# Weld Set Reference: Z264731
# Speedtec® 400S/500S

** Maximum Range is limited by power source rating or feeder configuration*

| | Type | Size | Procedure | Waveform | Gas Type | Mode # | Arc Control | Max. Range (*) |
|---|---|---|---|---|---|---|---|---|
| GMAW | All | All | GMAW CV | GMAW CV | | **5** | Pinch, Hot Start | 10 — 45 V |
| | Steel | 0.8mm | GMAW CV | CV | 100% CO2 | **11** | Pinch | 2.54 — 20.32 m/min (100 — 800 ipm) |
| | | | | | 82% Ar 18% CO2 | **10** | | 1.91 — 20.32 m/min (75 — 800 ipm) |
| | | | | | 92% Ar 8% CO2 | **1034** | | 1.91 — 20.32 m/min (75 — 800 ipm) |
| | | | | SSA | 82% Ar 18% CO2 | **12** | | 2.54 — 20.32 m/min (100 — 800 ipm) |
| | | | | | 92% Ar 8% CO2 | **1036** | | 2.54 — 20.32 m/min (100 — 800 ipm) |
| | | | GMAW Pulse | Pulse | 82% Ar 18% CO2 | **14** | UltimArc | 1.91 — 22.86 m/min (75 — 900 ipm) |
| | | | | | 92% Ar 8% CO2 | **1038** | | 1.91 — 22.86 m/min (75 — 900 ipm) |
| | | | | | 95% Ar 5% O2 | **15** | | 2.54 — 20.32 m/min (100 — 800 ipm) |
| | | | | SSP | 82% Ar 18% CO2 | **16** | | 1.91 — 17.78 m/min (75 — 700 ipm) |
| | | | | | 92% Ar 8% CO2 | **1040** | | 1.91 — 17.78 m/min (75 — 700 ipm) |
| | | | | | 95% Ar 5% O2 | **17** | | 3.81 — 20.32 m/min (150 — 800 ipm) |
| | | 1.0mm | GMAW CV | CV | 100% CO2 | **37** | Pinch | 1.52 — 20.32 m/min (60 — 800 ipm) |
| | | | | | 82% Ar 18% CO2 | **36** | | 1.52 — 21.84 m/min (60 — 860 ipm) |
| | | | | | 92% Ar 8% CO2 | **1060** | | 1.52 — 21.84 m/min (60 — 860 ipm) |
| | | | | HPS | 82% Ar 18% CO2 | **39** | | 10.16 — 21.97 m/min (400 — 865 ipm) |
| | | | | | 92% Ar 8% CO2 | **1063** | | 10.16 — 21.97 m/min (400 — 865 ipm) |
| | | | | SSA | 82% Ar 18% CO2 | **38** | | 1.52 — 12.7 m/min (60 — 500 ipm) |
| | | | | | 92% Ar 8% CO2 | **1062** | | 1.52 — 12.7 m/min (60 — 500 ipm) |
| | | | GMAW Pulse | Pulse | 82% Ar 18% CO2 | **40** | UltimArc | 1.91 — 22.86 m/min (75 — 900 ipm) |
| | | | | | 92% Ar 8% CO2 | **1064** | | 1.91 — 22.86 m/min (75 — 900 ipm) |
| | | | | | 95% Ar 5% O2 | **41** | | 1.91 — 22.86 m/min (75 — 900 ipm) |
| | | | | SSP | 82% Ar 18% CO2 | **42** | | 1.91 — 20.32 m/min (75 — 800 ipm) |
| | | | | | 92% Ar 8% CO2 | **1066** | | 1.91 — 20.32 m/min (75 — 800 ipm) |
| | | | | | 95% Ar 5% O2 | **43** | | 1.91 — 20.32 m/min (75 — 800 ipm) |
| | | 1.2mm | GMAW CV | CV | 100% CO2 | **50** | Pinch | 1.52 — 20.32 m/min (60 — 800 ipm) |
| | | | | | 82% Ar 18% CO2 | **49** | | 1.52 — 20.32 m/min (60 — 800 ipm) |
| | | | | | 92% Ar 8% CO2 | **1073** | | 1.52 — 20.32 m/min (60 — 800 ipm) |
| | | | | HPS | 82% Ar 18% CO2 | **52** | | 8.89 — 19.05 m/min (350 — 750 ipm) |
| | | | | | 92% Ar 8% CO2 | **1076** | | 8.89 — 19.05 m/min (350 — 750 ipm) |
| | | | | SSA | 82% Ar 18% CO2 | **51** | | 1.52 — 10.16 m/min (60 — 400 ipm) |
| | | | | | 92% Ar 8% CO2 | **1075** | | 1.52 — 10.16 m/min (60 — 400 ipm) |
| | | | GMAW Pulse | Pulse | 82% Ar 18% CO2 | **53** | UltimArc | 1.91 — 17.78 m/min (75 — 700 ipm) |
| | | | | | 92% Ar 8% CO2 | **1077** | | 1.91 — 17.78 m/min (75 — 700 ipm) |
| | | | | | 95% Ar 5% O2 | **54** | | 1.91 — 17.78 m/min (75 — 700 ipm) |
| | | | | SSP | 82% Ar 18% CO2 | **55** | | 1.91 — 17.78 m/min (75 — 700 ipm) |
| | | | | | 92% Ar 8% CO2 | **1079** | | 1.91 — 17.78 m/min (75 — 700 ipm) |
| | | | | | 95% Ar 5% O2 | **56** | | 1.91 — 17.78 m/min (75 — 700 ipm) |
| | | 1.6mm | GMAW CV | CV | 100% CO2 | **78** | Pinch | 1.52 — 8.89 m/min (60 — 350 ipm) |
| | | | | | 82% Ar 18% CO2 | **77** | | 1.52 — 8.89 m/min (60 — 350 ipm) |
| | | | | | 92% Ar 8% CO2 | **1101** | | 1.52 — 8.89 m/min (60 — 350 ipm) |
| | | | | HPS | 82% Ar 18% CO2 | **80** | | 5.72 — 8.89 m/min (225 — 350 ipm) |
| | | | GMAW Pulse | Pulse | 82% Ar 18% CO2 | **81** | UltimArc | 1.52 — 8.89 m/min (60 — 350 ipm) |
| | | | | | 92% Ar 8% CO2 | **1105** | | 1.52 — 8.89 m/min (60 — 350 ipm) |
| | | | | SSP | 82% Ar 18% CO2 | **83** | | 1.52 — 8.89 m/min (60 — 350 ipm) |
| | | | | | 92% Ar 8% CO2 | **1107** | | 1.52 — 8.89 m/min (60 — 350 ipm) |
| | MCW Steel | 1.0mm | GMAW CV | CV | 82% Ar 18% CO2 | **164** | Pinch | 1.52 — 21.84 m/min (60 — 860 ipm) |
| | | | GMAW Pulse | Pulse | 82% Ar 18% CO2 | **165** | UltimArc | 1.91 — 15.24 m/min (75 — 600 ipm) |
| | | 1.2mm | GMAW CV | CV | 82% Ar 18% CO2 | **168** | Pinch | 1.52 — 17.78 m/min (60 — 700 ipm) |
| | | | GMAW Pulse | Pulse | 82% Ar 18% CO2 | **169** | UltimArc | 1.91 — 15.24 m/min (75 — 600 ipm) |
| | | 1.4mm | GMAW CV | CV | 82% Ar 18% CO2 | **174** | Pinch | 1.52 — 15.24 m/min (60 — 600 ipm) |
| | | | GMAW Pulse | Pulse | 82% Ar 18% CO2 | **175** | UltimArc | 1.91 — 15.24 m/min (75 — 600 ipm) |
| | | 1.6mm | GMAW CV | CV | 82% Ar 18% CO2 | **180** | Pinch | 1.52 — 10.16 m/min (60 — 400 ipm) |
| | | | GMAW Pulse | Pulse | 82% Ar 18% CO2 | **181** | UltimArc | 1.52 — 8.89 m/min (60 — 350 ipm) |
| | 3XX Stainless | 0.8mm | GMAW CV | CV | 98% Ar 2% CO2 | **85** | Pinch | 2.54 — 20.32 m/min (100 — 800 ipm) |
| | | | | SSA | 98% Ar 2% CO2 | **86** | | 2.54 — 20.32 m/min (100 — 800 ipm) |
| | | | GMAW Pulse | Pulse | 98% Ar 2% CO2 | **87** | UltimArc | 1.91 — 20.32 m/min (75 — 800 ipm) |
| | | 1.0mm | GMAW CV | CV | 98% Ar 2% CO2 | **100** | Pinch | 1.91 — 20.32 m/min (75 — 800 ipm) |
| | | | | SSA | 98% Ar 2% CO2 | **101** | | 1.52 — 15.24 m/min (60 — 600 ipm) |
| | | | GMAW Pulse | SSP | 98% Ar 2% CO2 | **103** | UltimArc | 2.54 — 17.78 m/min (100 — 700 ipm) |
| | | 1.2mm | GMAW CV | CV | 98% Ar 2% CO2 | **108** | Pinch | 1.91 — 17.78 m/min (75 — 700 ipm) |
| | | | | SSA | 98% Ar 2% CO2 | **109** | | 1.52 — 12.7 m/min (60 — 500 ipm) |
| | | | GMAW Pulse | SSP | 98% Ar 2% CO2 | **111** | UltimArc | 1.91 — 15.24 m/min (75 — 600 ipm) |
| | AlSi | 1.0mm | GMAW CV | CV | 100% Ar | **129** | Pinch | 3.81 — 17.78 m/min (150 — 700 ipm) |
| | | | GMAW Pulse | Pulse | 100% Ar | **130** | UltimArc | 3.81 — 17.78 m/min (150 — 700 ipm) |
| | | | | SSP | 100% Ar | **131** | | 3.81 — 17.78 m/min (150 — 700 ipm) |
| | | 1.2mm | GMAW CV | CV | 100% Ar | **134** | Pinch | 3.81 — 15.24 m/min (150 — 600 ipm) |
| | | | GMAW Pulse | Pulse | 100% Ar | **135** | UltimArc | 2.54 — 15.24 m/min (100 — 600 ipm) |
| | | | | SSP | 100% Ar | **136** | | 2.54 — 12.7 m/min (100 — 500 ipm) |
| | | 1.6mm | GMAW CV | CV | 100% Ar | **139** | Pinch | 2.54 — 9.53 m/min (100 — 375 ipm) |
| | | | GMAW Pulse | Pulse | 100% Ar | **140** | UltimArc | 1.91 — 8.89 m/min (75 — 350 ipm) |
| | | | | SSP | 100% Ar | **141** | | 1.91 — 8.89 m/min (75 — 350 ipm) |
| | AlMg | 1.0mm | GMAW CV | CV | 100% Ar | **147** | Pinch | 3.81 — 20.32 m/min (150 — 800 ipm) |
| | | | GMAW Pulse | Pulse | 100% Ar | **148** | UltimArc | 2.54 — 20.32 m/min (100 — 800 ipm) |
| | | | | SSP | 100% Ar | **149** | | 3.81 — 17.78 m/min (150 — 700 ipm) |
| | | 1.2mm | GMAW CV | CV | 100% Ar | **152** | Pinch | 3.81 — 20.32 m/min (150 — 800 ipm) |
| | | | GMAW Pulse | Pulse | 100% Ar | **153** | UltimArc | 2.16 — 17.78 m/min (85 — 700 ipm) |
| | | | | SSP | 100% Ar | **154** | | 2.54 — 15.24 m/min (100 — 600 ipm) |
| | | 1.6mm | GMAW CV | CV | 100% Ar | **157** | Pinch | 3.81 — 10.16 m/min (150 — 400 ipm) |
| | | | GMAW Pulse | Pulse | 100% Ar | **158** | UltimArc | 1.91 — 12.07 m/min (75 — 475 ipm) |

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| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| GMAW | AlMg | 1.6mm | GMAW Pulse | SSP | 100% Ar | **159** | UltimArc | 1.91 — 10.16 m/min (75 — 400 ipm) |
| | CuSi 69 | 1.0mm | GMAW CV | CV | 100% Ar | **188** | Pinch | 2.54 — 12.7 m/min (100 — 500 ipm) |
| | CuAl | 1.0mm | GMAW CV | CV | 100% Ar | **215** | Pinch | 2.54 — 12.7 m/min (100 — 500 ipm) |
| | | | GMAW Pulse | Pulse | 100% Ar | **216** | UltimArc | 1.91 — 12.7 m/min (75 — 500 ipm) |
| | | 1.2mm | GMAW CV | CV | 100% Ar | **218** | Pinch | 2.54 — 12.7 m/min (100 — 500 ipm) |
| | | | GMAW Pulse | Pulse | 100% Ar | **219** | UltimArc | 1.91 — 12.7 m/min (75 — 500 ipm) |

| | Type | Size | Procedure | Waveform | Gas Type | Mode # | Arc Control | Max. Range (*) |
|---|---|---|---|---|---|---|---|---|
| FCAW | All | All | FCAW-S CV | FCAW-S | NA | **6** | Pinch, Hot Start | 10 — 45 V |
| | | | FCAW-G CV | FCAW-G | | **7** | Pinch, Hot Start | 10 — 45 V |
| | Cored Wire | 1.2mm | FCAW-G CV | CV | 100% $CO_2$ | **232** | Pinch | 4.45 — 21.97 m/min (175 — 865 ipm) |
| | | | | | 82% Ar 18% $CO_2$ | **231** | | 4.45 — 15.24 m/min (175 — 600 ipm) |
| | | 1.6mm | FCAW-G CV | CV | 100% $CO_2$ | **241** | Pinch | 2.54 — 12.7 m/min (100 — 500 ipm) |
| | | | | | 82% Ar 18% $CO_2$ | **240** | | 3.18 — 10.16 m/min (125 — 400 ipm) |

| | Type | Size | Procedure | Waveform | Gas Type | Mode # | Arc Control | Max. Range (*) |
|---|---|---|---|---|---|---|---|---|
| SMAW | Stick | All | SMAW | Stick MMA | NA | **1** | Arc Force, Hot Start | 15 — 500 A |

| | Type | Size | Procedure | Waveform | Gas Type | Mode # | Arc Control | Max. Range (*) |
|---|---|---|---|---|---|---|---|---|
| GTAW | N/A | All | GTAW | GTAW | He / Ar | **3** | Frequency, Background | 4 — 500 A |

| | Type | Size | Procedure | Waveform | Gas Type | Mode # | Arc Control | Max. Range (*) |
|---|---|---|---|---|---|---|---|---|
| CAG | Carbon Arc | All | GOUGE | Arc Gouge | NA | **9** | | 60 — 500 A |