



Power Wave AC/DC 1000

Weld Set Reference: Z092804K

	Single Arc Mild Steel									Single Arc Stainless				Twin Arc Mild Steel				
	7/32"	3/16"	5/32"	1/8"	3/32"	5/64"	1/16"	0.052"	0.045"	5/32"	1/8"	3/32"	1/16"	3/32"	5/64"	1/16"	0.052"	0.045"
CC 60Hz Sine	22	32	42	52	62	72	82											
CC 50Hz Sine	23	33	43	53	63	73	83											
CV DC-	24	34	44	54	64	74	84	90	93	104	114	124	134	164	174	184	190	193
CV DC+	25	35	45	55	65	75	85	91	94	105	115	125	135	165	175	185	191	194
CV Square Wave	26	36	46	56	66	76	86	92	95	106	116	126	136	166	176	186	192	195
CC DC-	27	37	47	57	67	77	87			107	117	127	137	167	177	187		
CC DC+	28	38	48	58	68	78	88			108	118	128	138	168	178	188		
CC Square Wave	29	39	49	59	69	79	89			109	119	129	139	169	179	189		



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Note: Parallel machines may be required to reach the upper limits of the WFS/Amp Range									
Mode	Wire Type	Wire Size	Procedure	WFS/Amp Range		Volts (V)	Frequency (Hz) Offset (%) Balance		
22	Steel	7/32in	CC 60Hz Sine	500 - 2000	A	20.0 - 60.0	50	-25 to +25	50
23	Steel	7/32in	CC 50Hz Sine	500 - 2000	A	20.0 - 60.0	50	-25 to +25	50
24	Steel	7/32in	CV DC-	43 - 196	IPM	20.0 - 60.0			
25	Steel	7/32in	CV DC+	29 - 130	IPM	20.0 - 60.0			
26	Steel	7/32in	CV Square Wave	36 - 160	IPM	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
27	Steel	7/32in	CC DC-	500 - 2000	A	20.0 - 60.0			
28	Steel	7/32in	CC DC+	500 - 2000	A	20.0 - 60.0			
29	Steel	7/32in	CC Square Wave	500 - 2000	A	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
32	Steel	3/16in	CC 60Hz Sine	400 - 2000	A	20.0 - 60.0	60	-25 to +25	50
33	Steel	3/16in	CC 50Hz Sine	400 - 2000	A	20.0 - 60.0	50	-25 to +25	50
34	Steel	3/16in	CV DC-	36 - 208	IPM	20.0 - 60.0			
35	Steel	3/16in	CV DC+	23 - 194	IPM	20.0 - 60.0			
36	Steel	3/16in	CV Square Wave	34 - 239	IPM	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
37	Steel	3/16in	CC DC-	400 - 2000	A	20.0 - 60.0			
38	Steel	3/16in	CC DC+	400 - 2000	A	20.0 - 60.0			
39	Steel	3/16in	CC Square Wave	400 - 2000	A	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
42	Steel	5/32in	CC 60Hz Sine	400 - 2000	A	20.0 - 60.0	60	-25 to +25	50
43	Steel	5/32in	CC 50Hz Sine	400 - 2000	A	20.0 - 60.0	50	-25 to +25	50
44	Steel	5/32in	CV DC-	30 - 314	IPM	20.0 - 60.0			
45	Steel	5/32in	CV DC+	26 - 225	IPM	20.0 - 60.0			
46	Steel	5/32in	CV Square Wave	29 - 327	IPM	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
47	Steel	5/32in	CC DC-	400 - 2000	A	20.0 - 60.0			
48	Steel	5/32in	CC DC+	400 - 2000	A	20.0 - 60.0			
49	Steel	5/32in	CC Square Wave	400 - 2000	A	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
52	Steel	1/8in	CC 60Hz Sine	200 - 2000	A	20.0 - 60.0	60	-25 to +25	50
53	Steel	1/8in	CC 50Hz Sine	200 - 2000	A	20.0 - 60.0	50	-25 to +25	50
54	Steel	1/8in	CV DC-	33 - 457	IPM	20.0 - 60.0			
55	Steel	1/8in	CV DC+	26 - 395	IPM	20.0 - 60.0			
56	Steel	1/8in	CV Square Wave	33 - 452	IPM	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
57	Steel	1/8in	CC DC-	200 - 2000	A	20.0 - 60.0			
58	Steel	1/8in	CC DC+	200 - 2000	A	20.0 - 60.0			
59	Steel	1/8in	CC Square Wave	200 - 2000	A	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
62	Steel	3/32in	CC 60Hz Sine	200 - 1000	A	20.0 - 60.0	50	-25 to +25	50
63	Steel	3/32in	CC 50Hz Sine	200 - 1000	A	20.0 - 60.0	60	-25 to +25	50
64	Steel	3/32in	CV DC-	57 - 350	IPM	20.0 - 60.0			
65	Steel	3/32in	CV DC+	37 - 325	IPM	20.0 - 60.0			
66	Steel	3/32in	CV Square Wave	50 - 350	IPM	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
67	Steel	3/32in	CC DC-	200 - 1000	A	20.0 - 60.0			
68	Steel	3/32in	CC DC+	200 - 1000	A	20.0 - 60.0			
69	Steel	3/32in	CC Square Wave	200 - 1000	A	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
72	Steel	5/64in	CC 60Hz Sine	200 - 800	A	20.0 - 60.0	60	-25 to +25	50
73	Steel	5/64in	CC 50Hz Sine	200 - 800	A	20.0 - 60.0	50	-25 to +25	50
74	Steel	5/64in	CV DC-	75 - 290	IPM	20.0 - 60.0			
75	Steel	5/64in	CV DC+	50 - 288	IPM	20.0 - 60.0			
76	Steel	5/64in	CV Square Wave	62 - 300	IPM	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
77	Steel	5/64in	CC DC-	200 - 600	A	20.0 - 60.0			
78	Steel	5/64in	CC DC+	200 - 800	A	20.0 - 60.0			
79	Steel	5/64in	CC Square Wave	200 - 800	A	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
82	Steel	1/16in	CC 60Hz Sine	200 - 600	A	20.0 - 60.0	60	-25 to +25	50
83	Steel	1/16in	CC 50Hz Sine	200 - 600	A	20.0 - 60.0	50	-25 to +25	50
84	Steel	1/16in	CV DC-	140 - 500	IPM	20.0 - 60.0			
85	Steel	1/16in	CV DC+	98 - 500	IPM	20.0 - 60.0			
86	Steel	1/16in	CV Square Wave	115 - 500	IPM	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
87	Steel	1/16in	CC DC-	200 - 500	A	20.0 - 60.0			
88	Steel	1/16in	CC DC+	200 - 630	A	20.0 - 60.0			
89	Steel	1/16in	CC Square Wave	200 - 800	A	20.0 - 60.0	10 - 100	-25 to +25	25 to 75



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Note: Parallel machines may be required to reach the upper limits of the WFS/Amp Range									
90	Steel	0.052	CV DC-	230 - 500	IPM	20.0 - 60.0			
91	Steel	0.052	CV DC+	220 - 500	IPM	20.0 - 60.0			
92	Steel	0.052	CV Square Wave	184 - 500	IPM	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
93	Steel	0.045	CV DC-	300 - 500	IPM	20.0 - 60.0			
94	Steel	0.045	CV DC+	250 - 500	IPM	20.0 - 60.0			
95	Steel	0.045	CV Square Wave	240 - 500	IPM	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
104	Stainless	5/32in	CV DC-	40 - 327	IPM	20.0 - 60.0			
105	Stainless	5/32in	CV DC+	30 - 224	IPM	20.0 - 60.0			
106	Stainless	5/32in	CV Square Wave	35 - 280	IPM	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
107	Stainless	5/32in	CC DC-	250 - 2000	A	20.0 - 60.0			
108	Stainless	5/32in	CC DC+	250 - 2000	A	20.0 - 60.0			
109	Stainless	5/32in	CC Square Wave	250 - 2000	A	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
114	Stainless	1/8in	CV DC-	60 - 450	IPM	20.0 - 60.0			
115	Stainless	1/8in	CV DC+	45 - 372	IPM	20.0 - 60.0			
116	Stainless	1/8in	CV Square Wave	40 - 410	IPM	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
117	Stainless	1/8in	CC DC-	200 - 2000	A	20.0 - 60.0			
118	Stainless	1/8in	CC DC+	200 - 2000	A	20.0 - 60.0			
119	Stainless	1/8in	CC Square Wave	200 - 2000	A	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
124	Stainless	3/32in	CV DC-	93 - 500	IPM	20.0 - 60.0			
125	Stainless	3/32in	CV DC+	69 - 481	IPM	20.0 - 60.0			
126	Stainless	3/32in	CV Square Wave	63 - 500	IPM	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
127	Stainless	3/32in	CC DC-	200 - 1050	A	20.0 - 60.0			
128	Stainless	3/32in	CC DC+	200 - 1050	A	20.0 - 60.0			
129	Stainless	3/32in	CC Square Wave	200 - 1050	A	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
134	Stainless	1/16in	CV DC-	200 - 500	IPM	20.0 - 60.0			
135	Stainless	1/16in	CV DC+	175 - 500	IPM	20.0 - 60.0			
136	Stainless	1/16in	CV Square Wave	150 - 500	IPM	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
137	Stainless	1/16in	CC DC-	200 - 500	A	20.0 - 60.0			
138	Stainless	1/16in	CC DC+	200 - 500	A	20.0 - 60.0			
139	Stainless	1/16in	CC Square Wave	200 - 500	A	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
164	Twin Arc	3/32	CV DC-	28 - 400	IPM	20.0 - 60.0			
165	Twin Arc	3/32	CV DC+	23 - 260	IPM	20.0 - 60.0			
166	Twin Arc	3/32	CV Square Wave	25 - 300	IPM	20.0 - 60.0	10 - 100		25 to 75
167	Twin Arc	3/32	CC DC-	200-2000	A	20.0 - 60.0			
168	Twin Arc	3/32	CC DC+	200-2000	A	20.0 - 60.0			
169	Twin Arc	3/32	CC Square Wave	200-2000	A	20.0 - 60.0	10 - 100	-25 to +25	25 to 75
174	Twin Arc	5/64	CV DC-	42 - 500	IPM	20.0 - 60.0			
175	Twin Arc	5/64	CV DC+	40 - 350	IPM	20.0 - 60.0			
176	Twin Arc	5/64	CV Square Wave	40 - 440	IPM	20.0 - 60.0	10 to 100	-25 to +25	25 to 75
177	Twin Arc	5/64	CC DC-	200-2000	A	20.0 - 60.0			
178	Twin Arc	5/64	CC DC+	200-2000	A	20.0 - 60.0			
179	Twin Arc	5/64	CC Square Wave	200-2000	A	20.0 - 60.0	10 to 100	-25 to +25	25 to 75
184	Twin Arc	1/16	CV DC-	82 - 500	IPM	20.0 - 60.0			
185	Twin Arc	1/16	CV DC+	61 - 500	IPM	20.0 - 60.0			
186	Twin Arc	1/16	CV Square Wave	56 - 500	IPM	20.0 - 60.0	10 to 100	-25 to +25	25 to 75
187	Twin Arc	1/16	CC DC-	200-2000	A	20.0 - 60.0			
188	Twin Arc	1/16	CC DC+	200-2000	A	20.0 - 60.0			
189	Twin Arc	1/16	CC Square Wave	200-1200	A	20.0 - 60.0	10 to 100	-25 to +25	25 to 75
190	Twin Arc	0.052	CV DC-	128 - 500	IPM	20.0 - 60.0			
191	Twin Arc	0.052	CV DC+	110 - 500	IPM	20.0 - 60.0			
192	Twin Arc	0.052	CV Square Wave	106 - 500	IPM	20.0 - 60.0	10 to 100	-25 to +25	25 to 75
193	Twin Arc	0.045	CV DC-	175 - 500	IPM	20.0 - 60.0			
194	Twin Arc	0.045	CV DC+	117 - 500	IPM	20.0 - 60.0			
195	Twin Arc	0.045	CV Square Wave	120 - 500	IPM	20.0 - 60.0	10 to 100	-25 to +25	25 to 75



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