Power Wave F355i

Weld Set Reference: Z050114F

Steel

Procedure	Gas Type	Mode
.030 Wire Size		
CV	CO_2	93
CV	Argon Mix	94
Pulse	Argon Mix	95
.035 Wire Size		
CV	CO_2	10
CV	Argon Mix	11
Pulse Crisp	Argon Mix	12
Pulse Soft	Argon Mix	14
Pulse RapidArc	Argon CO_2	13
.045 Wire Size		
CV	CO_2	20
CV	Argon Mix	21
Pulse Crisp	Argon Mix	22
Pulse Soft	Argon Mix	19
Pulse RapidArc	Argon CO_2	18
.052 Wire Size		
CV	CO_2	24
CV	Argon Mix	25
Pulse Crisp	Argon Mix	26
Pulse Soft	Argon Mix	28
Pulse RapidArc	Argon CO_2	27

Stainless

Procedure	Gas Type	Mode
.030 Wire Size		
CV	Argon Mix	61
CV	He Ar CO_2	63
Pulse	He Ar CO_2	64
Pulse	Argon CO_2	66
Pulse	Argon O_2	62
.035 Wire Size		
CV	Argon Mix	31
CV	He Ar CO_2	33
Pulse	He Ar CO_2	34
Pulse	Argon CO_2	36
Pulse	Argon O_2	32
.045 Wire Size		
CV	Argon Mix	41
CV	He Ar CO_2	43
Pulse	He Ar CO_2	44
Pulse	Argon CO_2	46
Pulse	Argon O_2	42

Nickel Alloy

.035 Wire Size		
Pulse	Ar He	170
.045 Wire Size		
Pulse	Ar He	175

Silicon Bronze

.035 Wire Size		
Pulse	Argon	192

Aluminum 4043

Procedure	Gas Type	Mode
.035 Wire Size		
CV	Argon	148
Pulse	Argon	149
Pulse on Pulse	Argon	98
3/64 Wire Size		
CV	Argon	71
Pulse	Argon	72
Pulse on Pulse	Argon	99
1/16 Wire Size		
CV	Argon	73
Pulse	Argon	74
Pulse on Pulse	Argon	100

Metal Core

.045 Wire Size		
CV	Argon CO_2	81
Pulse	Argon CO_2	82
Pulse RapidArc	Argon CO_2	87
.052 Wire Size		
CV	Argon CO_2	83
Pulse	Argon CO_2	84
Pulse RapidArc	Argon CO_2	88
1/16 Wire Size		
Pulse RapidArc	Argon CO_2	89

Aluminum 5356

Procedure	Gas Type	Mode
.035 Wire Size		
CV	Argon	151
Pulse	Argon	152
Pulse on Pulse	Argon	101
3/64 Wire Size		
CV	Argon	75
Pulse	Argon	76
Pulse on Pulse	Argon	102
1/16 Wire Size		
CV	Argon	77
Pulse	Argon	78
Pulse on Pulse	Argon	103

General

Wire Welding (Non Synergic)		
CV MIG		5
FCAW-SS	Self Shielded	6
Power mode		40

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THE WELDING EXPERTS

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CONTENTS OF WELDING SOFTWARE Z050114f

Mode	Process	Procedure	Wire Size	Wire Type	Gas	ArcControl	
5	GMAW	CV MIG (NonSyn)				Pinch	
6	FCAW-SS	FCAW-SS (NonSyn)			Self Shielded	Pinch	
10	GMAW	CV	.035"	Steel	CO2	Pinch	
11	GMAW	CV	.035"	Steel	Argon Blends	Pinch	
12	GMAW-P	Pulse - Crisp	.035"	Steel	Argon Blends	Wave Control	
13	GMAW-P	Pulse - RapidArc	.035"	Steel	Argon CO2 Blends	Wave Control	
14	GMAW-P	Pulse - Soft	.035"	Steel	Argon Blends	Wave Control	
18	GMAW-P	Pulse - RapidArc	.045"	Steel	Argon CO2 Blends	Wave Control	
19	GMAW-P	Pulse - Soft	.045"	Steel	Argon Blends	Wave Control	
20	GMAW	CV	.045"	Steel	CO2	Pinch	
21	GMAW	CV	.045"	Steel	Argon Blends	Pinch	
22	GMAW-P	Pulse - Crisp	.045"	Steel	Argon Blends	Wave Control	
24	GMAW	CV	.052"	Steel	CO2	Pinch	
25	GMAW	CV	.052"	Steel	Argon Blends	Pinch	
26	GMAW-P	Pulse - Crisp	.052"	Steel	Argon Blends	Wave Control	
27	GMAW-P	Pulse - RapidArc	.052"	Steel	Argon CO2 Blends	Wave Control	
28	GMAW-P	Pulse - Soft	.052"	Steel	Argon Blends	Wave Control	
31	GMAW	CV	.035"	Stainless	Argon Blends	Pinch	
32	GMAW-P	Pulse	.035"	Stainless	Argon O2	Wave Control	
33	GMAW	CV	.035"	Stainless	Helium Argon CO2	Pinch	
34	GMAW-P	Pulse	.035"	Stainless	Helium Argon CO2	Wave Control	
36	GMAW-P	Pulse	.035"	Stainless	Argon Blends	Wave Control	
40	GMAW	Power Mode (NonSyn)				Pinch	N.A.
41	GMAW	CV	.045"	Stainless	Argon Blends	Pinch	
42	GMAW-P	Pulse	.045"	Stainless	Argon O2	Wave Control	
43	GMAW	CV	.045"	Stainless	Helium Argon CO2	Pinch	
44	GMAW-P	Pulse	.045"	Stainless	Helium Argon CO2	Wave Control	
46	GMAW-P	Pulse	.045"	Stainless	Argon CO2 Blends	Wave Control	
61	GMAW	CV	.030"	Stainless	Argon Blends	Pinch	
62	GMAW-P	Pulse	.030"	Stainless	Argon O2	Wave Control	
63	GMAW	CV	.030"	Stainless	Helium Argon CO2	Pinch	
64	GMAW-P	Pulse	.030"	Stainless	Helium Argon CO2	Wave Control	
66	GMAW-P	Pulse	.030"	Stainless	Argon CO2 Blends	Wave Control	
71	GMAW	CV	3/64"	Aluminum (4043)	Argon	Pinch	
72	GMAW-P	Pulse	3/64"	Aluminum (4043)	Argon	Wave Control	
73	GMAW	CV	1/16"	Aluminum (4043)	Argon	Pinch	
74	GMAW-P	Pulse	1/16"	Aluminum (4043)	Argon	Wave Control	
75	GMAW	CV	3/64"	Aluminum (5356)	Argon	Pinch	
76	GMAW-P	Pulse	3/64"	Aluminum (5356)	Argon	Wave Control	
77	GMAW	CV	1/16"	Aluminum (5356)	Argon	Pinch	
78	GMAW-P	Pulse	1/16"	Aluminum (5356)	Argon	Wave Control	
81	GMAW	CV	.045"	Metal Core	Argon CO2 Blends	Pinch	
82	GMAW-P	Pulse	.045"	Metal Core	Argon CO2 Blends	Wave Control	
83	GMAW	CV	.052"	Metal Core	Argon CO2 Blends	Pinch	
84	GMAW-P	Pulse	.052"	Metal Core	Argon CO2 Blends	Wave Control	
87	GMAW-P	Pulse - RapidArc	.045"	Metal Core	Argon CO2 Blends	Wave Control	
88	GMAW-P	Pulse - RapidArc	.052"	Metal Core	Argon CO2 Blends	Wave Control	
89	GMAW-P	Pulse - RapidArc	1/16"	Metal Core	Argon CO2 Blends	Wave Control	
93	GMAW	CV	.030"	Steel	CO2	Pinch	
94	GMAW	CV	.030"	Steel	Argon Blends	Pinch	
95	GMAW-P	Pulse	.030"	Steel	Argon Blends	Wave Control	
98	GMAW-P	Pulse on Pulse	.035"	Aluminum (4043)	Argon	Modulation Freq	
99	GMAW-P	Pulse on Pulse	3/64"	Aluminum (4043)	Argon	Modulation Freq	
100	GMAW-P	Pulse on Pulse	1/16"	Aluminum (4043)	Argon	Modulation Freq	
101	GMAW-P	Pulse on Pulse	.035"	Aluminum (5356)	Argon	Modulation Freq	
102	GMAW-P	Pulse on Pulse	3/64"	Aluminum (5356)	Argon	Modulation Freq	
103	GMAW-P	Pulse on Pulse	1/16"	Aluminum (5356)	Argon	Modulation Freq	
148	GMAW	CV	.035"	Aluminum (4043)	Argon	Pinch	
149	GMAW-P	Pulse	.035"	Aluminum (4043)	Argon	Wave Control	
151	GMAW	CV	.035"	Aluminum (5356)	Argon	Pinch	
152	GMAW-P	Pulse	.035"	Aluminum (5356)	Argon	Wave Control	
170	GMAW-P	Pulse - NonAdaptive	.035"	Ni Alloy	Argon Helium	Wave Control	
175	GMAW-P	Pulse - NonAdaptive	.045"	Ni Alloy	Argon Helium	Wave Control	
192	GMAW-P	Pulse	.035"	Si Bronze	Argon	Wave Control	

Notes:

All GMAW-P procedures accept Trim input of 1.00 ± 0.50 (2 decimal places) and have been optimized for robotic welding
This may require reselecting the weld mode on the teach pendant and adjusting trim values when updating from earlier weld sets.

N.A. Power Mode workpoints have been modified to approximate actual power and match scaling of other Power Wave products.
Procedures based on earlier F355i Power Mode workpoints may require modification.

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