

Weld Set Reference: Z224717
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 ₂	2.54 to 20.32 m/min	Pinch -10.0 to 10.0	N/A	
				98% Ar 2% O ₂				
				Ar-Mix				
			1.0 mm	98% Ar 2% CO ₂				
				98% Ar 2% O ₂				
				Ar-Mix				
			1.2 mm	98% Ar 2% CO ₂				1.91 to 18.92 m/min
				98% Ar 2% O ₂				
				Ar-Mix				
		MCW Steel	1.2 mm	75% Ar 25% CO ₂	2.54 to 16.51 m/min	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					
			Steel	0.9 mm	100% CO ₂	2.54 to 20.32 m/min	Pinch -10.0 to 10.0	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						
	1.0 mm	100% CO ₂		2.54 to 20.32 m/min				
		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							
	1.2 mm	100% CO ₂	2.54 to 15.37 m/min					
		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							
	HyperFill®	MCW Steel	1.2mm	80% Ar 20% CO ₂	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 ₂	3.81 to 15.11 m/min	UltimArc® -10.0 to 10.0	N/A	
				Ar-Mix				
			1.0 mm	80% Ar 20% CO ₂				
				Ar-Mix				
	Low Fume Pulse™	Steel	1.0 mm	80% Ar 20% CO ₂	1.91 to 20.70 m/min	UltimArc® -10.0 to 10.0	N/A	
				Ar-Mix				
		1.2 mm	80% Ar 20% CO ₂					
Ar-Mix								
Smart Pulse®	3XX Stainless	0.9 mm	62.2% Ar 35% He 2.8% CO ₂	3.81 to 20.32 m/min	UltimArc® -10.0 to 10.0	N/A		
			98% Ar 2% CO ₂					
			98% Ar 2% O ₂					
			Ar-Mix					
			Tri-Mix (Ar)					
			62.2% Ar 35% He 2.8% CO ₂					
		98% Ar 2% CO ₂						
		98% Ar 2% O ₂						
		Ar-Mix						
		Tri-Mix (Ar)						
		1.2 mm	62.2% Ar 35% He 2.8% CO ₂	2.54 to 15.11 m/min				
			98% Ar 2% CO ₂					
	98% Ar 2% O ₂							
	Ar-Mix							
	Tri-Mix (Ar)							

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GMAW	Smart Pulse®	MCW Steel	1.2 mm	80% Ar 20% CO ₂	2.54 to 16.51 m/min	UltimArc® -10.0 to 10.0	N/A	
				82% Ar 18% CO ₂				
				85% Ar 15% CO ₂				
				90% Ar 10% CO ₂				
				92% Ar 8% CO ₂				
				Ar-Mix				
		Steel	0.9 mm	80% Ar 20% CO ₂	2.54 to 20.32 m/min	UltimArc® -10.0 to 10.0	N/A	
				82% Ar 18% CO ₂				
				85% Ar 15% CO ₂				
				90% Ar 10% CO ₂				
				92% Ar 8% CO ₂				
				Ar-Mix				
			1.0 mm	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	80% Ar 20% CO ₂	2.54 to 15.37 m/min	UltimArc® -10.0 to 10.0	N/A			
		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)	3XX Stainless	0.9 mm	62.2% Ar 35% He 2.8% CO ₂	2.54 to 8.89 m/min	UltimArc® -10.0 to 10.0	N/A		
			98% Ar 2% CO ₂					
			98% Ar 2% O ₂					
			Ar-Mix					
			Tri-Mix (Ar)					
			62.2% Ar 35% He 2.8% CO ₂					
		1.0 mm	98% Ar 2% CO ₂	2.54 to 7.62 m/min				
			98% Ar 2% O ₂					
			Ar-Mix					
			Tri-Mix (Ar)					
			98% Ar 2% CO ₂					
			98% Ar 2% O ₂					
	1.2 mm	98% Ar 2% CO ₂	2.29 to 6.35 m/min					
		98% Ar 2% O ₂						
		Ar-Mix						
		Ar-Mix						
MCW Steel	1.2 mm	75% Ar 25% CO ₂	2.29 to 5.72 m/min	UltimArc® -10.0 to 10.0	N/A			
		80% Ar 20% CO ₂						
		82% Ar 18% CO ₂						
		85% Ar 15% CO ₂						
		Ar-Mix						
		75% Ar 25% CO ₂				2.54 to 8.89 m/min	UltimArc® -10.0 to 10.0	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								
Steel	0.9 mm	100% CO ₂	2.54 to 6.35 m/min	UltimArc® -10.0 to 10.0	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						
	1.0 mm	92% Ar 8% CO ₂	2.54 to 6.99 m/min					
		Ar-Mix						
		100% CO ₂				2.29 to 5.08 m/min		
		75% Ar 25% CO ₂						
80% Ar 20% CO ₂								
82% Ar 18% CO ₂								
1.2 mm	85% Ar 15% CO ₂	2.29 to 5.72 m/min						
	90% Ar 10% CO ₂							
	92% Ar 8% CO ₂							
	Ar-Mix							
	Ar-Mix							
	Ar-Mix							

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Process Type	Waveform	Wire Type	Wire Size	Gas Type	Workpoint Limits	Wave Control 1	Wave Control 2	
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 ₂	4.45 to 15.24 m/min	Pinch -10.0 to 10.0	N/A	
				75% Ar 25% CO ₂				
				80% Ar 20% CO ₂				
		Steel	1.2 mm	100% CO ₂	4.45 to 15.24 m/min	Pinch -10.0 to 10.0	N/A	
				75% Ar 25% CO ₂				
				80% Ar 20% CO ₂				
			1.4 mm	100% CO ₂	3.81 to 12.70 m/min	Pinch -10.0 to 10.0	N/A	
				75% Ar 25% CO ₂				
				80% Ar 20% CO ₂				
			1.6 mm	100% CO ₂	3.18 to 10.16 m/min	Pinch -10.0 to 10.0	N/A	
				75% Ar 25% CO ₂				
				80% Ar 20% CO ₂				
	HyperFill®		Steel	1.2 mm	100% CO ₂	2.54 to 7.62 m/min	Pinch -10.0 to 10.0	N/A
					75% Ar 25% CO ₂			
80% Ar 20% CO ₂								
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)							