



Power Wave 405M

F355i CE

Weld Set Reference: Z060044E

| Steel | | | Stainless | | | Aluminum AISi | | | Aluminum AlMg | | |
|------------------------|-----------------------|------|------------------------|-----------------------|------|------------------------|----------|------|------------------------|----------|------|
| Procedure | Gas Type | Mode | Procedure | Gas Type | Mode | Procedure | Gas Type | Mode | Procedure | Gas Type | Mode |
| 0.8mm Wire Size | | | 0.8mm Wire Size | | | 1.0mm Wire Size | | | 1.0mm Wire Size | | |
| CV | CO ₂ | 93 | CV | Argon Mix | 61 | CV | Argon | 148 | CV | Argon | 151 |
| CV | Argon Mix | 94 | CV | Ar He CO ₂ | 63 | Pulse | Argon | 149 | Pulse | Argon | 152 |
| Pulse | Argon Mix | 95 | Pulse | Ar He CO ₂ | 64 | Pulse on Pulse | Argon | 98 | Pulse on Pulse | Argon | 101 |
| Pulse | Argon CO ₂ | 66 | 1.0mm Wire Size | | | 1.2mm Wire Size | | | 1.2mm Wire Size | | |
| 1.0mm Wire Size | | | 1.0mm Wire Size | | | 1.2mm Wire Size | | | 1.2mm Wire Size | | |
| CV | CO ₂ | 10 | CV | Argon Mix | 31 | CV | Argon | 71 | CV | Argon | 75 |
| CV | Argon Mix | 11 | CV | Ar He CO ₂ | 33 | Pulse | Argon | 72 | Pulse | Argon | 76 |
| Pulse | Argon Mix | 12 | Pulse | Ar He CO ₂ | 34 | Pulse on Pulse | Argon | 99 | Pulse on Pulse | Argon | 102 |
| Pulse RapidArc | Argon CO ₂ | 13 | Pulse | Argon CO ₂ | 36 | 1.6mm Wire Size | | | 1.6mm Wire Size | | |
| 1.2mm Wire Size | | | 1.2mm Wire Size | | | 1.6mm Wire Size | | | 1.6mm Wire Size | | |
| CV | CO ₂ | 20 | CV | Argon Mix | 41 | CV | Argon | 73 | CV | Argon | 77 |
| CV | Argon Mix | 21 | CV | Ar He CO ₂ | 43 | Pulse | Argon | 74 | Pulse | Argon | 78 |
| Pulse | Argon Mix | 22 | Pulse | Ar He CO ₂ | 44 | Pulse on Pulse | Argon | 100 | Pulse on Pulse | Argon | 103 |
| Pulse RapidArc | Argon CO ₂ | 18 | Pulse | Argon CO ₂ | 46 | Nickel Alloy | | | Nickel Alloy | | |
| General | | | Metal Core | | | Nickel Alloy | | | Nickel Alloy | | |
| Stick/Tig/Gouge | | | 1.2mm Wire Size | | | 1.0mm Wire Size | | | 1.0mm Wire Size | | |
| Stick Soft | | 1 | CV | Argon CO ₂ | 81 | Pulse | Ar He | 170 | 1.2mm Wire Size | | |
| Stick Crisp | | 2 | Pulse | Argon CO ₂ | 82 | 1.2mm Wire Size | | | 1.2mm Wire Size | | |
| Touch Start TIG | Argon | 3 | 1.4mm Wire Size | | | 1.2mm Wire Size | | | 1.2mm Wire Size | | |
| Gouging | | 9 | CV | Argon CO ₂ | 83 | Pulse | Ar He | 175 | Silicon Bronze | | |
| Wire Welding | | | Pulse | Argon CO ₂ | 84 | 1.0mm Wire Size | | | Silicon Bronze | | |
| CV MIG | | 5 | Nickel Alloy | | | 1.0mm Wire Size | | | Silicon Bronze | | |
| FCAW-SS | Self Shielded | 6 | Nickel Alloy | | | 1.0mm Wire Size | | | Silicon Bronze | | |
| Power mode | | 40 | Nickel Alloy | | | 1.0mm Wire Size | | | Silicon Bronze | | |
| General | | | Metal Core | | | Nickel Alloy | | | Nickel Alloy | | |
| Stick/Tig/Gouge | | | 1.2mm Wire Size | | | 1.0mm Wire Size | | | 1.0mm Wire Size | | |
| Stick Soft | | 1 | CV | Argon CO ₂ | 81 | Pulse | Ar He | 170 | 1.2mm Wire Size | | |
| Stick Crisp | | 2 | Pulse | Argon CO ₂ | 82 | 1.2mm Wire Size | | | 1.2mm Wire Size | | |
| Touch Start TIG | Argon | 3 | 1.4mm Wire Size | | | 1.2mm Wire Size | | | 1.2mm Wire Size | | |
| Gouging | | 9 | CV | Argon CO ₂ | 83 | Pulse | Ar He | 175 | Silicon Bronze | | |
| Wire Welding | | | Pulse | Argon CO ₂ | 84 | 1.0mm Wire Size | | | Silicon Bronze | | |
| CV MIG | | 5 | Nickel Alloy | | | 1.0mm Wire Size | | | Silicon Bronze | | |
| FCAW-SS | Self Shielded | 6 | Nickel Alloy | | | 1.0mm Wire Size | | | Silicon Bronze | | |
| Power mode | | 40 | Nickel Alloy | | | 1.0mm Wire Size | | | Silicon Bronze | | |



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| Mode | Process | Procedure | Wire Size | Wire Type | Gas Type | ArcControl |
|------|---------|----------------------|-----------|---------------|---------------|-----------------|
| 1 | SMAW | Stick Soft | | | | Arc Force |
| 2 | SMAW | Stick Crisp | | | | Arc Force |
| 3 | GTAW | Touch Start TIG | | | Argon | n/a |
| 5 | GMAW | CV MIG (Non Syn) | | | | Pinch |
| 6 | FCAW-S | FCAW-SS (Non Syn) | | | Self Shielded | Pinch |
| 9 | GOUGING | Gouging | | | | Arc Force |
| 10 | GMAW | CV | 1.0 mm | Steel | CO2 | Pinch |
| 11 | GMAW | CV | 1.0 mm | Steel | Argon Mix | Pinch |
| 12 | GMAW-P | Pulse | 1.0 mm | Steel | Argon Mix | Wave Control |
| 13 | GMAW-P | Pulse - RapidArc | 1.0 mm | Steel | Argon CO2 | Wave Control |
| 18 | GMAW-P | Pulse - RapidArc | 1.2 mm | Steel | Argon CO2 | Wave Control |
| 20 | GMAW | CV | 1.2 mm | Steel | CO2 | Pinch |
| 21 | GMAW | CV | 1.2 mm | Steel | Argon Mix | Pinch |
| 22 | GMAW-P | Pulse | 1.2 mm | Steel | Argon Mix | Wave Control |
| 31 | GMAW | CV | 1.0 mm | Stainless | Argon Mix | Pinch |
| 33 | GMAW | CV | 1.0 mm | Stainless | Ar He CO2 | Pinch |
| 34 | GMAW-P | Pulse | 1.0 mm | Stainless | Ar He CO2 | Wave Control |
| 36 | GMAW-P | Pulse | 1.0 mm | Stainless | Argon CO2 | Wave Control |
| 40 | GMAW | Power Mode (Non Syn) | | | | Pinch |
| 41 | GMAW | CV | 1.2 mm | Stainless | Argon Mix | Pinch |
| 43 | GMAW | CV | 1.2 mm | Stainless | Ar He CO2 | Pinch |
| 44 | GMAW-P | Pulse | 1.2 mm | Stainless | Ar He CO2 | Wave Control |
| 46 | GMAW-P | Pulse | 1.2 mm | Stainless | Argon CO2 | Wave Control |
| 61 | GMAW | CV | 0.8 mm | Stainless | Argon Mix | Pinch |
| 63 | GMAW | CV | 0.8 mm | Stainless | Ar He CO2 | Pinch |
| 64 | GMAW-P | Pulse | 0.8 mm | Stainless | Ar He CO2 | Wave Control |
| 66 | GMAW-P | Pulse | 0.8 mm | Stainless | Argon CO2 | Wave Control |
| 71 | GMAW | CV | 1.2 mm | Aluminum AISi | Argon | Pinch |
| 72 | GMAW-P | Pulse | 1.2 mm | Aluminum AISi | Argon | Wave Control |
| 73 | GMAW | CV | 1.6 mm | Aluminum AISi | Argon | Pinch |
| 74 | GMAW-P | Pulse | 1.6 mm | Aluminum AISi | Argon | Wave Control |
| 75 | GMAW | CV | 1.2 mm | Aluminum AlMg | Argon | Pinch |
| 76 | GMAW-P | Pulse | 1.2 mm | Aluminum AlMg | Argon | Wave Control |
| 77 | GMAW | CV | 1.6 mm | Aluminum AlMg | Argon | Pinch |
| 78 | GMAW-P | Pulse | 1.6 mm | Aluminum AlMg | Argon | Wave Control |
| 81 | GMAW | CV | 1.2 mm | Metal Core | Argon CO2 | Pinch |
| 82 | GMAW-P | Pulse | 1.2 mm | Metal Core | Argon CO2 | Wave Control |
| 83 | GMAW | CV | 1.4 mm | Metal Core | Argon CO2 | Pinch |
| 84 | GMAW-P | Pulse | 1.4 mm | Metal Core | Argon CO2 | Wave Control |
| 93 | GMAW | CV | 0.8 mm | Steel | CO2 | Pinch |
| 94 | GMAW | CV | 0.8 mm | Steel | Argon Mix | Pinch |
| 95 | GMAW-P | Pulse | 0.8 mm | Steel | Argon Mix | Wave Control |
| 98 | GMAW-P | Pulse on Pulse | 1.0 mm | Aluminum AISi | Argon | Modulation Freq |
| 99 | GMAW-P | Pulse on Pulse | 1.2 mm | Aluminum AISi | Argon | Modulation Freq |
| 100 | GMAW-P | Pulse on Pulse | 1.6 mm | Aluminum AISi | Argon | Modulation Freq |
| 101 | GMAW-P | Pulse on Pulse | 1.0 mm | Aluminum AlMg | Argon | Modulation Freq |
| 102 | GMAW-P | Pulse on Pulse | 1.2 mm | Aluminum AlMg | Argon | Modulation Freq |
| 103 | GMAW-P | Pulse on Pulse | 1.6 mm | Aluminum AlMg | Argon | Modulation Freq |
| 148 | GMAW | CV | 1.0 mm | Aluminum AISi | Argon | Pinch |
| 149 | GMAW-P | Pulse | 1.0 mm | Aluminum AISi | Argon | Wave Control |
| 151 | GMAW | CV | 1.0 mm | Aluminum AlMg | Argon | Pinch |
| 152 | GMAW-P | Pulse | 1.0 mm | Aluminum AlMg | Argon | Wave Control |
| 170 | GMAW-P | Pulse - Non Adaptive | 1.0 mm | Ni Alloy | Argon Helium | Wave Control |
| 175 | GMAW-P | Pulse - Non Adaptive | 1.2 mm | Ni Alloy | Argon Helium | Wave Control |
| 192 | GMAW-P | Pulse | 1.0 mm | Si Bronze | Argon | Wave Control |



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