



Power Wave 355M

Weld Set Reference: Z123322L

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	CO ₂	93	CV	Argon Mix	61	CV	Argon	148	CV	Argon	151
CV	Argon Mix	94	CV	He Ar CO ₂	63	Pulse	Argon	149	Pulse	Argon	152
Pulse	Argon Mix	95	Pulse	He Ar CO ₂	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	CO ₂	10	CV	Argon Mix	31	CV	Argon	71	CV	Argon	75
CV	Argon Mix	11	CV	He Ar CO ₂	33	Pulse	Argon	72	Pulse	Argon	76
Pulse Crisp	Argon Mix	12	Pulse	He Ar CO ₂	34	Pulse on Pulse	Argon	99	Pulse on Pulse	Argon	102
Pulse Soft	Argon Mix	14	Pulse	Argon CO ₂	36	1/16 Wire Size			1/16 Wire Size		
Pulse RapidArc	Argon CO ₂	13	Pulse	Argon O ₂	32	CV	Argon	73	CV	Argon	77
.045 Wire Size			.045 Wire Size			Metal Core			Nickel Alloy		
CV	CO ₂	20	CV	Argon Mix	41	.045 Wire Size			.035 Wire Size		
CV	Argon Mix	21	CV	He Ar CO ₂	43	CV	Argon CO ₂	81	Pulse	Ar He	170
Pulse Crisp	Argon Mix	22	Pulse	He Ar CO ₂	44	Pulse	Argon CO ₂	82	.045 Wire Size		
Pulse Soft	Argon Mix	19	Pulse	Argon CO ₂	46	Pulse RapidArc	Argon CO ₂	87	Pulse	Ar He	175
Pulse RapidArc	Argon CO ₂	18	Pulse	Argon O ₂	42	.052 Wire Size			Silicon Bronze		
.052 Wire Size			General			.052 Wire Size			.035 Wire Size		
CV	CO ₂	24	Stick/Tig/Gouge			CV	Argon CO ₂	83	Pulse	Argon	192
CV	Argon Mix	25	Stick Soft		1	Pulse	Argon CO ₂	84	1/16 Wire Size		
Pulse Crisp	Argon Mix	26	Stick Crisp		2	Pulse RapidArc	Argon CO ₂	88	1/16 Wire Size		
Pulse Soft	Argon Mix	28	Touch Start TIG	Argon	3	1/16 Wire Size			1/16 Wire Size		
Pulse RapidArc	Argon CO ₂	27	Gouging		9	Pulse RapidArc	Argon CO ₂	89	1/16 Wire Size		
.052 Wire Size			Wire Welding (Non Synergic)			1/16 Wire Size			1/16 Wire Size		
.052 Wire Size			CV MIG		5	1/16 Wire Size			1/16 Wire Size		
.052 Wire Size			FCAW-SS	Self Shielded	6	1/16 Wire Size			1/16 Wire Size		
.052 Wire Size			Power mode		40	1/16 Wire Size			1/16 Wire Size		



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Mode	Process	Procedure	Wire Size	Wire Type	Gas Type	Range	ArcControl
1	SMAW	Stick Soft				40 - 400 A	Arc Force
2	SMAW	Stick Crisp				40 - 400 A	Arc Force
3	GTAW	Touch Start TIG			Argon	5 - 425 A	
5	GMAW	CV MIG (Non Syn)				10.0 - 45.0 V	Pinch
6	FCAW-S	FCAW-SS (Non Syn)			Self Shielded	10.0 - 45.0 V	Pinch
9	GOUGING	Arc Gouging				60 - 400 A	
10	GMAW	CV	0.035	Steel	CO2	50 - 1200 ipm	Pinch
11	GMAW	CV	0.035	Steel	Argon	50 - 1200 ipm	Pinch
12	GMAW-P	Pulse - Crisp	0.035	Steel	Argon Blends	100 - 800 ipm	Wave Control
13	GMAW-P	Pulse - RapidArc	0.035	Steel	Argon CO2	100 - 800 ipm	Wave Control
14	GMAW-P	Pulse - Soft	0.035	Steel	Argon Blends	100 - 800 ipm	Wave Control
18	GMAW-P	Pulse - RapidArc	0.045	Steel	Argon CO2	100 - 600 ipm	Wave Control
19	GMAW-P	Pulse - Soft	0.045	Steel	Argon Blends	50 - 600 ipm	Wave Control
20	GMAW	CV	0.045	Steel	CO2	75 - 800 ipm	Pinch
21	GMAW	CV	0.045	Steel	Argon Blends	50 - 800 ipm	Pinch
22	GMAW-P	Pulse - Crisp	0.045	Steel	Argon Blends	50 - 600 ipm	Wave Control
24	GMAW	CV	0.052	Steel	CO2	50 - 600 ipm	Pinch
25	GMAW	CV	0.052	Steel	Argon Blends	50 - 600 ipm	Pinch
26	GMAW-P	Pulse - Crisp	0.052	Steel	Argon Blends	85 - 500 ipm	Wave Control
27	GMAW-P	Pulse - RapidArc	0.052	Steel	Argon CO2	100 - 500 ipm	Wave Control
28	GMAW-P	Pulse - Soft	0.052	Steel	Argon Blends	75 - 500 ipm	Wave Control
31	GMAW	CV	0.035	Stainless	Argon Blends	75 - 800 ipm	Pinch
32	GMAW-P	Pulse	0.035	Stainless	Argon Oxy	65 - 770 ipm	Wave Control
33	GMAW	CV	0.035	Stainless	He Ar CO2	75 - 800 ipm	Pinch
34	GMAW-P	Pulse	0.035	Stainless	He Ar CO2	75 - 770 ipm	Wave Control
36	GMAW-P	Pulse	0.035	Stainless	Argon CO2	65 - 770 ipm	Wave Control
40	GMAW	Power Mode (Non Syn)				0.1 - 12.5 kw	Pinch
41	GMAW	CV	0.045	Stainless	Argon Blends	50 - 700 ipm	Pinch
42	GMAW-P	Pulse	0.045	Stainless	Argon Oxy	50 - 600 ipm	Wave Control
43	GMAW	CV	0.045	Stainless	He Ar CO2	50 - 700 ipm	Pinch
44	GMAW-P	Pulse	0.045	Stainless	He Ar CO2	50 - 600 ipm	Wave Control
46	GMAW-P	Pulse	0.045	Stainless	Argon CO2	60 - 550 ipm	Wave Control
61	GMAW	CV	0.030	Stainless	Argon Blends	75 - 800 ipm	Pinch
62	GMAW-P	Pulse	0.030	Stainless	Argon Oxy	85 - 770 ipm	Wave Control
63	GMAW	CV	0.030	Stainless	He Ar CO2	75 - 800 ipm	Pinch
64	GMAW-P	Pulse	0.030	Stainless	He Ar CO2	110 - 770 ipm	Wave Control
66	GMAW-P	Pulse	0.030	Stainless	Argon CO2	80 - 770 ipm	Wave Control
71	GMAW	CV	3/64	Aluminum 4043	Argon	125 - 600 ipm	Pinch
72	GMAW-P	Pulse	3/64	Aluminum 4043	Argon	85 - 600 ipm	Wave Control
73	GMAW	CV	1/16	Aluminum 4043	Argon	75 - 350 ipm	Pinch
74	GMAW-P	Pulse	1/16	Aluminum 4043	Argon	60 - 350 ipm	Wave Control
75	GMAW	CV	3/64	Aluminum 5356	Argon	125 - 750 ipm	Pinch
76	GMAW-P	Pulse	3/64	Aluminum 5356	Argon	85 - 700 ipm	Wave Control
77	GMAW	CV	1/16	Aluminum 5356	Argon	135 - 425 ipm	Pinch
78	GMAW-P	Pulse	1/16	Aluminum 5356	Argon	75 - 400 ipm	Wave Control
81	GMAW	CV	0.045	Metal Core	Argon CO2	100 - 650 ipm	Pinch
82	GMAW-P	Pulse	0.045	Metal Core	Argon CO2	50 - 650 ipm	Wave Control
83	GMAW	CV	0.052	Metal Core	Argon CO2	80 - 500 ipm	Pinch
84	GMAW-P	Pulse	0.052	Metal Core	Argon CO2	50 - 500 ipm	Wave Control
87	GMAW-P	Pulse - RapidArc	0.045	Metal Core	Argon CO2	100 - 600 ipm	Wave Control
88	GMAW-P	Pulse - RapidArc	0.052	Metal Core	Argon CO2	100 - 500 ipm	Wave Control
89	GMAW-P	Pulse - RapidArc	1/16	Metal Core	Argon CO2	75 - 300 ipm	Wave Control
93	GMAW	CV	0.030	Steel	CO2	90 - 770 ipm	Pinch
94	GMAW	CV	0.030	Steel	Argon Blends	80 - 1200 ipm	Pinch
95	GMAW-P	Pulse	0.030	Steel	Argon Blends	65 - 1200 ipm	Wave Control
98	GMAW-P	Pulse on Pulse	0.035	Aluminum 4043	Argon	125 - 700 ipm	Modulation Freq
99	GMAW-P	Pulse on Pulse	3/64	Aluminum 4043	Argon	85 - 600 ipm	Modulation Freq
100	GMAW-P	Pulse on Pulse	1/16	Aluminum 4043	Argon	65 - 350 ipm	Modulation Freq
101	GMAW-P	Pulse on Pulse	0.035	Aluminum 5356	Argon	140 - 700 ipm	Modulation Freq
102	GMAW-P	Pulse on Pulse	3/64	Aluminum 5356	Argon	85 - 700 ipm	Modulation Freq
103	GMAW-P	Pulse on Pulse	1/16	Aluminum 5356	Argon	75 - 400 ipm	Modulation Freq
148	GMAW	CV	0.035	Aluminum 4043	Argon	150 - 750 ipm	Pinch
149	GMAW-P	Pulse	0.035	Aluminum 4043	Argon	125 - 700 ipm	Wave Control
151	GMAW	CV	0.035	Aluminum 5356	Argon	175 - 750 ipm	Pinch
152	GMAW-P	Pulse	0.035	Aluminum 5356	Argon	140 - 700 ipm	Wave Control
170	GMAW-P	Pulse - Non Adaptive	0.035	Ni Alloy	Argon Helium	80 - 700 ipm	Wave Control
175	GMAW-P	Pulse - Non Adaptive	0.045	Ni Alloy	Argon Helium	75 - 550 ipm	Wave Control
192	GMAW-P	Pulse	0.035	Si Bronze	Argon	100 - 700 ipm	Wave Control



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