

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 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
31	GMAW	CV	1.0	Stainless	Argon CO ₂	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 ₂	UltimArc
40	GMAW	Power				Pinch
41	GMAW	CV	1.2	Stainless	Argon CO ₂	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 ₂	UltimArc
61	GMAW	CV	0.8	Stainless	Argon CO ₂	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 ₂	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 ₂	Pinch
82	GMAW-P	Pulse	1.2	Metal Core	Argon CO ₂	UltimArc
84	GMAW-P	Pulse	1.4	Metal Core	Argon CO ₂	UltimArc
90	FCAW-GS	CV	1.2		CO ₂	Pinch
91	FCAW-GS	CV	1.2		Argon CO ₂	Pinch
93	GMAW	CV	0.8	Steel	CO ₂	Pinch
94	GMAW	CV	0.8	Steel	Argon CO ₂	Pinch
95	GMAW-P	Pulse	0.8	Steel	Argon CO ₂	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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