

# Weld Set Reference: Z103113

Steel			Stainless			Aluminum 4043			Aluminum 5356		
Procedure	Gas Type	Mode	Procedure	Gas Type	Mode	Procedure	Gas Type	Mode	Procedure	Gas Type	Mode
<b>0.8mm Wire Size</b>			<b>0.8mm Wire Size</b>			<b>1.0mm Wire Size</b>			<b>1.0mm Wire Size</b>		
CV	CO2	93	CV	Argon Mix	61				CV	Argon	151
CV	Argon Mix	94	CV	Ar He CO2	63				Pulse	Argon	152
Pulse	Argon Mix	95	Pulse	Ar He CO2	64	Pulse on Pulse	Argon	98	Pulse on Pulse	Argon	101
<b>0.9mm Wire Size</b>			<b>1.0mm Wire Size</b>			<b>1.2mm Wire Size</b>			<b>1.2mm Wire Size</b>		
CV	CO2	14	CV	Argon Mix	31	CV	Argon	71	CV	Argon	75
CV	Argon Mix	15	CV	Ar He CO2	33	Pulse	Argon	72	Pulse	Argon	76
Pulse	Argon Mix	16	Pulse	Ar He CO2	34	Pulse on Pulse	Argon	99	Pulse on Pulse	Argon	102
Pulse RapidArc	Argon CO <sub>2</sub>	17	Pulse	Argon CO <sub>2</sub>	36	<b>1.6mm Wire Size</b>			<b>1.6mm Wire Size</b>		
<b>1.0mm Wire Size</b>			<b>1.2mm Wire Size</b>			<b>Flux Core</b>			<b>Silicon Bronze</b>		
CV	CO2	10	CV	Argon Mix	41	<b>1.2mm Wire Size</b>			<b>1.0mm Wire Size</b>		
CV	Argon Mix	11	CV	Ar He CO2	43	CV	CO2	90	Pulse	Argon	192
Pulse	Argon Mix	12	Pulse	Ar He CO2	44	CV	Argon CO <sub>2</sub>	91	<b>Nickel Alloy</b>		
Pulse RapidArc	Argon CO <sub>2</sub>	13	Pulse	Argon CO <sub>2</sub>	46	<b>Metal Core</b>			<b>1.0mm Wire Size</b>		
<b>1.2mm Wire Size</b>			<b>General</b>			CV	Argon CO <sub>2</sub>	81	<b>1.2mm Wire Size</b>		
CV	CO2	20	<b>Stick/Tig/Gouge</b>			Pulse	Argon CO <sub>2</sub>	82	<b>Pulse</b>		
CV	Argon Mix	21	Stick Soft		1	Pulse 1.4mm	Argon CO <sub>2</sub>	82	Pulse	Argon He	175
Pulse	Argon Mix	22	Stick Crisp		2	<b>Copper</b>			<b>1.0mm Wire Size</b>		
Pulse RapidArc	Argon CO <sub>2</sub>	18	Stick Pipe		4	Pulse 1.0mm	Argon He	195	<b>1.2mm Wire Size</b>		
<b>Wire Welding (Non Synergic)</b>			Tig	Argon	3	Pulse 1.2mm	Argon He	196	<b>1.0mm Wire Size</b>		
			Tig - Pulse	Argon	8	<b>Flux Core</b>			<b>1.2mm Wire Size</b>		
			<b>Wire Welding (Non Synergic)</b>			<b>Flux Core</b>			<b>1.0mm Wire Size</b>		
			CV		5	<b>1.2mm Wire Size</b>			<b>1.0mm Wire Size</b>		
			FCAW-SS		6	<b>1.0mm Wire Size</b>			<b>1.2mm Wire Size</b>		
			FCAW-G		7	<b>1.2mm Wire Size</b>			<b>1.0mm Wire Size</b>		
			Power		40	<b>1.0mm Wire Size</b>			<b>1.2mm Wire Size</b>		



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				Pinch
7	FCAW-GS	CV				Pinch
8	GTAW-P	Tig - Pulse			Argon	Frequency, Background
10	GMAW	CV	1.0	Steel	CO <sub>2</sub>	Pinch
11	GMAW	CV	1.0	Steel	Argon CO <sub>2</sub>	Pinch
12	GMAW-P	Pulse	1.0	Steel	Argon CO <sub>2</sub>	UltimArc
13	GMAW-RA	Pulse - RapidArc	1.0	Steel	Argon CO <sub>2</sub>	UltimArc
14	GMAW	CV	0.9	Steel	CO <sub>2</sub>	Pinch
15	GMAW	CV	0.9	Steel	Argon CO <sub>2</sub>	Pinch
16	GMAW-P	Pulse	0.9	Steel	Argon CO <sub>2</sub>	UltimArc
17	GMAW-RA	Pulse - RapidArc	0.9	Steel	Argon CO <sub>2</sub>	UltimArc
18	GMAW-RA	Pulse - RapidArc	1.2	Steel	Argon CO <sub>2</sub>	UltimArc
20	GMAW	CV	1.2	Steel	CO <sub>2</sub>	Pinch
21	GMAW	CV	1.2	Steel	Argon CO <sub>2</sub>	Pinch
22	GMAW-P	Pulse	1.2	Steel	Argon CO <sub>2</sub>	UltimArc
31	GMAW	CV	1.0	Stainless	Argon CO <sub>2</sub>	Pinch
33	GMAW	CV	1.0	Stainless	80Ar18He2CO2	Pinch
34	GMAW-P	Pulse	1.0	Stainless	80Ar18He2CO2	UltimArc
36	GMAW-P	Pulse	1.0	Stainless	Argon CO <sub>2</sub>	UltimArc
40	GMAW	Power				Pinch
41	GMAW	CV	1.2	Stainless	Argon CO <sub>2</sub>	Pinch
43	GMAW	CV	1.2	Stainless	80Ar18He2CO2	Pinch
44	GMAW-P	Pulse	1.2	Stainless	80Ar18He2CO2	UltimArc
46	GMAW-P	Pulse	1.2	Stainless	Argon CO <sub>2</sub>	UltimArc
61	GMAW	CV	0.8	Stainless	Argon CO <sub>2</sub>	Pinch
63	GMAW	CV	0.8	Stainless	80Ar18He2CO2	Pinch
64	GMAW-P	Pulse	0.8	Stainless	80Ar18He2CO2	UltimArc
66	GMAW-P	Pulse	0.8	Stainless	Argon CO <sub>2</sub>	UltimArc
71	GMAW	CV	1.2	Aluminum 4043	Argon	UltimArc
72	GMAW-P	Pulse	1.2	Aluminum 4043	Argon	UltimArc
73	GMAW	CV	1.6	Aluminum 4043	Argon	UltimArc
74	GMAW-P	Pulse	1.6	Aluminum 4043	Argon	UltimArc
75	GMAW	CV	1.2	Aluminum 5356	Argon	UltimArc
76	GMAW-P	Pulse	1.2	Aluminum 5356	Argon	UltimArc
77	GMAW	CV	1.6	Aluminum 5356	Argon	UltimArc
78	GMAW-P	Pulse	1.6	Aluminum 5356	Argon	UltimArc
81	GMAW	CV	1.2	Metal Core	Argon CO <sub>2</sub>	Pinch
82	GMAW-P	Pulse	1.2	Metal Core	Argon CO <sub>2</sub>	UltimArc
84	GMAW-P	Pulse	1.4	Metal Core	Argon CO <sub>2</sub>	UltimArc
90	FCAW-GS	CV	1.2		CO <sub>2</sub>	Pinch
91	FCAW-GS	CV	1.2		Argon CO <sub>2</sub>	Pinch
93	GMAW	CV	0.8	Steel	CO <sub>2</sub>	Pinch
94	GMAW	CV	0.8	Steel	Argon CO <sub>2</sub>	Pinch
95	GMAW-P	Pulse	0.8	Steel	Argon CO <sub>2</sub>	UltimArc
98	GMAW-P	Pulse on Pulse	1.0	Aluminum 4043	Argon	UltimArc
99	GMAW-P	Pulse on Pulse	1.2	Aluminum 4043	Argon	UltimArc
100	GMAW-P	Pulse on Pulse	1.6	Aluminum 4043	Argon	UltimArc
101	GMAW-P	Pulse on Pulse	1.0	Aluminum 5356	Argon	UltimArc
102	GMAW-P	Pulse on Pulse	1.2	Aluminum 5356	Argon	UltimArc
103	GMAW-PP	Pulse on Pulse	1.6	Aluminum 5356	Argon	Frequency
151	GMAW	CV	1.0	Aluminum 5356	Argon	Pinch
152	GMAW-P	Pulse	1.0	Aluminum 5356	Argon	UltimArc
175	GMAW-P	Pulse	1.2	Ni Chrome	Argon He	UltimArc
192	GMAW-P	Pulse	1.0	Si Bronze	Argon	UltimArc
195	GMAW-P	Pulse	1.0	Copper	Argon He	UltimArc
196	GMAW-P	Pulse	1.2	Copper	Argon He	UltimArc



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