



Welding & Cleaning Programs for STEEL, TITANIUM, NICKEL ALLOYS

FUSION WELDING				20 ga 0.038"	16 ga 0.063"	14 ga 0.078"	11 ga 0.125"	9 ga 0.156"
METAL	SHIELDING GAS	PROCESS TYPE	PROGRAM					
STAINLESS STEEL	NITROGEN	FUSION WELDING	A1	350 W	530 W	650 W	950 W	1350 W
		PULSED WELDING	P0	350 W	530 W	650 W	950 W	1300 W
MILD STEEL	NITROGEN	FUSION WELDING	A4	350 W	530 W	650 W	1000 W	1400 W
		PULSED WELDING	P1	350 W	530 W	650 W	1000 W	1350 W
GALVANIZED STEEL	NITROGEN	FUSION WELDING	A7	350 W	530 W	650 W	1000 W	1400 W
		PULSED WELDING	P2	350 W	530 W	650 W	1000 W	1350 W

TACK WELDING				20 ga 0.038"	16 ga 0.063"	14 ga 0.078"	11 ga 0.125"	9 ga 0.156"
METAL	SHIELDING GAS	PROCESS TYPE	PROGRAM					
STAINLESS STEEL	NITROGEN	TACK	A0	300 W	450 W	550 W	750 W	1000 W
MILD STEEL	NITROGEN	TACK	A3	300 W	450 W	550 W	1000 W	1350 W

CLEANING				INTENSITY		
METAL	SHIELDING GAS	PROCESS TYPE		LOW	MEDIUM	HIGH
STEELS	NITROGEN	CLEANING		C0	C1	C2

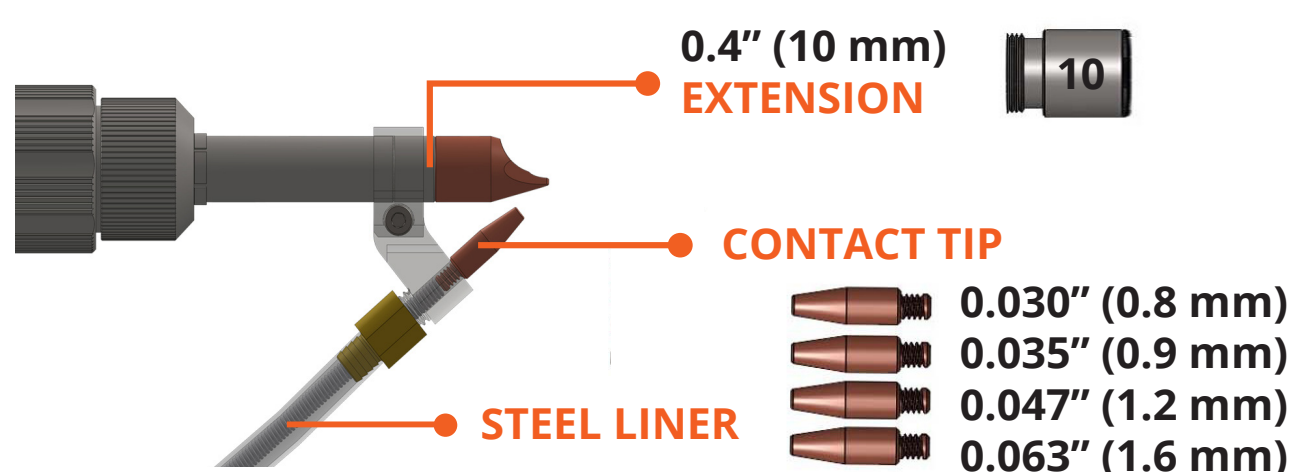
Cleaning function available on LightWELD XC and XR models.

HARD WIRE WELDING				20 ga 0.038"	16 ga 0.063"	14 ga 0.078"	11 ga 0.125"	9 ga 0.156"	
METAL	SHIELDING GAS	WIRE ALLOY	WIRE SIZE	PROGRAM					
STAINLESS STEEL	NITROGEN	308LSi	0.045"	A2	500 W	710 W	850 W	1200 W	1500 W*
					16 ipm	15 ipm	14 ipm	12 ipm	10 ipm
MILD STEEL	NITROGEN	ER70S-6	0.045"	A5	600 W	810 W	950 W	1250 W	1500 W*
					16 ipm	15 ipm	14 ipm	10 ipm	8 ipm

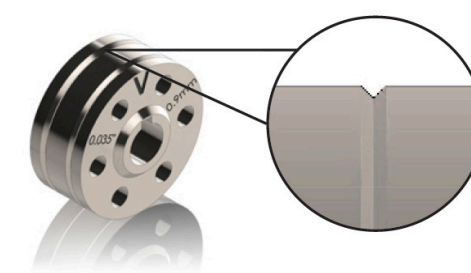
*Adjust wobble frequency value to -50

HARD WIRE WELDING CONFIGURATION

HARD WIRE



Wire Feeder Programs require LightWELD Wire Feeder.



V - Groove



Welding & Cleaning Programs for ALUMINUM & COPPER

FUSION WELDING					18 ga 0.040"	14 ga 0.064"	12 ga 0.081"	8 ga 0.129"	6 ga 0.162"
METAL	SHIELDING GAS	PROCESS TYPE	PROGRAM						
ALUMINUM 5XXX	ARGON	FUSION WELDING	F1	-	800 W	900 W	1250 W	1500 W	
		PULSED WELDING	P3	900 W	1200 W	-	-	-	
ALUMINUM 3XXX	ARGON	FUSION WELDING	F7	-	800 W	900 W	1250 W	1500 W	
		PULSED WELDING	P5	900 W	1200 W	-	-	-	

TACK WELDING					18 ga 0.040"	14 ga 0.064"	12 ga 0.081"	8 ga 0.129"	6 ga 0.162"
METAL	SHIELDING GAS	PROCESS TYPE	PROGRAM						
ALUMINUM 5XXX	ARGON	TACK	A0	300 W	450 W	550 W	750 W	1000 W	
ALUMINUM 3XXX	ARGON	TACK	A3	300 W	450 W	550 W	1000 W	1350 W	

*Adjust wobble frequency (tack time) value to -70

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

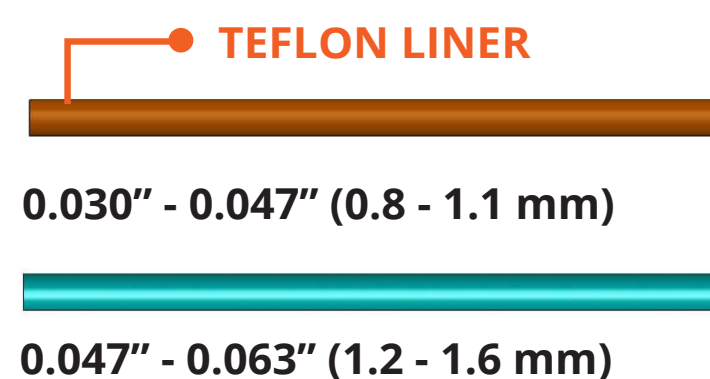
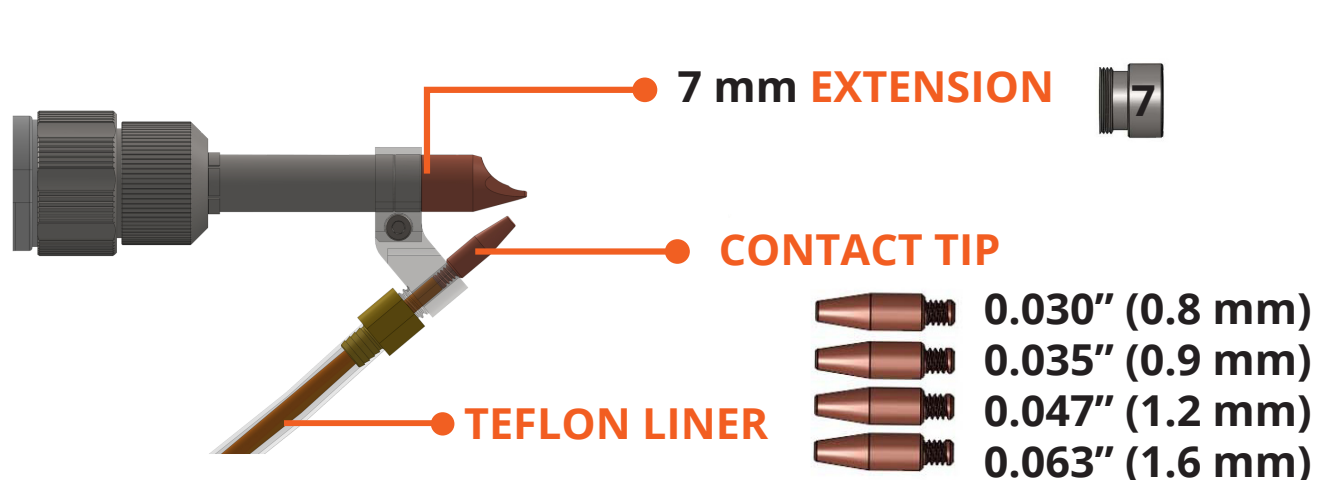
CLEANING					INTENSITY		
METAL	SHIELDING GAS	PROCESS TYPE		LOW	MEDIUM	HIGH	
ALUMINUM 5XXX	ARGON	CLEANING		H0	-	H2	

Cleaning function available on LightWELD XC and XR models.

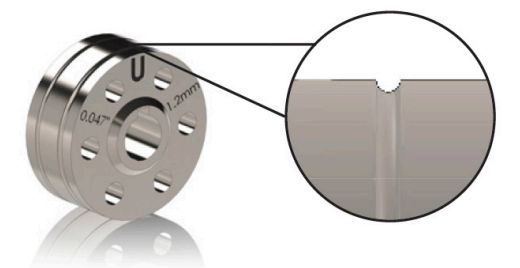
HARD WIRE WELDING					18 ga 0.040"	14 ga 0.064"	12 ga 0.081"	8 ga 0.129"	6 ga 0.162"
METAL	SHIELDING GAS	WIRE ALLOY	WIRE SIZE	PROGRAM					
ALUMINUM 5XXX	ARGON	ER5356	0.047"	F2	700 W 20 ipm	850 W 19 ipm	950 W 18 ipm	1250 W 16 ipm	1500 W 14 ipm

SOFT WIRE WELDING CONFIGURATION

SOFT WIRE



Wire Feeder Programs require LightWELD Wire Feeder.



U - Groove

