

# SPEEDTEC 405S SPEEDTEC 505S WELD MODE NUMBERS

Weld set reference: **ZWD14103**

<b>Mode</b>	<b>Procedure</b>	<b>Wire Size</b>	<b>Wire Type</b>	<b>Gas Type</b>	<b>Control</b>
1	Stick	-	-	-	ArcForce
3	Touch Start TIG	-	-	Argon	n/a
5	CV	Non Synergic			Pinch
6	FCAW-SS	Non Synergic		Self Shielded	Pinch
7	FCAW-GS	Non Synergic		Argon Blends	Pinch
9	Gouging	-	-	Air	ArcForce
10	CV	1,0	Steel	CO2	Pinch
11	CV	1,0	Steel	Argon Blends	Pinch
20	CV	1,2	Steel	CO2	Pinch
21	CV	1,2	Steel	Argon Blends	Pinch
31	CV	1,0	Stainless	Argon Blends	Pinch
41	CV	1,2	Stainless	Argon Blends	Pinch
61	CV	0,8	Stainless	Argon Blends	Pinch
71	CV	1,2	AlSi 4043	Argon	Pinch
73	CV	1,6	AlSi 4043	Argon	Pinch
75	CV	1,2	AlMg 5356	Argon	Pinch
77	CV	1,6	AlMg 5356	Argon	Pinch
81	CV	1,2	Metal Core	Argon CO2	Pinch
85	CV	1,6	Metal Core	Argon CO2	Pinch
91	CV	1,2	Flux Core	Argon CO2	Pinch
93	CV	0,8	Steel	CO2	Pinch
94	CV	0,8	Steel	Argon Blends	Pinch
105	CV	1,6	Steel	CO2	Pinch
107	CV	1,6	Steel	Argon Blends	Pinch