



Weld Set Reference: Z093217

Power Wave i400

Steel			Stainless			Aluminum 4043			Aluminum 5356		
Procedure	Gas Type	Mode	Procedure	Gas Type	Mode	Procedure	Gas Type	Mode	Procedure	Gas Type	Mode
.030 Wire Size			.030 Wire Size			.035 Wire Size			.035 Wire Size		
CV	CO ₂	93	CV	Argon Mix	61	CV	Argon	148	CV	Argon	151
CV	Argon CO ₂	94	CV	HeArCO ₂	63	Pulse	Argon	149	Pulse	Argon	152
Pulse	Argon Mix	95	Pulse	Argon O ₂	62	Pulse on Pulse	Argon	98	Pulse on Pulse	Argon	101
.035 Wire Size			.035 Wire Size			3/64 Wire Size			3/64 Wire Size		
CV	CO ₂	10	Pulse	HeArCO ₂	64	CV	Argon	71	CV	Argon	75
CV	Argon Mix	11	Pulse	Argon CO ₂	66	Pulse	Argon	72	Pulse	Argon	76
Pulse	Argon Mix	12	.035 Wire Size			Pulse on Pulse	Argon	99	Pulse on Pulse	Argon	102
Pulse RapidArc	Argon CO ₂	13	CV	Argon Mix	31	1/16 Wire Size			1/16 Wire Size		
Vertical Up Pulse	Argon Mix	19	CV	HeArCO ₂	33	CV	Argon	73	CV	Argon	77
.040 Wire Size			Pulse	Argon O ₂	32	Pulse	Argon	74	Pulse	Argon	78
CV	CO ₂	14	Pulse	HeArCO ₂	34	Pulse on Pulse	Argon	100	Pulse on Pulse	Argon	103
CV	Argon Mix	15	Pulse	Argon CO ₂	36	Flux Core			Silicon Bronze		
Pulse	Argon Mix	16	Vertical Up Pulse	Argon Mix	38	.045 Wire Size			.035 Wire Size		
Pulse RapidArc	Argon CO ₂	17	.045 Wire Size			CV	CO ₂	90	Pulse	Argon	192
.045 Wire Size			CV	Argon Mix	41	CV	Argon Mix	91	Nickel Alloy		
CV	CO ₂	20	CV	HeArCO ₂	43	Metal Core			.035 Wire Size		
CV	Argon Mix	21	Pulse	Argon O ₂	42	.045 Wire Size			.045 Wire Size		
Pulse	Argon Mix	22	Pulse	HeArCO ₂	44	CV	Argon Mix	81	Pulse	Argon Helium	170
Pulse RapidArc	Argon CO ₂	18	Pulse	Argon CO ₂	46	Pulse	Argon Mix	82	.045 Wire Size		
Vertical Up Pulse	Argon Mix	23	Vertical Up Pulse	Argon Mix	48	Pulse RapidArc	Argon CO ₂	87	Pulse	Argon Helium	175
.052 Wire Size			General			.052 Wire Size			Copper		
CV	CO ₂	24	Stick/Tig/Gouge			CV	Argon Mix	83	.035 Wire Size		
CV	Argon Mix	25	Stick Soft		1	Pulse	Argon Mix	84	Pulse	Argon Helium	195
Pulse	Argon Mix	26	Stick Crisp		2	Pulse RapidArc	Argon CO ₂	88	.045 Wire Size		
Pulse RapidArc	Argon CO ₂	27	Stick Pipe		4	1/16 Wire Size			Pulse	Argon Helium	196
1/16 Wire Size			Tig	Argon	3	CV	Argon Mix	85	Lincoln Electric		
CV	CO ₂	107	Tig - Pulse	Argon	8	Pulse	Argon Mix	86	ELECTRIC		
Pulse	Argon Mix	108	Gouging		9	Pulse RapidArc	Argon CO ₂	89	THE WELDING EXPERTS		
Wire Welding (Non Synergic)			Wire Welding (Non Synergic)			1/16 Wire Size			1/16 Wire Size		
CV		5	CV		5	CV	Argon Mix	85	CV	Argon Mix	85
FCAW-S	Self Shielded	6	FCAW-S	Self Shielded	6	Pulse	Argon Mix	86	Pulse	Argon Mix	86
FCAW-G	Gas Shielded	7	FCAW-G	Gas Shielded	7	Pulse RapidArc	Argon CO ₂	89	Pulse RapidArc	Argon CO ₂	89
Power Mode		40	Power Mode		40	1/16 Wire Size			1/16 Wire Size		

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Mode	Process	Procedure	Wire Size	Wire Type	Gas Type	ArcControl
1	SMAW	Stick Soft				Arc Force, Hot Start
2	SMAW	Stick Crisp				Arc Force, Hot Start
3	GTAW	Touch Start TIG			Argon	
4	SMAW	Stick Pipe				Arc Force
5	GMAW	CV				Pinch
6	FCAW-SS	CV			Self Shielded	Pinch
7	FCAW-GS	CV			Gas Shielded	Pinch
8	GTAW-P	Tig - Pulse			Argon	Frequency, Background
9	GOUGING	Arc Gouging				
10	GMAW	CV	0.035	Steel	CO ₂	Pinch
11	GMAW	CV	0.035	Steel	Argon Blends	Pinch
12	GMAW-P	Pulse	0.035	Steel	Argon Blends	UltimArc
13	GMAW-P	Pulse - RapidArc	0.035	Steel	Argon Blends	UltimArc
14	GMAW	CV	0.040	Steel	CO ₂	Pinch
15	GMAW	CV	0.040	Steel	Argon Blends	Pinch
16	GMAW-P	Pulse	0.040	Steel	Argon Blends	UltimArc
17	GMAW-P	Pulse - RapidArc	0.040	Steel	Argon Blends	UltimArc
18	GMAW-P	Pulse - RapidArc	0.045	Steel	Argon Blends	UltimArc
19	GMAW-P	Vertical Up Pulse	0.035	Steel	Argon Blends	Frequency Offset
20	GMAW	CV	0.045	Steel	CO ₂	Pinch
21	GMAW	CV	0.045	Steel	Argon Blends	Pinch
22	GMAW-P	Pulse	0.045	Steel	Argon Blends	UltimArc
23	GMAW-P	Vertical Up Pulse	0.045	Steel	Argon Blends	Frequency Offset
24	GMAW	CV	0.052	Steel	CO ₂	Pinch
25	GMAW	CV	0.052	Steel	Argon Blends	Pinch
26	GMAW-P	Pulse	0.052	Steel	Argon blends	UltimArc
27	GMAW-P	Pulse - RapidArc	0.052	Steel	Argon blends	UltimArc
31	GMAW	CV	0.035	Stainless	Argon Blends	Pinch
32	GMAW-P	Pulse	0.035	Stainless	Argon O ₂	UltimArc
33	GMAW	CV	0.035	Stainless	He Ar CO ₂	Pinch
34	GMAW-P	Pulse	0.035	Stainless	He Ar CO ₂	UltimArc
36	GMAW-P	Pulse	0.035	Stainless	Argon CO ₂	UltimArc
38	GMAW-P	Vertical Up Pulse	0.035	Stainless	Argon CO ₂	Frequency Offset
40	GMAW	Power Mode				Pinch
41	GMAW	CV	0.045	Stainless	Argon Blends	Pinch
42	GMAW-P	Pulse	0.045	Stainless	Argon O ₂	UltimArc
43	GMAW	CV	0.045	Stainless	He Ar CO ₂	Pinch
44	GMAW-P	Pulse	0.045	Stainless	He Ar CO ₂	UltimArc
46	GMAW-P	Pulse	0.045	Stainless	Argon CO ₂	UltimArc
48	GMAW-P	Vertical Up Pulse	0.045	Stainless	Argon CO ₂	Frequency Offset
61	GMAW	CV	0.030	Stainless	Argon Blends	Pinch
62	GMAW-P	Pulse	0.030	Stainless	Argon O ₂	UltimArc
63	GMAW	CV	0.030	Stainless	He Ar CO ₂	Pinch
64	GMAW-P	Pulse	0.030	Stainless	He Ar CO ₂	UltimArc
66	GMAW-P	Pulse	0.030	Stainless	Argon CO ₂	UltimArc
71	GMAW	CV	3/64	Al 4043	Argon	Pinch
72	GMAW-P	Pulse	3/64	Al 4043	Argon	UltimArc
73	GMAW	CV	1/16	Al 4043	Argon	Pinch
74	GMAW-P	Pulse	1/16	Al 4043	Argon	UltimArc
75	GMAW	CV	3/64	Al 5356	Argon	Pinch
76	GMAW-P	Pulse	3/64	Al 5356	Argon	UltimArc
77	GMAW	CV	1/16	Al 5356	Argon	Pinch
78	GMAW-P	Pulse	1/16	Al 5356	Argon	UltimArc
81	GMAW	CV	0.045	Metal Core	Argon Blends	Pinch
82	GMAW-P	Pulse	0.045	Metal Core	Argon Blends	UltimArc
83	GMAW	CV	0.052	Metal Core	Argon Blends	Pinch
84	GMAW-P	Pulse	0.052	Metal Core	Argon Blends	UltimArc
87	GMAW-P	Pulse - RapidArc	0.045	Metal Core	Argon Blends	UltimArc
88	GMAW-P	Pulse - RapidArc	0.052	Metal Core	Argon Blends	UltimArc
90	FCAW-GS	CV	0.045		CO ₂	Pinch
91	FCAW-GS	CV	0.045		Argon CO ₂	Pinch
93	GMAW	CV	0.030	Steel	CO ₂	Pinch
94	GMAW	CV	0.030	Steel	Argon Blends	Pinch
95	GMAW-P	Pulse	0.030	Steel	Argon Blends	UltimArc
98	GMAW-PP	Pulse on Pulse	0.035	Al 4043	Argon	Frequency
99	GMAW-PP	Pulse on Pulse	3/64	Al 4043	Argon	Frequency
100	GMAW-PP	Pulse on Pulse	1/16	Al 4043	Argon	Frequency
101	GMAW-PP	Pulse on Pulse	0.035	Al 5356	Argon	Frequency
102	GMAW-PP	Pulse on Pulse	3/64	Al 5356	Argon	Frequency
103	GMAW-PP	Pulse on Pulse	1/16	Al 5356	Argon	Frequency
107	GMAW	CV	1/16	Steel	Argon Blends	Pinch
108	GMAW-P	Pulse	1/16	Steel	Argon Blends	Ultimarc
148	GMAW	CV	0.035	Al 4043	Argon	Pinch
149	GMAW-P	Pulse	0.035	Al 4043	Argon	UltimArc
151	GMAW	CV	0.035	Al 5356	Argon	Pinch
152	GMAW-P	Pulse	0.035	Al 5356	Argon	UltimArc
170	GMAW-P	Pulse	0.035	Ni Chrome	Argon He	UltimArc
175	GMAW-P	Pulse	0.045	Ni Chrome	Argon He	UltimArc
192	GMAW-P	Pulse	0.035	Si Bronze	Argon	UltimArc
195	GMAW-P	Pulse	0.035	Copper	Argon He	UltimArc
196	GMAW-P	Pulse	0.045	Copper	Argon He	UltimArc



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