | 92% Ar 8% CO ₂ | | | | |
| | | Ar-Mix | | | | | | |
| | | Smart Pulse™ (§) | 80% Ar 20% CO ₂ | 2.54 to 12.57 m/min | Ultimarc® -10.0 to 10.0 | | | |
| | | | 82% Ar 18% CO ₂ | | | | | |
| | | | 85% Ar 15% CO ₂ | | | | | |
| | | | 90% Ar 10% CO ₂ | | | | | |
| | | | 92% Ar 8% CO ₂ | | | | | |
| | | Ar-Mix | | | | | | |
| STT® (Root Pass) (§) | 75% Ar 25% CO ₂ | 2.29 to 5.72 m/min | | | | | | |
| | 80% Ar 20% CO ₂ | | | | | | | |
| | 82% Ar 18% CO ₂ | | | | | | | |
| | 85% Ar 15% CO ₂ | | | | | | | |
| | 90% Ar 10% CO ₂ | | | | | | | |
| | 92% Ar 8% CO ₂ | | | | | | | |
| Ar-Mix | | | | | | | | |

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| Process type | Wire type | Wire size | Waveform | Gas Type | Workpoint Limits | Wave Control 1 | Wave Control 2 | Wave Control 3 |
|--------------|---------------|----------------------------|----------------------------|----------------------------|---------------------|---------------------------|------------------------|---------------------------|
| FCAW_S | Self-Shielded | None | Self-Shielded | No gas | 10.0 to 45.0 V | Pinch -10.0 to 10.0 | N/A | N/A |
| FCAW-G | Manual | None | Gas-Shielded | Any Shielding Gas | 10.0 to 45.0 V | Pinch -10.0 to 10.0 | N/A | N/A |
| | Steel | 1.2 mm | Gas-Shielded | 100% CO ₂ | 4.45 to 15.24 m/min | Pinch -10.0 to 10.0 | N/A | N/A |
| | | | | 75% Ar 25% CO ₂ | | | | |
| | | | | 80% Ar 20% CO ₂ | | | | |
| | | Ar-Mix | | | | | | |
| | | 100% CO ₂ | | | | | | |
| | | 75% Ar 25% CO ₂ | | | | | | |
| | 1.4 mm | Gas-Shielded | 80% Ar 20% CO ₂ | 3.81 to 12.70 m/min | | | | |
| | | | Ar-Mix | | | | | |
| | | | 100% CO ₂ | | | | | |
| | 1.6 mm | Gas-Shielded | 75% Ar 25% CO ₂ | 3.18 to 9.91 m/min | | | | |
| | | | 80% Ar 20% CO ₂ | | | | | |
| Ar-Mix | | | | | | | | |
| GTAW | GTAW | N/A | HF TIG (§) | Helium, Argon | 5 to 350 A | N/A | N/A | N/A |
| | | | Touch Start | | | | | |
| | | | HF TIG Pulse (§) | | | Frequency 0.3 to 35.6 Hz | Background 20 to 100 % | N/A |
| | | | Touch Start TIG Pulse | | 10 to 350 A | AC Frequency 50 to 200 Hz | AC Balance 35 to 85 % | DC Offset -30 to 30 % |
| | | | HF AC TIG (§) | | | | | |
| | | | Touch Start AC TIG (§) | | | | | |
| SMAW | SMAW | N/A | AC SMAW (§) | No gas | 15 to 350 A | Arc Force -10.0 to 10.0 | Hot Start 0.0 to 10.0 | AC Frequency 20 to 100 Hz |
| | | | Crisp (EXX10) | | | | | N/A |
| | | | DCEN SMAW (§) | | | | | |
| | | | Soft (EXX18) | | | | | |
| | | | Stainless (E3XX) | | | | | |
| CAG | Carbon Arc | N/A | Arc Gouge | No gas | 60 to 350 A | N/A | N/A | N/A |