

Weld Set Reference: Z223722
PipeFab® (Imperial Units)



Process Type	Waveform	Wire Type	Wire Size	Gas Type	Workpoint Limits	Wave Control 1	Wave Control 2			
GMAW	Manual CV	Other	None	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)							
			90% He 7.5% Ar 2.5% CO ₂							
			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				75 to 645 in/min		
				98% Ar 2% CO ₂						
		98% Ar 2% O ₂								
		Ar-Mix								
		.045 in	90% He 7.5% Ar 2.5% CO ₂	75 to 645 in/min						
			98% Ar 2% CO ₂							
			98% Ar 2% O ₂							
			Ar-Mix							
		MCW Steel	.045 in	75% Ar 25% CO ₂	100 to 650 in/min	Pinch -10.0 to 10.0	N/A			
				80% Ar 20% CO ₂						
				85% Ar 15% CO ₂						
				90% Ar 10% CO ₂						
			Ar-Mix							
			Steel	.035 in				100% CO ₂	75 to 800 in/min	Pinch -10.0 to 10.0
	75% Ar 25% CO ₂									
	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								
		80% Ar 20% CO ₂								
		85% Ar 15% CO ₂								
	.045 in	90% Ar 10% CO ₂		100 to 800 in/min						
		Ar-Mix								
		100% CO ₂	50 to 800 in/min							
		75% Ar 25% CO ₂								
	80% Ar 20% CO ₂									
	85% Ar 15% CO ₂									
	90% Ar 10% CO ₂	50 to 615 in/min								
	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	UltimArc® -10.0 to 10.0	N/A			
				Ar-Mix						
			.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	UltimArc® -10.0 to 10.0	N/A				
			Ar-Mix							
		.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			
				98% Ar 2% CO ₂			
		98% Ar 2% O ₂					
		Ar-Mix					
		Tri-Mix (He)					
	MCW Steel	.045 in	90% Ar 10% CO ₂	100 to 650 in/min	UltimArc® -10.0 to 10.0	N/A	
			Ar-Mix				
			80% Ar 20% CO ₂				
	Steel	.035 in	85% Ar 15% CO ₂	100 to 800 in/min	UltimArc® -10.0 to 10.0	N/A	
			80% Ar 20% CO ₂				
			90% Ar 10% CO ₂				
			Ar-Mix				
			.040 in				80% Ar 20% CO ₂
							85% Ar 15% CO ₂
		90% Ar 10% CO ₂					
		.045 in	Ar-Mix				
			80% Ar 20% CO ₂				
			85% Ar 15% CO ₂				
		90% Ar 10% CO ₂					
		STT® (Root Pass)	3XX Stainless				.035 in
98% Ar 2% CO ₂							
98% Ar 2% O ₂							
Ar/CO ₂ /H							
Ar/CO ₂ /N							
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)						
	Tri-Mix (He)						
.045 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)						
	Tri-Mix (He)						
MCW Steel	.045 in	Ar-Mix	90 to 225 in/min	UltimArc® -10.0 to 10.0	N/A		
		75% Ar 25% CO ₂					
		80% Ar 20% CO ₂					
Steel	.035 in	85% Ar 15% CO ₂	125 to 250 in/min	UltimArc® -10.0 to 10.0	N/A		
		100% CO ₂					
		75% Ar 25% CO ₂					
		80% Ar 20% CO ₂					
		85% Ar 15% CO ₂					
		90% Ar 10% CO ₂					
Ar-Mix							

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Process Type	Waveform	Wire Type	Wire Size	Gas Type	Workpoint Limits	Wave Control 1	Wave Control 2							
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										
			.045 in	100% CO ₂				100 to 200 in/min						
				75% Ar 25% CO ₂	90 to 250 in/min									
				80% Ar 20% CO ₂										
				85% Ar 15% CO ₂										
				90% Ar 10% CO ₂										
				Ar-Mix										
				FCAW-G				Manual CV	Other	None	Unspecified	10.0 to 45.0 V	Pinch -10.0 to 10.0	N/A
								Gas-Shielded	3XX Stainless	.045 in	100% CO ₂	175 to 600 in/min	Pinch -10.0 to 10.0	N/A
75% Ar 25% CO ₂														
80% Ar 20% CO ₂														
Ar-Mix														
1/16 in	100% CO ₂	125 to 400 in/min												
	75% Ar 25% CO ₂													
	80% Ar 20% CO ₂													
Steel	.045 in		100% CO ₂		175 to 600 in/min									
			75% Ar 25% CO ₂											
			Ar-Mix											
	.052 in	100% CO ₂	150 to 500 in/min											
		75% Ar 25% CO ₂												
		Ar-Mix												
1/16 in	100% CO ₂	125 to 400 in/min												
	75% Ar 25% CO ₂													
	Ar-Mix													
HyperFill®	Steel		.045 in	100% CO ₂	100 to 335 in/min	N/A	N/A							
				75% Ar 25% CO ₂	100 to 360 in/min	Pinch -10.0 to 10.0	N/A							
				80% Ar 20% CO ₂										
		Ar-Mix												
Gouge	Arc Gouge	Carbon Arc	N/A	Unspecified				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													
	HF TIG Pulse					Frequency 0.3 to 35.6 Hz	Background 20 to 100 %							
	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)													