



Invertec V450

Weld Set Reference: Z050060V

Steel			Aluminum 4043			General	
Procedure	Gas Type	Wire Size	Procedure	Gas Type	Wire Size	Procedure	Gas Type
Pulse	Argon Mix	.030	Pulse	Argon	.035	Stick/TIG/Gouge	
Pulse	Argon Mix	.035	Pulse on Pulse	Argon	.035	Stick Soft	
Pulse	Argon Mix	.045	Pulse	Argon	3/64	Stick Crisp	
Pulse	Argon Mix	.052	Pulse on Pulse	Argon	3/64	TIG	Argon
Pulse	Argon Mix	1/16	Pulse	Argon	1/16	Gouging	
			Pulse on Pulse	Argon	1/16	Wire Welding	
Stainless			Aluminum 5356			CV MIG	Gas Shielded
Pulse	He Ar CO ₂	.030	Pulse	Argon	.035	Power mode	Gas Shielded
Pulse	Argon Mix	.030	Pulse on Pulse	Argon	.035	Flux Cored	Self Shielded
Pulse	He Ar CO ₂	.035	Pulse	Argon	3/64	Flux Cored	Gas Shielded
Pulse	Argon Mix	.035	Pulse on Pulse	Argon	3/64		
Pulse	He Ar CO ₂	.045	Pulse	Argon	1/16		
Pulse	Argon Mix	.045	Pulse on Pulse	Argon	1/16		
Metal Core			Nickel Alloy				
Pulse	Argon Mix	.045	Pulse	Ar He	.035		
Pulse	Argon Mix	.052	Pulse	Ar He	.045		
Pulse	Argon Mix	1/16					



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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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