



Weld Set Reference: Z093120

| Steel | | | Stainless | | | Aluminum 4043 | | | Aluminum 5356 | | |
|------------------------|-----------------------|------|------------------------------------|----------------------|------|-------------------------|----------|------|-------------------------|----------|------|
| Procedure | Gas Type | Mode | Procedure | Gas Type | Mode | Procedure | Gas Type | Mode | Procedure | Gas Type | Mode |
| 0.8mm Wire Size | | | 0.9mm Wire Size | | | 0.9mm Wire Size | | | 0.9mm Wire Size | | |
| CV | CO ₂ | 93 | CV | Argon O ₂ | 29 | | | | | | |
| CV | Argon CO ₂ | 94 | Pulse | Argon O ₂ | 30 | | | | | | |
| 0.9mm Wire Size | | | 1.0mm Wire Size | | | 1.0mm Wire Size | | | 1.0mm Wire Size | | |
| CV | CO ₂ | 14 | CV | Argon O ₂ | 31 | | | | | | |
| CV | Argon CO ₂ | 15 | Pulse | Argon O ₂ | 32 | | | | | | |
| Pulse | Argon CO ₂ | 16 | | | | 1.2 mm Wire Size | | | 1.2 mm Wire Size | | |
| Pulse RapidArc | Argon CO ₂ | 17 | | | | CV | Argon | 71 | CV | Argon | 75 |
| 1.0mm Wire Size | | | 1.2mm Wire Size | | | Pulse | Argon | 72 | Pulse | Argon | 76 |
| CV | CO ₂ | 10 | CV | Argon O ₂ | 41 | Flux Core | | | Silicon Bronze | | |
| CV | Argon CO ₂ | 11 | Pulse | Argon O ₂ | 42 | 1.2 mm Wire Size | | | 0.9mm Wire Size | | |
| Pulse | Argon CO ₂ | 12 | General | | | Metal Core | | | Nickel Alloy | | |
| Pulse RapidArc | Argon CO ₂ | 13 | Stick/Tig/Gouge | | | 1.2 mm Wire Size | | | 0.9 mm Wire Size | | |
| 1.2mm Wire Size | | | Wire Welding (Non Synergic) | | | 1.2 mm Wire Size | | | 1.2 mm Wire Size | | |
| CV | CO ₂ | 20 | | | | | | | | | |
| CV | Argon CO ₂ | 21 | | | | | | | | | |
| Pulse | Argon CO ₂ | 22 | | | | | | | | | |
| Pulse RapidArc | Argon CO ₂ | 18 | | | | | | | | | |



CONTENTS OF WELDING SOFTWARE Z093120

| Mode | Process | Procedure | Wire Size | Wire Type | Gas Type | ArcControl |
|-------------|----------------|------------------|------------------|------------------|-----------------------|-------------------|
| 10 | GMAW | CV | 1.0 | Steel | CO ₂ | Pinch |
| 11 | GMAW | CV | 1.0 | Steel | Argon CO ₂ | Pinch |
| 12 | GMAW-P | Pulse | 1.0 | Steel | Argon CO ₂ | UltimArc |
| 13 | GMAW-RA | Pulse - RapidArc | 1.0 | Steel | Argon CO ₂ | UltimArc |
| 14 | GMAW | CV | 0.9 | Steel | CO ₂ | Pinch |
| 15 | GMAW | CV | 0.9 | Steel | Argon CO ₂ | Pinch |
| 16 | GMAW-P | Pulse | 0.9 | Steel | Argon CO ₂ | UltimArc |
| 17 | GMAW-RA | Pulse - RapidArc | 0.9 | Steel | Argon CO ₂ | UltimArc |
| 18 | GMAW-RA | Pulse - RapidArc | 1.2 | Steel | Argon CO ₂ | UltimArc |
| 20 | GMAW | CV | 1.2 | Steel | CO ₂ | Pinch |
| 21 | GMAW | CV | 1.2 | Steel | Argon CO ₂ | Pinch |
| 22 | GMAW-P | Pulse | 1.2 | Steel | Argon CO ₂ | UltimArc |
| 29 | GMAW | CV | 0.9 | Stainless | Argon O ₂ | Pinch |
| 30 | GMAW-P | Pulse | 0.9 | Stainless | Argon O ₂ | UltimArc |
| 31 | GMAW | CV | 1.0 | Stainless | Argon O ₂ | Pinch |
| 32 | GMAW-P | Pulse | 1.0 | Stainless | Argon O ₂ | UltimArc |
| 41 | GMAW | CV | 1.2 | Stainless | Argon O ₂ | Pinch |
| 42 | GMAW-P | Pulse | 1.2 | Stainless | Argon O ₂ | UltimArc |
| 71 | GMAW | CV | 1.2 | Aluminum 4043 | Argon | Pinch |
| 72 | GMAW-P | Pulse | 1.2 | Aluminum 4043 | Argon | UltimArc |
| 75 | GMAW | CV | 1.2 | Aluminum 5356 | Argon | Pinch |
| 76 | GMAW-P | Pulse | 1.2 | Aluminum 5356 | Argon | UltimArc |
| 93 | GMAW | CV | 0.8 | Steel | CO ₂ | Pinch |
| 94 | GMAW | CV | 0.8 | Steel | Argon CO ₂ | Pinch |



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