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

FEAURES

* Based on a side by side comparison of Synchronized Tandem MIG® and Pulse using Power Wave® i400’s with 0.045” L56 wire. Synchronized Tandem MIG® 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.
**Applications**

**Recommended Equipment**

<table>
<thead>
<tr>
<th>Power Source</th>
<th>Wire Drive</th>
<th>Accessories</th>
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<tr>
<td>Power Wave® i400, S500 or R500</td>
<td>Power Feed® 10R AutoDrive® 4R220</td>
<td>SuperArc® Wire, SupraMig® Wire Tandem MIG Torch Autodrive® 19 Tandem MIG Controller</td>
</tr>
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</table>

**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.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirement.

Subject to change. This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.

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**Power Wave**

- **SuperArc® 0.045 L-56**
  - 90Ar / 10CO₂
  - Steel, Mild
  - ga. 10
  - Degrees 30
  - in / min 500 / 300
  - 0.82 / 0.86 +10.0 / 0.0
  - 22.2 / 21.2
  - 218 / 180

- **SupraMIG® 1.2mm**
  - 80Ar / 20CO₂
  - Steel, Mild
  - inch 5/8
  - Degrees 30
  - in / min 12.70 / 7.62
  - 0.82 / 0.86 +10.0 / 0.0
  - 22.2 / 21.2
  - 218 / 180

**UltimArc™**

- **SuperArc® 0.052 L-56**
  - 90Ar / 10CO₂
  - Mild Steel
  - inch 1/4
  - Degrees 45
  - in / min 325 / 325
  - 0.85 / 0.92 +5.0 / 0.0
  - 21.8 / 24.0
  - 273 / 280

- **SupraMIG® 1.4mm**
  - 80Ar / 20CO₂
  - Mild Steel
  - inch 3/4
  - Degrees 45
  - in / min 8.26 / 8.26
  - 0.85 / 0.92 +5.0 / 0.0
  - 21.8 / 24.0
  - 273 / 280