



# Invertec V450

## Weld Set Reference: Z050060V

Steel		
Procedure	Gas Type	Wire Size
Pulse	Argon Mix	.030
Pulse	Argon Mix	.035
Pulse	Argon Mix	.045
Pulse	Argon Mix	.052
Pulse	Argon Mix	1/16

Stainless		
Procedure	Gas Type	Wire Size
Pulse	He Ar CO <sub>2</sub>	.030
Pulse	Argon Mix	.030
Pulse	He Ar CO <sub>2</sub>	.035
Pulse	Argon Mix	.035
Pulse	He Ar CO <sub>2</sub>	.045
Pulse	Argon Mix	.045

Metal Core		
Procedure	Gas Type	Wire Size
Pulse	Argon Mix	.045
Pulse	Argon Mix	.052
Pulse	Argon Mix	1/16

Aluminum 4043		
Procedure	Gas Type	Wire Size
Pulse	Argon	.035
Pulse on Pulse	Argon	.035
Pulse	Argon	3/64
Pulse on Pulse	Argon	3/64
Pulse	Argon	1/16
Pulse on Pulse	Argon	1/16

Aluminum 5356		
Procedure	Gas Type	Wire Size
Pulse	Argon	.035
Pulse on Pulse	Argon	.035
Pulse	Argon	3/64
Pulse on Pulse	Argon	3/64
Pulse	Argon	1/16
Pulse on Pulse	Argon	1/16

Nickel Alloy		
Procedure	Gas Type	Wire Size
Pulse	Ar He	.035
Pulse	Ar He	.045

General	
Procedure	Gas Type
<b>Stick/TIG/Gouge</b>	
Stick Soft	
Stick Crisp	
TIG	Argon
Gouging	
<b>Wire Welding</b>	
CV MIG	Gas Shielded
Power mode	Gas Shielded
Flux Cored	Self Shielded
Flux Cored	Gas Shielded



**CONTENTS OF WELDING SOFTWARE Z050060V**

Material	Wire Size	Process Description	Gas	WP Range	Arc Control
General		CC Stick Soft		55 - 570 A	Arc Force, Hot Start
General		CC Stick Crisp		55 - 570 A	Arc Force, Hot Start
General		CC TIG		5 - 570 A	Start Mode
General		CC Gouge		60 - 570 A	
General		CV MIG	Gas Shielded	10.0 - 45.0 V	Pinch
General		Power Mode	Gas Shielded	0.1 - 20.0 kW	Pinch
General		CV Flux Cored	Self Shielded	10.0 - 45.0 V	Pinch
General		CV Flux Cored	Gas Shielded	10.0 - 45.0 V	Pinch
Steel	.030in	Pulse	Argon Blends	75 - 800 ipm	Wave Cntrl
Steel	.035in	Pulse	Argon Blends	50 - 800 ipm	Wave Cntrl
Steel	.045in	Pulse	Argon Blends	60 - 800 ipm	Wave Cntrl
Steel	.052in	Pulse	Argon Blends	60 - 750 ipm	Wave Cntrl
Steel	1/16in	Pulse	Argon Blends	60 - 500 ipm	Wave Cntrl
Metal Core	.045in	Pulse	Argon Blends	60 - 700 ipm	Wave Cntrl
Metal Core	.052in	Pulse	Argon Blends	60 - 600 ipm	Wave Cntrl
Metal Core	1/16in	Pulse	Argon Blends	60 - 500 ipm	Wave Cntrl
Stainless	.030in	Pulse	Argon Blends	100 - 800 ipm	Wave Cntrl
Stainless	.030in	Pulse	Helium Argon CO2	100 - 800 ipm	Wave Cntrl
Stainless	.035in	Pulse	Argon Blends	70 - 800 ipm	Wave Cntrl
Stainless	.035in	Pulse	Helium Argon CO2	70 - 800 ipm	Wave Cntrl
Stainless	.045in	Pulse	Argon Blends	50 - 700 ipm	Wave Cntrl
Stainless	.045in	Pulse	Helium Argon CO2	60 - 700 ipm	Wave Cntrl
Aluminum 4043	.035in	Pulse On Pulse	Argon	125 - 600 ipm	Mod Freq
Aluminum 4043	.035in	Pulse	Argon	125 - 700 ipm	Wave Cntrl
Aluminum 4043	3/64in	Pulse	Argon	85 - 600 ipm	Wave Cntrl
Aluminum 4043	3/64in	Pulse On Pulse	Argon	85 - 400 ipm	Mod Freq
Aluminum 4043	1/16in	Pulse	Argon	55 - 350 ipm	Wave Cntrl
Aluminum 4043	1/16in	Pulse On Pulse	Argon	65 - 315 ipm	Mod Freq
Aluminum 5356	.035in	Pulse On Pulse	Argon	140 - 770 ipm	Mod Freq
Aluminum 5356	.035in	Pulse	Argon	130 - 750 ipm	Wave Cntrl
Aluminum 5356	3/64in	Pulse	Argon	85 - 720 ipm	Wave Cntrl
Aluminum 5356	3/64in	Pulse On Pulse	Argon	85 - 575 ipm	Mod Freq
Aluminum 5356	1/16in	Pulse	Argon	65 - 400 ipm	Wave Cntrl
Aluminum 5356	1/16in	Pulse On Pulse	Argon	75 - 360 ipm	Mod Freq
Ni Alloy	.035in	Pulse (Non Adaptive)	Argon Helium	60 - 700 ipm	Wave Cntrl
Ni Alloy	.045in	Pulse (Non Adaptive)	Argon Helium	60 - 600 ipm	Wave Cntrl



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