

Ultramag® S4

Typical Operating Procedures

Diameter, Polarity Shielding Gas	CTWD mm	Wire Feed Speed in/min	Voltage volts	Current amps
0.9mm DC+				
Short Circuit Transfer C1	10-12	100	18	80
		150	19	120
		250	22	175
Spray Transfer M21	12-19	375	23	195
		500	29	230
		600	30	275
1.2mm DC+				
Short Circuit Transfer C1	12-19	125	19	145
		150	20	165
		200	21	200
Spray Transfer M21	12-19	350	27	285
		475	30	335