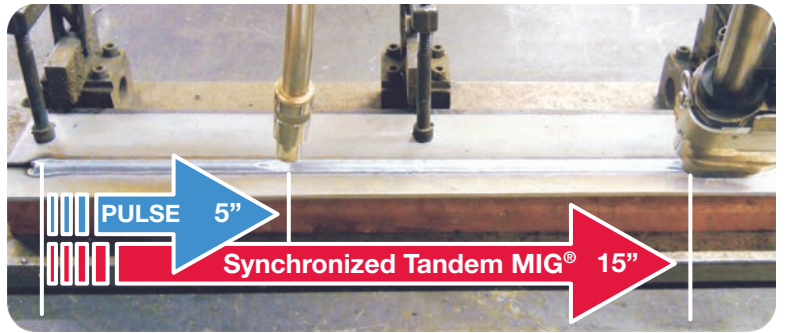


# Synchronized Tandem MIG<sup>®</sup>

Synchronized Tandem MIG<sup>®</sup> gets it done faster.

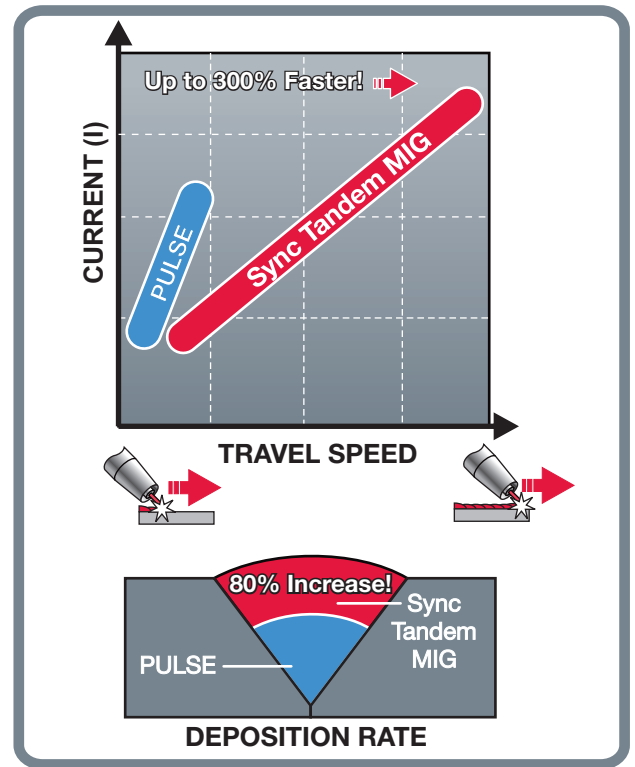
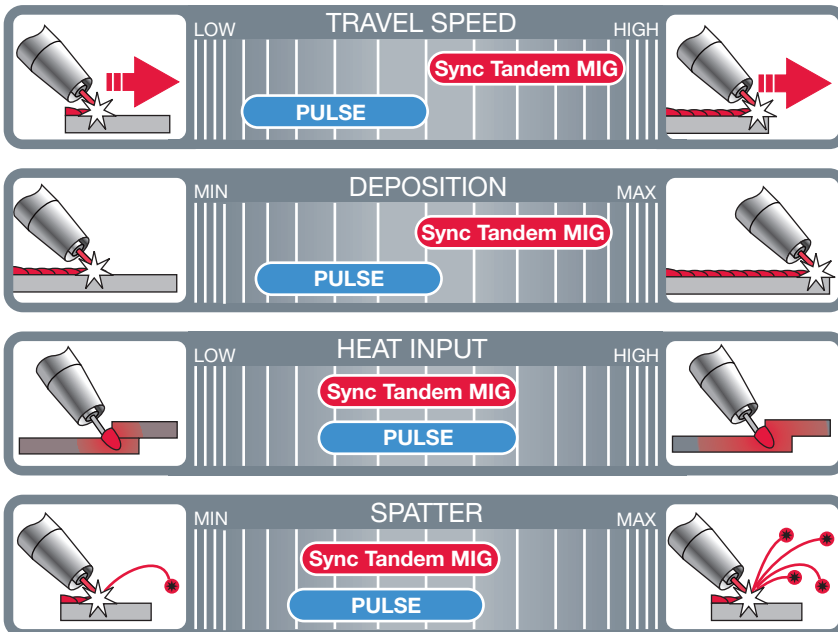
- Increases Travel Speed up to 300%
- Increases Deposition Rates up to 80%
- Enhances Bead Appearance
- Reduces Spatter\*\*



The maximum deposition rate in a traditional single wire GMAW (MIG) process is limited by the saturation current (I) for any specific wire diameter. To overcome this limitation, Tandem MIG combines two separate MIG welds into a single application. The outcome is a process capable of nearly double the deposition rate of single wire MIG.

**Synchronized Tandem MIG<sup>®</sup>** increases stability, reduces spatter and improves bead appearance compared to a standard tandem MIG process. **Synchronized Tandem MIG<sup>®</sup>** utilizes a pulse waveform and synergic precision controls allowing customization of both arcs to meet specific application needs. UltimArc<sup>™</sup> controls fine tune the ramp, peak, background and tailout for each arc. The resulting **Synchronized Tandem MIG<sup>®</sup>** process provides exceptional deposition rates and fast travel speeds.

## FEATURES



\* Based on a side by side comparison of Synchronized Tandem MIG<sup>®</sup> and Pulse using Power Wave<sup>®</sup> i400's with 0.045" L56 wire. Synchronized Tandem MIG<sup>®</sup> parameters: WFS 500 in/min, Travel Speed 100 in/min, 23.3 Volts. Pulse parameters: WFS 350 in/min, Travel Speed 35 in/min, 22.5 Volts.

\*\* Compared to non-synchronized tandem MIG.

**LINCOLN<sup>®</sup>**  
**ELECTRIC**

The Performance You Need.  
The Quality You Expect.<sup>SM</sup>

**2F**

\* Setting used for macro image.

Lead / Trail

o/o T UltimArc™ V A

* SuperArc® 0.045 L-56	90Ar / 10CO <sub>2</sub>	Steel, Mild	ga. 10	Degrees 30	inch 5/8	in / min 100	in / min 500 / 300	0.82 / 0.86	+10.0 / 0.0	22.2 / 21.2	218 / 180	Degrees 180
SupraMIG® 1.2mm	80Ar / 20CO <sub>2</sub>	Steel, Mild	mm 3.4	Degrees 30	mm 16	m / min 2.54	m / min 12.70 / 7.62	0.82 / 0.86	+10.0 / 0.0	22.2 / 21.2	218 / 180	Degrees 180

**2F**

\* Setting used for macro image.

Lead / Trail

o/o T UltimArc™ V A

* SuperArc® 0.052 L-56	90Ar / 10CO <sub>2</sub>	Mild Steel	inch 1/4	Degrees 45	inch 3/4	in / min 40	in / min 325 / 325	0.85 / 0.92	+5.0 / 0.0	21.8 / 24.0	273 / 280	Degrees 180
SupraMIG® 1.4mm	80Ar / 20CO <sub>2</sub>	Mild Steel	mm 6.4	Degrees 45	mm 19	m / min 1.01	m / min 8.26 / 8.26	0.85 / 0.92	+5.0 / 0.0	21.8 / 24.0	273 / 280	Degrees 180

## Recommended Equipment

### Power Source

Power Wave® i400, S500 or R500

### Wire Drive

Power Feed® 10R  
AutoDrive® 4R220

### Accessories

SuperArc® Wire, SupraMig® Wire  
Tandem MIG Torch  
Autodrive® 19 Tandem MIG Controller

### Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customer and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customer's particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

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