



Power Wave AC/DC 1000 SD

Weld Set Reference: Z092815

							TwinArc®		
	3/16"	5/32"	1/8"	3/32"	5/64"	1/16"	3/32"	5/64"	1/16"
CC 60Hz Sine	32	42	52	62					
CC 50Hz Sine	33	43	53	63					
CV DC-	34	44	54	64	74	84	164	174	184
CV DC+	35	45	55	65	75	85	165	175	185
CV Square Wave	36	46	56	66	76	86	166	176	186
CC DC-	37	47	57	67	77	87	167	177	187
CC DC+	38	48	58	68	78	88	168	178	188
CC Square Wave	39	49	59	69	79	89	169	179	189



THE WELDING EXPERTS

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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)	DC Offset (%)	Balance
32	Steel	3/16in	CC 60Hz Sine	200 - 2000 A	20.0 - 60.0	60	-25 to +25	50
33	Steel	3/16in	CC 50Hz Sine	200 - 2000 A	20.0 - 60.0	50	-25 to +25	50
34	Steel	3/16in	CV DC-	20 - 300 IPM	20.0 - 60.0			
35	Steel	3/16in	CV DC+	30 - 300 IPM	20.0 - 60.0			
36	Steel	3/16in	CV Square Wave	20 - 240 IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
37	Steel	3/16in	CC DC-	200 - 2000 A	20.0 - 60.0			
38	Steel	3/16in	CC DC+	200 - 2000 A	20.0 - 60.0			
39	Steel	3/16in	CC Square Wave	200 - 2000 A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
42	Steel	5/32in	CC 60Hz Sine	200 - 2000 A	20.0 - 60.0	60	-25 to +25	50
43	Steel	5/32in	CC 50Hz Sine	200 - 2000 A	20.0 - 60.0	50	-25 to +25	50
44	Steel	5/32in	CV DC-	30 - 300 IPM	20.0 - 60.0			
45	Steel	5/32in	CV DC+	30 - 256 IPM	20.0 - 60.0			
46	Steel	5/32in	CV Square Wave	26 - 210 IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
47	Steel	5/32in	CC DC-	200 - 2000 A	20.0 - 60.0			
48	Steel	5/32in	CC DC+	200 - 2000 A	20.0 - 60.0			
49	Steel	5/32in	CC Square Wave	200 - 2000 A	20.0 - 60.0	20 - 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 - 426 IPM	20.0 - 60.0			
55	Steel	1/8in	CV DC+	30 - 256 IPM	20.0 - 60.0			
56	Steel	1/8in	CV Square Wave	30 - 310 IPM	20.0 - 60.0	20 - 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	20 - 100	-25 to +25	25 to 75
62	Steel	3/32in	CC 60Hz Sine	200 - 2000 A	20.0 - 60.0	60	-25 to +25	50
63	Steel	3/32in	CC 50Hz Sine	200 - 2000 A	20.0 - 60.0	50	-25 to +25	50
64	Steel	3/32in	CV DC-	33 - 426 IPM	20.0 - 60.0			
65	Steel	3/32in	CV DC+	30 - 256 IPM	20.0 - 60.0			
66	Steel	3/32in	CV Square Wave	30 - 310 IPM	20.0 - 60.0	20 - 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	20 - 100	-25 to +25	25 to 75
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	20 - 100	-25 to +25	25 to 75
77	Steel	5/64in	CC DC-	200 - 2000 A	20.0 - 60.0			
78	Steel	5/64in	CC DC+	200 - 2000 A	20.0 - 60.0			
79	Steel	5/64in	CC Square Wave	200 - 2000 A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
84	Steel	1/16in	CV DC-	140 - 500 IPM	20.0 - 60.0			
85	Steel	1/16in	CV DC+	84 - 500 IPM	20.0 - 60.0			
86	Steel	1/16in	CV Square Wave	62-500 IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
87	Steel	1/16in	CC DC-	200 - 2000 A	20.0 - 60.0			
88	Steel	1/16in	CC DC+	200 - 2000 A	20.0 - 60.0			
89	Steel	1/16in	CC Square Wave	200 - 2000 A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
164	Steel	3/32in	CV DC- Twin	57 - 220 IPM	20.0 - 60.0			
165	Steel	3/32in	CV DC+ Twin	41-199 IPM	20.0 - 60.0			
166	Steel	3/32in	CV Sq Wave Twin	40-336 IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
167	Steel	3/32in	CC DC- Twin	200 - 2000 A	20.0 - 60.0			
168	Steel	3/32in	CC DC+ Twin	200 - 2000 A	20.0 - 60.0			
169	Steel	3/32in	CC Sq WaveTwin	300 - 2000 A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
174	Steel	5/64in	CV DC- Twin	61 - 500 IPM	20.0 - 60.0			
175	Steel	5/64in	CV DC+ Twin	47 - 425 IPM	20.0 - 60.0			
176	Steel	5/64in	CV Sq Wave Twin	53 - 298 IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
177	Steel	5/64in	CC DC- Twin	200 - 2000 A	20.0 - 60.0			
178	Steel	5/64in	CC DC+ Twin	200 - 2000 A	20.0 - 60.0			
179	Steel	5/64in	CC Sq WaveTwin	200 - 2000 A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
184	Steel	1/16in	CV DC- Twin	65-500 IPM	20.0 - 60.0			
185	Steel	1/16in	CV DC+ Twin	65-500 IPM	20.0 - 60.0			
186	Steel	1/16in	CV Sq Wave Twin	65 - 500 IPM	20.0 - 60.0	20 - 100	-25 to +25	25 to 75
187	Steel	1/16in	CC DC- Twin	200 - 2000 A	20.0 - 60.0			
188	Steel	1/16in	CC DC+ Twin	200 - 2000 A	20.0 - 60.0			
189	Steel	1/16in	CC Sq WaveTwin	200 - 2000 A	20.0 - 60.0	20 - 100	-25 to +25	25 to 75



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