



WELDING

METAL	SHIELDING GAS	MODE	WELD DEPTH			
			0.040" (1.0mm)	0.080" (2.0mm)	0.120" (3.0mm)	0.160" (4.0mm)
STAINLESS STEEL	NITROGEN	CW	A1	A2	A3	A4
		M	C1	C2	C3	-
		W	A6	A7	A8	A9
MILD STEEL	NITROGEN	CW	E1	E2	E3	E4
		M	F1	F2	F3	-
		W	E6	E7	E8	-
GALVANIZED STEEL	NITROGEN	CW	-	-	-	-
		M	J1	J2	J3	-
		W	-	-	-	-
ALUMINUM 3XXX	ARGON	CW	-	-	-	-
		M	H1	H2	H3	H4
		W	-	-	-	-
ALUMINUM 5XXX	ARGON	CW	-	-	-	-
		M	L1	L2	L3	L4
		W	L6	L7	L8	L9

CLEANING

MODE	INTENSITY	
	Low	High
C	P1	P2
C	P2	P3
C	P2	P3
C	U0	U1
C	U0	U1

TACK

METAL	SHIELDING GAS	MODE	PROGRAM	TACK DEPTH			
				0.040" (1.0mm)	0.080" (2.0mm)	0.120" (3.0mm)	0.160" (4.0mm)
STAINLESS STEEL	NITROGEN	T	A5	300 W	550 W	800 W	1150 W
MILD STEEL	NITROGEN	T	E5	400 W	650 W	900 W	1250 W
ALUMINUM 5XXX	ARGON	T	L5	700 W	800 W	1100 W	1500 W

1) SELECT THE TACK PROGRAM 2) ADJUST POWER CONTROL TO MATCH DESIRED TACK DEPTH



Continuous Wave:
Maximum penetration & travel speed



Modulation:
Reduced energy for slower welding with less heat input



Tack:
Small and temporary welds that hold parts together for final welding



Wire Welding
Used when filler material is required to help bridge gaps or produce fillet weld



Cleaning
Pre & post weld joint cleaning to improve weld quality, consistency, & appearance