



Weld Set Reference: Z103121

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	CO2	93	CV	Argon CO2	61	CV	Argon	148	CV	Argon	151
CV	Argon Mix	94	CV	He Ar CO2	63	Pulse	Argon	149	Pulse	Argon	152
Pulse	Argon Mix	95	Pulse	He Ar CO2	64	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	CO2	10	CV	Argon CO2	31	CV	Argon	71	CV	Argon	75
CV	Argon Mix	11	CV	He Ar CO2	33	Pulse	Argon	72	Pulse	Argon	76
Pulse	Argon Mix	12	CV	He Ar CO2	34	Pulse on Pulse	Argon	99	Pulse on Pulse	Argon	102
Pulse RapidArc	Argon CO2	13	Pulse	He Ar CO2	34	1/16 Wire Size			1/16 Wire Size		
Pulse Vertical Up	Argon Mix	16	Pulse	ArCO2/ArO2	36	1/16 Wire Size			1/16 Wire Size		
.040 Wire Size			Pulse Vertical Up	Argon CO2	38	Flux Core			Silicon Bronze		
CV	CO2	270	.045 Wire Size			.045 Wire Size			.035 Wire Size		
CV	Argon Mix	271	CV	Argon CO2	41	CV	CO2	90	Pulse	Argon Mix	192
Pulse	Argon Mix	272	CV	He Ar CO2	43	CV	Argon Mix	91	Nickel Alloy		
Pulse RapidArc	Argon CO2	273	Pulse	He Ar CO2	44	Metal Core			.035 Wire Size		
.045 Wire Size			Pulse	ArCO2/ArO2	46	.045 Wire Size			Pulse	Argon Helium	170
CV	CO2	20	Pulse Vertical Up	Argon CO2	48	CV	Argon Mix	81	.045 Wire Size		
CV	Argon Mix	21	General			Pulse	Argon Mix	82	.052 Wire Size		
Pulse	Argon Mix	22	Stick/Tig/Gouge			Pulse RapidArc	Argon CO2	87	CV	Argon Mix	83
Pulse RapidArc	Argon CO2	18	Stick Soft		1	.052 Wire Size			Pulse	Argon Mix	84
Pulse Vertical Up	Argon Mix	23	Stick Crisp		2	CV	Argon Mix	83	Pulse RapidArc	Argon CO2	88
.045 Wire Size			Stick Pipe		4	Copper			.045 Wire Size		
.045 Wire Size			Tig	Argon	3	.045 Wire Size			Pulse	Argon Helium	196
.045 Wire Size			Tig - Pulse	Argon	8	.045 Wire Size			THE WELDING EXPERTS		
.045 Wire Size			Wire Welding (Non Synergic)			.045 Wire Size			THE WELDING EXPERTS		
.045 Wire Size			CV		5	.045 Wire Size			THE WELDING EXPERTS		
.045 Wire Size			FCAW-SS	Self Shielded	6	.045 Wire Size			THE WELDING EXPERTS		
.045 Wire Size			FCAW-GS	Gas Shielded	7	.045 Wire Size			THE WELDING EXPERTS		
.045 Wire Size			Power Mode		40	.045 Wire Size			THE WELDING EXPERTS		



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
10	GMAW	CV	0.035	Steel	CO2	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
16	GMAW-P	Pulse - Vertical Up	0.035	Steel	Argon Blends	Frequency Offset
18	GMAW-P	Pulse - RapidArc	0.045	Steel	Argon Blends	UltimArc
20	GMAW	CV	0.045	Steel	CO2	Pinch
21	GMAW	CV	0.045	Steel	Argon Blends	Pinch
22	GMAW-P	Pulse	0.045	Steel	Argon Blends	UltimArc
23	GMAW-P	Pulse - Vertical Up	0.045	Steel	Argon Blends	Frequency Offset
31	GMAW	CV	0.035	Stainless	Argon Blends	Pinch
33	GMAW	CV	0.035	Stainless	He Ar CO2	Pinch
34	GMAW-P	Pulse	0.035	Stainless	He Ar CO2	UltimArc
36	GMAW-P	Pulse	0.035	Stainless	ArCO2/ArO2	UltimArc
38	GMAW-P	Pulse - Vertical Up	0.035	Stainless	Argon Blends	Frequency Offset
40	GMAW	Power Mode				Pinch
41	GMAW	CV	0.045	Stainless	Argon Blends	Pinch
43	GMAW	CV	0.045	Stainless	He Ar CO2	Pinch
44	GMAW-P	Pulse	0.045	Stainless	He Ar CO2	UltimArc
46	GMAW-P	Pulse	0.045	Stainless	ArCO2/ArO2	UltimArc
48	GMAW-P	Pulse - Vertical Up	0.045	Stainless	Argon Blends	Frequency Offset
61	GMAW	CV	0.030	Stainless	Argon Blends	Pinch
63	GMAW	CV	0.030	Stainless	He Ar CO2	Pinch
64	GMAW-P	Pulse	0.030	Stainless	He Ar CO2	UltimArc
66	GMAW-P	Pulse	0.030	Stainless	ArCO2/ArO2	UltimArc
71	GMAW	CV	3/64	Al 4043	Argon	Pinch
72	GMAW-P	Pulse	3/64	Al 4043	Argon	UltimArc
75	GMAW	CV	3/64	Al 5356	Argon	Pinch
76	GMAW-P	Pulse	3/64	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		CO2	Pinch
91	FCAW-GS	CV	0.045		Argon CO2	Pinch
93	GMAW	CV	0.030	Steel	CO2	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
101	GMAW-PP	Pulse on Pulse	0.035	Al 5356	Argon	Frequency
102	GMAW-PP	Pulse on Pulse	3/64	Al 5356	Argon	Frequency
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
196	GMAW-P	Pulse	0.045	Copper	Helium Argon	UltimArc
270	GMAW	CV	0.040	Steel	CO2	Pinch
271	GMAW	CV	0.040	Steel	Argon Blends	Pinch
272	GMAW-P	Pulse	0.040	Steel	Argon Blends	UltimArc
273	GMAW-P	Pulse - RapidArc	0.040	Steel	Argon Blends	UltimArc



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