

**Weld Set Reference: Z223723**  
**PipeFab® (Metric 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	0.9 mm	98% Ar 2% CO <sub>2</sub>	2.54 to 20.32 m/min	Pinch -10.0 to 10.0	N/A	
				98% Ar 2% O <sub>2</sub>				
				Ar-Mix				
			1.0 mm	98% Ar 2% CO <sub>2</sub>				
				98% Ar 2% O <sub>2</sub>				
				Ar-Mix				
			1.2 mm	98% Ar 2% CO <sub>2</sub>				1.91 to 18.92 m/min
				98% Ar 2% O <sub>2</sub>				
				Ar-Mix				
		MCW Steel	1.2 mm	75% Ar 25% CO <sub>2</sub>	2.54 to 16.51 m/min	N/A	N/A	
				80% Ar 20% CO <sub>2</sub>				
				82% Ar 18% CO <sub>2</sub>				
				85% Ar 15% CO <sub>2</sub>				
				90% Ar 10% CO <sub>2</sub>				
				92% Ar 8% CO <sub>2</sub>				
				Ar-Mix				
				100% CO <sub>2</sub>				
				Steel				0.9 mm
		80% Ar 20% CO <sub>2</sub>						
		82% Ar 18% CO <sub>2</sub>						
		85% Ar 15% CO <sub>2</sub>						
		90% Ar 10% CO <sub>2</sub>						
		92% Ar 8% CO <sub>2</sub>						
		Ar-Mix						
	1.0 mm	100% CO <sub>2</sub>	2.54 to 20.32 m/min					
		75% Ar 25% CO <sub>2</sub>	2.54 to 19.30 m/min					
		80% Ar 20% CO <sub>2</sub>	2.54 to 20.32 m/min					
		82% Ar 18% CO <sub>2</sub>						
		85% Ar 15% CO <sub>2</sub>						
		90% Ar 10% CO <sub>2</sub>						
		92% Ar 8% CO <sub>2</sub>						
		Ar-Mix						
		1.2 mm	100% CO <sub>2</sub>		2.54 to 15.37 m/min			
	75% Ar 25% CO <sub>2</sub>		2.54 to 16.38 m/min					
	80% Ar 20% CO <sub>2</sub>		2.54 to 14.10 m/min					
	82% Ar 18% CO <sub>2</sub>							
	85% Ar 15% CO <sub>2</sub>							
	90% Ar 10% CO <sub>2</sub>							
	92% Ar 8% CO <sub>2</sub>							
	Ar-Mix							
	HyperFill®	MCW Steel	1.2mm		80% Ar 20% CO <sub>2</sub>	3.81 to 8.64 m/min	UltimArc® -10.0 to 10.0	N/A
				Ar-Mix				
		Steel	0.9 mm	80% Ar 20% CO <sub>2</sub>	3.81 to 15.11 m/min	UltimArc® -10.0 to 10.0	N/A	
				Ar-Mix				
			1.0 mm	80% Ar 20% CO <sub>2</sub>	2.54 to 11.05 m/min			
				Ar-Mix				
	Low Fume Pulse™	Steel	1.0 mm	80% Ar 20% CO <sub>2</sub>	1.91 to 20.70 m/min	UltimArc® -10.0 to 10.0	N/A	
				Ar-Mix				
			1.2 mm	80% Ar 20% CO <sub>2</sub>	1.52 to 20.32 m/min			
Ar-Mix								
Smart Pulse®	3XX Stainless	0.9 mm	62.2% Ar 35% He 2.8% CO <sub>2</sub>	3.81 to 20.32 m/min	UltimArc® -10.0 to 10.0	N/A		
			98% Ar 2% CO <sub>2</sub>					
			98% Ar 2% O <sub>2</sub>					
			Ar-Mix					
			Tri-Mix (Ar)					
		1.0 mm	62.2% Ar 35% He 2.8% CO <sub>2</sub>	2.54 to 20.32 m/min				
			98% Ar 2% CO <sub>2</sub>					
			98% Ar 2% O <sub>2</sub>					
			Ar-Mix					
			Tri-Mix (Ar)					
		1.2 mm	62.2% Ar 35% He 2.8% CO <sub>2</sub>	2.54 to 15.11 m/min				
			98% Ar 2% CO <sub>2</sub>					
			98% Ar 2% O <sub>2</sub>					
			Ar-Mix					
			Tri-Mix (Ar)					

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GMAW	Smart Pulse®	MCW Steel	1.2 mm	80% Ar 20% CO <sub>2</sub>	2.54 to 16.51 m/min	UltimArc® -10.0 to 10.0	N/A		
				82% Ar 18% CO <sub>2</sub>					
				85% Ar 15% CO <sub>2</sub>					
				90% Ar 10% CO <sub>2</sub>					
				92% Ar 8% CO <sub>2</sub>					
		Ar-Mix							
		Steel	0.9 mm	80% Ar 20% CO <sub>2</sub>	2.54 to 20.32 m/min	UltimArc® -10.0 to 10.0	N/A		
				82% Ar 18% CO <sub>2</sub>					
				85% Ar 15% CO <sub>2</sub>					
			90% Ar 10% CO <sub>2</sub>						
			92% Ar 8% CO <sub>2</sub>						
			Ar-Mix						
	1.0 mm	80% Ar 20% CO <sub>2</sub>	2.54 to 15.37 m/min	UltimArc® -10.0 to 10.0	N/A				
		82% Ar 18% CO <sub>2</sub>							
		85% Ar 15% CO <sub>2</sub>							
		90% Ar 10% CO <sub>2</sub>							
		92% Ar 8% CO <sub>2</sub>							
		Ar-Mix							
	1.2 mm	80% Ar 20% CO <sub>2</sub>	2.54 to 8.89 m/min	UltimArc® -10.0 to 10.0	N/A				
		82% Ar 18% CO <sub>2</sub>							
		85% Ar 15% CO <sub>2</sub>							
		90% Ar 10% CO <sub>2</sub>							
		92% Ar 8% CO <sub>2</sub>							
		Ar-Mix							
STT® (Root Pass)	3XX Stainless	0.9 mm	62.2% Ar 35% He 2.8% CO <sub>2</sub>	2.54 to 7.62 m/min	UltimArc® -10.0 to 10.0	N/A			
			98% Ar 2% CO <sub>2</sub>						
			98% Ar 2% O <sub>2</sub>						
		Ar-Mix							
		Tri-Mix (Ar)							
		1.0 mm	62.2% Ar 35% He 2.8% CO <sub>2</sub>	2.29 to 6.35 m/min			UltimArc® -10.0 to 10.0	N/A	
	98% Ar 2% CO <sub>2</sub>								
	98% Ar 2% O <sub>2</sub>								
	1.2 mm	Ar-Mix	2.29 to 5.72 m/min	UltimArc® -10.0 to 10.0	N/A				
		Tri-Mix (Ar)							
		98% Ar 2% CO <sub>2</sub>							
	MCW Steel	1.2 mm	75% Ar 25% CO <sub>2</sub>	2.29 to 5.72 m/min	UltimArc® -10.0 to 10.0	N/A			
80% Ar 20% CO <sub>2</sub>									
82% Ar 18% CO <sub>2</sub>									
85% Ar 15% CO <sub>2</sub>									
Ar-Mix									
Ar-Mix									
GMAW	STT® (Root Pass)	Steel	0.9 mm	75% Ar 25% CO <sub>2</sub>	2.54 to 8.89 m/min	UltimArc® -10.0 to 10.0	N/A		
				80% Ar 20% CO <sub>2</sub>					
				82% Ar 18% CO <sub>2</sub>					
				85% Ar 15% CO <sub>2</sub>					
				90% Ar 10% CO <sub>2</sub>					
				92% Ar 8% CO <sub>2</sub>					
			Ar-Mix						
			1.0 mm	100% CO <sub>2</sub>	2.54 to 6.99 m/min			UltimArc® -10.0 to 10.0	N/A
				75% Ar 25% CO <sub>2</sub>					
				80% Ar 20% CO <sub>2</sub>					
				82% Ar 18% CO <sub>2</sub>					
				85% Ar 15% CO <sub>2</sub>					
		90% Ar 10% CO <sub>2</sub>							
		92% Ar 8% CO <sub>2</sub>							
		Ar-Mix							
		1.2 mm	100% CO <sub>2</sub>	2.29 to 5.72 m/min	UltimArc® -10.0 to 10.0	N/A			
			75% Ar 25% CO <sub>2</sub>						
			80% Ar 20% CO <sub>2</sub>						
			82% Ar 18% CO <sub>2</sub>						
			85% Ar 15% CO <sub>2</sub>						
			90% Ar 10% CO <sub>2</sub>						
		92% Ar 8% CO <sub>2</sub>							
		Ar-Mix							

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FCAW-G	Manual CV	Any	N/A	Unspecified	10.0 to 45.0 V	Pinch -10.0 to 10.0	N/A
	Gas-Shielded	3XX Stainless	1.2 mm	100% CO <sub>2</sub>	4.45 to 15.24 m/min	Pinch -10.0 to 10.0	N/A
				75% Ar 25% CO <sub>2</sub>			
				80% Ar 20% CO <sub>2</sub>			
				Ar-Mix			
		Steel	1.2 mm	100% CO <sub>2</sub>	4.45 to 15.24 m/min	Pinch -10.0 to 10.0	N/A
				75% Ar 25% CO <sub>2</sub>			
				80% Ar 20% CO <sub>2</sub>			
				Ar-Mix			
			1.4 mm	100% CO <sub>2</sub>	3.81 to 12.70 m/min	Pinch -10.0 to 10.0	N/A
				75% Ar 25% CO <sub>2</sub>			
				80% Ar 20% CO <sub>2</sub>			
				Ar-Mix			
	1.6 mm	100% CO <sub>2</sub>	3.18 to 10.16 m/min	Pinch -10.0 to 10.0	N/A		
		75% Ar 25% CO <sub>2</sub>					
		80% Ar 20% CO <sub>2</sub>					
Ar-Mix							
HyperFill®	Steel	1.2 mm	100% CO <sub>2</sub>	2.54 to 8.51 m/min	N/A	N/A	
			75% Ar 25% CO <sub>2</sub>	2.54 to 7.62 m/min	Pinch -10.0 to 10.0		
			80% Ar 20% CO <sub>2</sub>				
			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)						