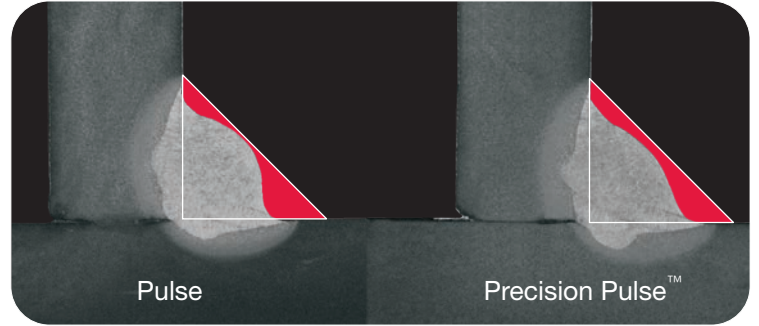


Precision Pulse™ Weld Process Overview

Precision Pulse™ out performs Pulse*.

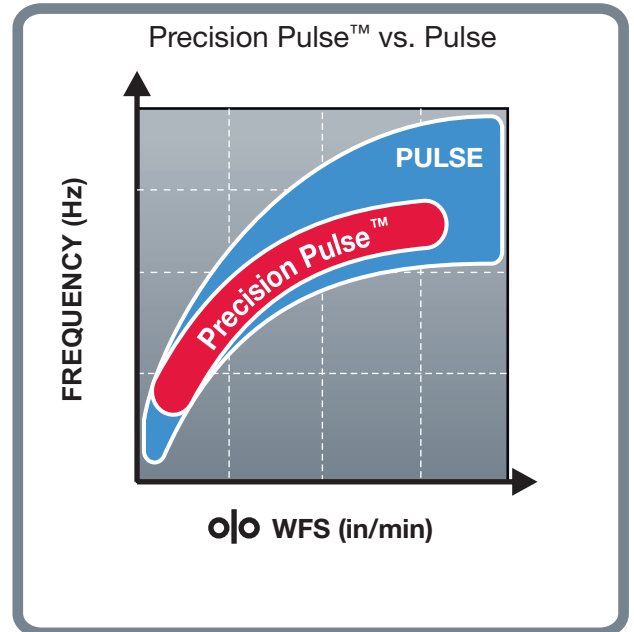
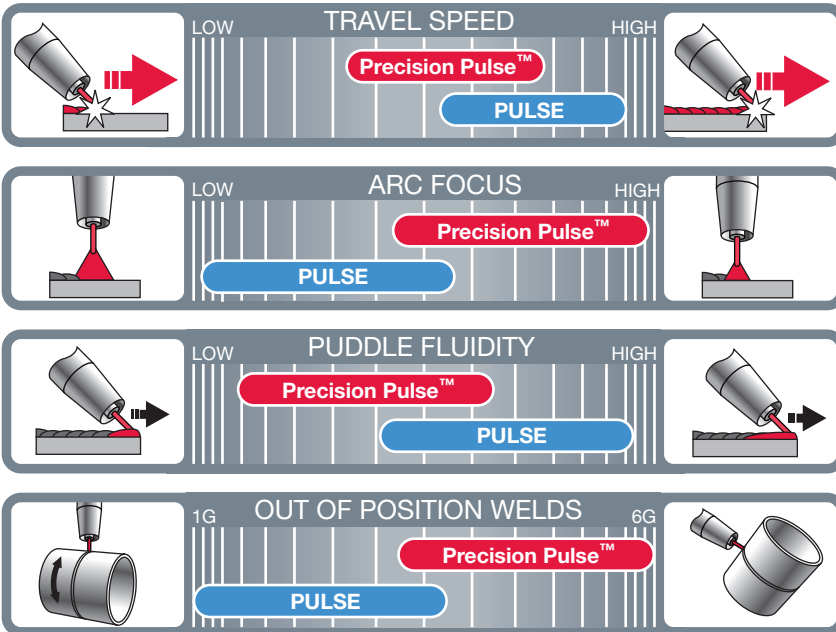
- Improves Out of Position Welds
- Enhances Puddle Control
- Controlled Heat Input
- Improves Welds in Tight Joints



Traditional Pulse welding consists of a peak and background current to deposit a molten droplet after each pulse. **Precision Pulse™** functions similarly, but at a fixed frequency to create a more consistent droplet transfer. The waveform is capable of producing an extremely focused arc at a lower voltage.

Ideal for out of position welds, **Precision Pulse™** gives the operator control over where the droplet transfers and how the puddle forms. A shorter, more focused arc increases puddle control and improves operator confidence compared to Pulse. Frequency adjustments change the focus and droplet size increasing control of the weld puddle. The **Precision Pulse™** waveform is ideally suited for out of position welds with enhanced puddle control.

FEATURES



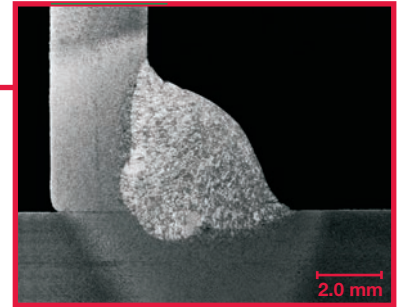
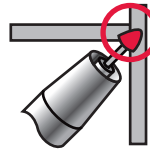
*Based on a side by side comparison of Precision Pulse™ and Pulse using a Power Wave® S350 with SuperArc® 0.045" L-56 wire. Parameters: Position 3F, WFS 110 in/min, Travel Speed 8 in/min, 19.0 Volts, 95 Amps and 1/2" CTWD.



The Performance You Need.
The Quality You Expect.™

Applications

3F

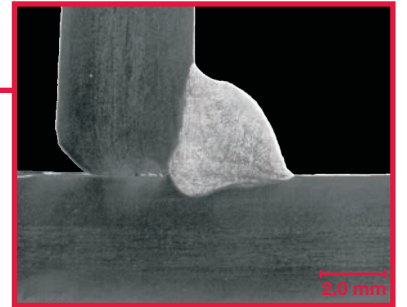


* Setting used for macro image.



* .045 L-56	90Ar / 10CO ₂	Mild Steel	1/4 in.	1/2 in.	110 in/min	19.0	95
1.2 mm	80Ar / 20CO ₂	Mild Steel	7 mm	13 mm	2.54 m/min	19.5	85

3F



* Setting used for macro image.



* .045 308LSi	98Ar / 2CO ₂	304 Stainless	1/4 in.	1/2 in.	120 in/min	17.5	100
1.2 mm	98Ar / 2CO ₂	304 Stainless	7 mm	13 mm	2.79 m/min	18.0	100

See the Precision Pulse™ weld process guide for technical data, proper set-up, application settings and troubleshooting.

Recommended Equipment

Power Source

Power Wave® S350, R350, S500
or R500

Wire Feeder

Power Feed® 10M or 25M

Accessories

SuperArc® Wire
SupraMig® Wire
Magnum® Pro Gun

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