

STEEL Welding Programs

FUSION WELDING

METAL	SHIELDING GAS	PROGRAM	20 ga 0.038"	16 ga 0.063"	14 ga 0.078"	11 ga 0.125"	9 ga 0.156"
STAINLESS STEEL	NITROGEN	A1	250 W	400 W	500 W	800 W	1000 W
MILD STEEL	NITROGEN	A4	250 W	400 W	500 W	800 W	1000 W
GALVANIZED STEEL	NITROGEN	A7	250 W	400 W	500 W	800 W	1000 W

*Adjust wobble frequency value to -50

TACK WELDING

METAL	SHIELDING GAS	PROGRAM	20 ga 0.038"	16 ga 0.063"	14 ga 0.078"	11 ga 0.125"	9 ga 0.156"
STAINLESS STEEL	NITROGEN	A0	220 W	360 W	450 W	750 W	1000 W
MILD STEEL	NITROGEN	A3	220 W	390 W	500 W	800 W	1000 W

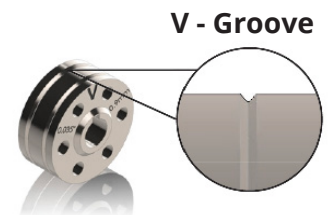
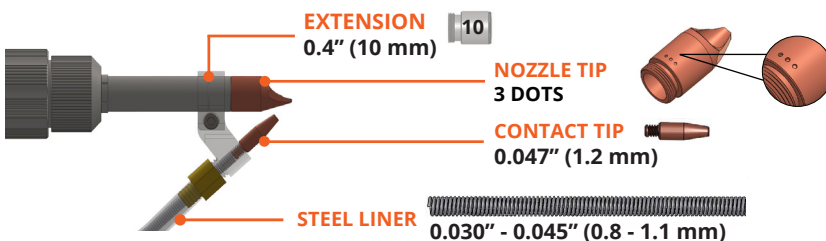
HARD WIRE WELDING

METAL	SHIELDING GAS	WIRE ALLOY	WIRE SIZE	PROGRAM	20 ga 0.038"	16 ga 0.063"	14 ga 0.078"	11 ga 0.125"
STAINLESS STEEL	NITROGEN	308LSi	0.045"	A2	350 W	530 W	650 W	950 W
					16 ipm	15 ipm	14 ipm	12 ipm
MILD STEEL	NITROGEN	ER70S-6	0.045"	A5	350 W	530 W	650 W	950 W
					14 ipm	13 ipm	12 ipm	10 ipm

*Adjust wobble frequency value to -50

HARD WIRE WELDING CONFIGURATION

Wire Feeder Programs require LightWELD Wire Feeder



ALUMINUM Welding Programs

FUSION WELDING

METAL	SHIELDING GAS	PROGRAM	18 ga 0.040"	14 ga 0.064"	12 ga 0.081"	8 ga 0.129"
ALUMINUM 5XXX	ARGON	F1	300 W	480 W	600 W	900 W
ALUMINUM 6XXX	ARGON	F4	300 W	480 W	600 W	900 W
ALUMINUM 3XXX	ARGON	F7	350 W	530 W	650 W	1000 W

*Adjust wobble frequency value to -50

TACK WELDING

METAL	SHIELDING GAS	PROGRAM	18 ga 0.040"	14 ga 0.064"	12 ga 0.081"	8 ga 0.129"
ALUMINUM 5XXX	ARGON	F0	350 W*	500 W	600 W	900 W
ALUMINUM 6XXX	ARGON	F3	350 W*	500 W	600 W	900 W
ALUMINUM 3XXX	ARGON	F6	700 W**	750 W*	800 W	1000 W

*Adjust wobble frequency (tack time) value to -50

**Adjust wobble frequency (tack time) value to -90

SOFT WIRE WELDING

METAL	SHIELDING GAS	WIRE ALLOY	WIRE SIZE	PROGRAM	18 ga 0.040"	14 ga 0.064"	12 ga 0.081"	8 ga 0.129"
ALUMINUM 5XXX	ARGON	ER5356	0.047"	F2	400 W	580 W	700 W	1000 W
					20 ipm	20 ipm	20 ipm	20 ipm
ALUMINUM 6XXX	ARGON	ER5356	0.047"	F5	400 W	580 W	700 W	1000 W
					20 ipm	20 ipm	20 ipm	20 ipm

*Adjust wobble frequency value to -50

SOFT WIRE WELDING CONFIGURATION

Wire Feeder Programs require LightWELD Wire Feeder

