

Weld Set Reference: Z223701
PipeFab® (Imperial units)



Process Type	Waveform	Wire Type	Wire Size	Gas Type	Workpoint Limits	Wave Control 1	Wave Control 2	
GMAW	Manual CV	Any	N/A	Unspecified	10.0 to 45.0 V	Pinch -10.0 to 10.0	N/A	
	CV	3XX Stainless	.035 in	90% He 7.5% Ar 2.5% CO ₂	100 to 800 in/min	Pinch -10.0 to 10.0	N/A	
				98% Ar 2% CO ₂				
				98% Ar 2% O ₂				
				Ar-Mix				
			Tri-Mix (He)					
			.040 in	90% He 7.5% Ar 2.5% CO ₂				
				98% Ar 2% CO ₂				
				98% Ar 2% O ₂				
				Ar-Mix				
			Tri-Mix (He)					
			.045 in	90% He 7.5% Ar 2.5% CO ₂				75 to 645 in/min
				98% Ar 2% CO ₂				75 to 745 in/min
		98% Ar 2% O ₂		75 to 745 in/min				
		Ar-Mix		75 to 645 in/min				
		Tri-Mix (He)	75 to 645 in/min					
		MCW Steel	.045 in	75% Ar 25% CO ₂	100 to 650 in/min			
				80% Ar 20% CO ₂	100 to 610 in/min			
				85% Ar 15% CO ₂	100 to 610 in/min			
				90% Ar 10% CO ₂	100 to 610 in/min			
		Ar-Mix	100 to 610 in/min					
		Steel	.035 in	100% CO ₂	75 to 800 in/min			
				75% Ar 25% CO ₂	100 to 815 in/min			
				80% Ar 20% CO ₂				
				85% Ar 15% CO ₂				
	90% Ar 10% CO ₂							
	Ar-Mix							
	.040 in			100% CO ₂		100 to 800 in/min		
				75% Ar 25% CO ₂		100 to 760 in/min		
				80% Ar 20% CO ₂		100 to 800 in/min		
				85% Ar 15% CO ₂				
	90% Ar 10% CO ₂							
	Ar-Mix							
	.045 in		100% CO ₂	50 to 800 in/min				
			75% Ar 25% CO ₂	50 to 780 in/min				
			80% Ar 20% CO ₂	50 to 615 in/min				
			85% Ar 15% CO ₂					
	90% Ar 10% CO ₂							
	Ar-Mix							
	HyperFill®		MCW Steel	.045 in	90% Ar 10% CO ₂	150 to 330 in/min	UltimArc® -10.0 to 10.0	N/A
					Ar-Mix			
			Steel	.035 in	90% Ar 10% CO ₂	150 to 585 in/min		
					Ar-Mix	UltimArc® -10.0 to 10.0		
				.040 in	90% Ar 10% CO ₂		100 to 410 in/min	
					Ar-Mix			
	Low Fume Pulse™	MCW Steel	.052 in	90% Ar 10% CO ₂	60 to 650 in/min		UltimArc® -10.0 to 10.0	N/A
				Ar-Mix				
		Steel	.035 in	90% Ar 10% CO ₂	75 to 815 in/min			
Ar-Mix				UltimArc® -10.0 to 10.0				
.040 in					90% Ar 10% CO ₂	75 to 800 in/min		
			Ar-Mix					
.045 in			90% Ar 10% CO ₂		100 to 800 in/min			
			Ar-Mix					

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GMAW	Smart Pulse®	3XX Stainless	.035 in	90% He 7.5% Ar 2.5% CO ₂	125 to 800 in/min	UltimArc® -10.0 to 10.0	N/A	
				98% Ar 2% CO ₂				
				98% Ar 2% O ₂				
				Ar-Mix				
			Tri-Mix (He)					
			.040 in	90% He 7.5% Ar 2.5% CO ₂				
				98% Ar 2% CO ₂				
				98% Ar 2% O ₂				
				Ar-Mix				
			Tri-Mix (He)					
			.045 in	90% He 7.5% Ar 2.5% CO ₂				100 to 765 in/min
				98% Ar 2% CO ₂				
		98% Ar 2% O ₂						
		Ar-Mix						
		Tri-Mix (He)						
		MCW Steel	.045 in	80% Ar 20% CO ₂	100 to 650 in/min			
	85% Ar 15% CO ₂							
	90% Ar 10% CO ₂							
	Ar-Mix							
	Steel	.035 in	80% Ar 20% CO ₂	100 to 800 in/min				
			85% Ar 15% CO ₂					
			90% Ar 10% CO ₂					
			Ar-Mix					
			80% Ar 20% CO ₂					
			85% Ar 15% CO ₂					
		.040 in	90% Ar 10% CO ₂					
			Ar-Mix					
			80% Ar 20% CO ₂		100 to 700 in/min			
85% Ar 15% CO ₂								
90% Ar 10% CO ₂								
Ar-Mix								
STT® (Root Pass)	3XX Stainless	.035 in	90% He 7.5% Ar 2.5% CO ₂	100 to 350 in/min	UltimArc® -10.0 to 10.0	N/A		
			98% Ar 2% CO ₂					
			98% Ar 2% O ₂					
			Ar-Mix					
			Tri-Mix (He)					
			.040 in				90% He 7.5% Ar 2.5% CO ₂	100 to 300 in/min
		98% Ar 2% CO ₂						
		98% Ar 2% O ₂						
		Ar-Mix						
		Tri-Mix (He)						
		.045 in	90% He 7.5% Ar 2.5% CO ₂	90 to 250 in/min				
			98% Ar 2% CO ₂					
98% Ar 2% O ₂								
Ar-Mix								
Tri-Mix (He)								
MCW Steel	.045 in	75% Ar 25% CO ₂	90 to 225 in/min					
		80% Ar 20% CO ₂						
		85% Ar 15% CO ₂						
		Ar-Mix						
Steel	.035 in	100% CO ₂	125 to 250 in/min	UltimArc® -10.0 to 10.0	N/A			
		75% Ar 25% CO ₂	100 to 350 in/min					
		80% Ar 20% CO ₂						
		85% Ar 15% CO ₂						
		90% Ar 10% CO ₂						
		Ar-Mix						

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GMAW	STT® (Root Pass)	Steel	.040 in	100% CO ₂	100 to 250 in/min	UltimArc® -10.0 to 10.0	N/A
				75% Ar 25% CO ₂	100 to 275 in/min		
				80% Ar 20% CO ₂			
				85% Ar 15% CO ₂			
				90% Ar 10% CO ₂			
			Ar-Mix	100 to 200 in/min			
			100% CO ₂				
			75% Ar 25% CO ₂				
			80% Ar 20% CO ₂				
			85% Ar 15% CO ₂				
90% Ar 10% CO ₂	90 to 250 in/min						
Ar-Mix							
100% CO ₂							
75% Ar 25% CO ₂							
80% Ar 20% CO ₂							
85% Ar 15% CO ₂	125 to 400 in/min						
90% Ar 10% CO ₂							
Ar-Mix							
100% CO ₂							
75% Ar 25% CO ₂							
80% Ar 20% CO ₂	150 to 500 in/min						
Ar-Mix							
100% CO ₂							
75% Ar 25% CO ₂							
Ar-Mix							
100% CO ₂	125 to 400 in/min						
75% Ar 25% CO ₂							
Ar-Mix							
100% CO ₂							
75% Ar 25% CO ₂							
Ar-Mix	100 to 360 in/min						
75% Ar 25% CO ₂							
80% Ar 20% CO ₂							
Ar-Mix							
Ar-Mix							
Gouge	Arc Gouge	Carbon Arc	N/A	No gas	60 to 405 A	N/A	N/A
GTAW	HF TIG	N/A	N/A	Helium, Argon	5 to 405 A	N/A	N/A
	Touch Start TIG					Frequency 0.3 to 35.6 Hz	Background 20 to 100 %
	HF TIG Pulse						
	Touch Start TIG Pulse						
SMAW	Crisp (EXX10)	Stick	N/A	No gas	15 to 405 A	Arc Force -10.0 to 10.0	Hot Start 0.0 to 10.0
	Soft (EXX18)						
	Stainless (E3XX)						