



### WELDING

METAL	SHIELDING GAS	MODE	WELD DEPTH			
			0.040" (1.0mm)	0.080" (2.0mm)	0.120" (3.0mm)	0.160" (4.0mm)
STAINLESS STEEL	NITROGEN	CW	A1	A2	A3	A4
		M	C1	C2	C3	-
		W	A6	A7	A8	A9
MILD STEEL	NITROGEN	CW	E1	E2	E3	E4
		M	F1	F2	F3	-
		W	E6	E7	E8	-
GALVANIZED STEEL	NITROGEN	CW	-	-	-	-
		M	J1	J2	J3	-
		W	-	-	-	-
ALUMINUM 3XXX	ARGON	CW	-	-	-	-
		M	H1	H2	H3	H4
		W	-	-	-	-
ALUMINUM 5XXX	ARGON	CW	-	-	-	-
		M	L1	L2	L3	L4
		W	L6	L7	L8	L9

### CLEANING

MODE	INTENSITY	
	Low	High
C	P1	P2
C	P2	P3
C	P2	P3
C	U0	U1
C	U0	U1

### TACK

METAL	SHIELDING GAS	MODE	PROGRAM	TACK DEPTH			
				0.040" (1.0mm)	0.080" (2.0mm)	0.120" (3.0mm)	0.160" (4.0mm)
STAINLESS STEEL	NITROGEN	T	A5	300 W	550 W	800 W	1150 W
MILD STEEL	NITROGEN	T	E5	400 W	650 W	900 W	1250 W
ALUMINUM 5XXX	ARGON	T	L5	700 W	800 W	1100 W	1500 W

1) SELECT THE TACK PROGRAM 2) ADJUST POWER CONTROL TO MATCH DESIRED TACK DEPTH



**Continuous Wave:**  
Maximum penetration  
& travel speed



**Modulation:**  
Reduced energy for slower  
welding with less heat input



**Tack:**  
Small and temporary welds  
that hold parts together for  
final welding



**Wire Welding**  
Used when filler material is  
required to help bridge gaps  
or produce fillet weld



**Cleaning**  
Pre & post weld joint cleaning  
to improve weld quality,  
consistency, & appearance

Cleaning Presets & Wire Feeder Programs require optional hardware (LightWELD XC & Wire Feeder respectively)



### WELDING NOZZLE SELECTION

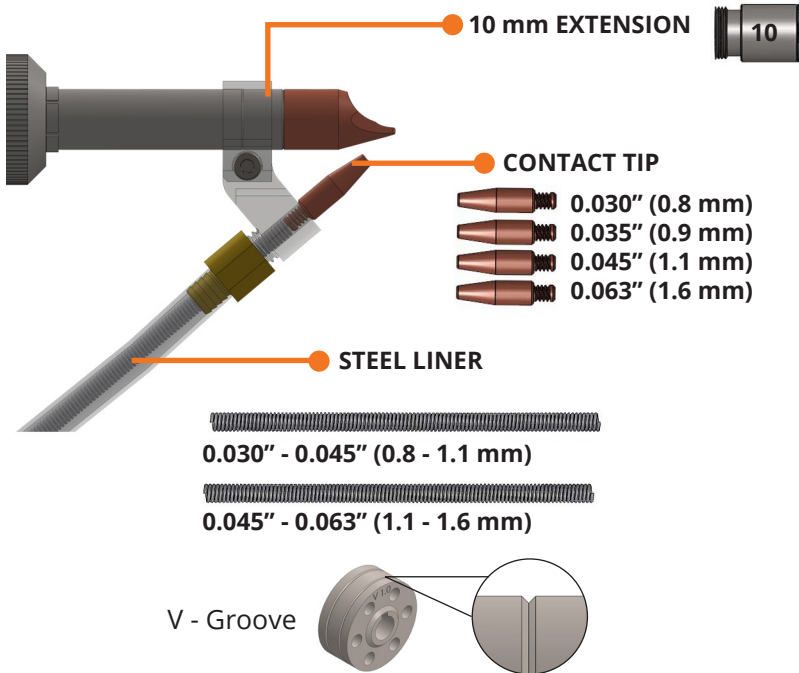
Butt Joint	Corner Joint	Tee Joint	Lap Joint	Edge Joint

### CLEANING NOZZLE SELECTION

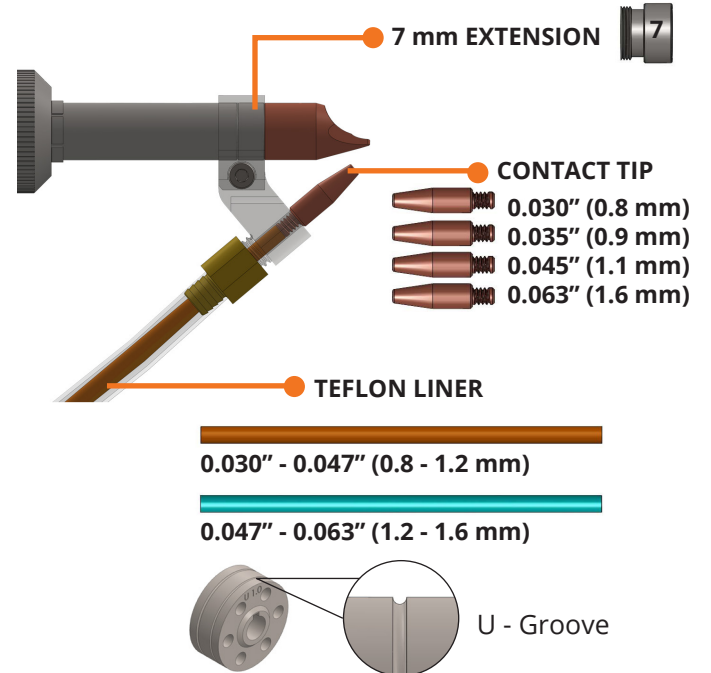
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### WIRE WELDING CONFIGURATIONS & PARAMETERS

#### HARD WIRE



#### SOFT WIRE



#### RECOMMENDED PARAMETERS

METAL	WIRE ALLOY	WIRE DIAMETER	SHIELDING GAS	WIRE FEED RATE (PROGRAM)			
				0.040" (1.0mm)	0.080" (2.0mm)	0.120" (3.0mm)	0.160" (4.0mm)
STAINLESS STEEL	308LSi	0.045" (1.1 mm)	NITROGEN	70 (A6)	65 (A7)	60 (A8)	50 (A9)
MILD STEEL	ER70S-6	0.045" (1.1 mm)	NITROGEN	70 (E6)	65 (E7)	60 (E8)	-
ALUMINUM 5XXX	ER5356	0.047" (1.2 mm)	ARGON	90 (L6)	80 (L7)	70 (L8)	60 (L9)

Cleaning Presets & Wire Feeder Presets require optional hardware (LightWELD XC & Wire Feeder respectively)