

Weld Set Reference: Z224716
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	100 to 815 in/min			
				85% Ar 15% CO ₂	100 to 815 in/min			
	90% Ar 10% CO ₂			100 to 815 in/min				
	Ar-Mix			100 to 815 in/min				
	.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	100 to 800 in/min				
			90% Ar 10% CO ₂	100 to 800 in/min				
			Ar-Mix	100 to 800 in/min				
	.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	50 to 615 in/min				
			90% Ar 10% CO ₂	50 to 615 in/min				
			Ar-Mix	50 to 615 in/min				
	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	150 to 330 in/min	UltimArc® -10.0 to 10.0	N/A	
		Steel	.035 in	90% Ar 10% CO ₂	150 to 585 in/min	UltimArc® -10.0 to 10.0	N/A	
				Ar-Mix	150 to 585 in/min	UltimArc® -10.0 to 10.0	N/A	
			.040 in	90% Ar 10% CO ₂	100 to 410 in/min	UltimArc® -10.0 to 10.0	N/A	
				Ar-Mix	100 to 410 in/min	UltimArc® -10.0 to 10.0	N/A	
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	60 to 650 in/min	UltimArc® -10.0 to 10.0	N/A		
	Steel	.035 in	90% Ar 10% CO ₂	75 to 815 in/min	UltimArc® -10.0 to 10.0	N/A		
			Ar-Mix	75 to 815 in/min	UltimArc® -10.0 to 10.0	N/A		
		.040 in	90% Ar 10% CO ₂	75 to 800 in/min	UltimArc® -10.0 to 10.0	N/A		
			Ar-Mix	75 to 800 in/min	UltimArc® -10.0 to 10.0	N/A		
		.045 in	90% Ar 10% CO ₂	100 to 800 in/min	UltimArc® -10.0 to 10.0	N/A		
			Ar-Mix	100 to 800 in/min	UltimArc® -10.0 to 10.0	N/A		

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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)						
			90% He 7.5% Ar 2.5% CO ₂						
		.040 in	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						
		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					
	.035 in		80% Ar 20% CO ₂	100 to 800 in/min					
			85% Ar 15% CO ₂						
	Steel	.040 in	90% Ar 10% CO ₂		100 to 800 in/min				
			Ar-Mix						
			80% Ar 20% CO ₂						
			85% Ar 15% CO ₂						
		.045 in	90% Ar 10% CO ₂			100 to 700 in/min			
			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)						
			90% He 7.5% Ar 2.5% CO ₂						
		.040 in	98% Ar 2% CO ₂	100 to 300 in/min					
			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							
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	100 to 350 in/min		UltimArc® -10.0 to 10.0	N/A		
		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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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								
Ar-Mix								
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	.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	Pinch -10.0 to 10.0	N/A	
				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	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	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)							