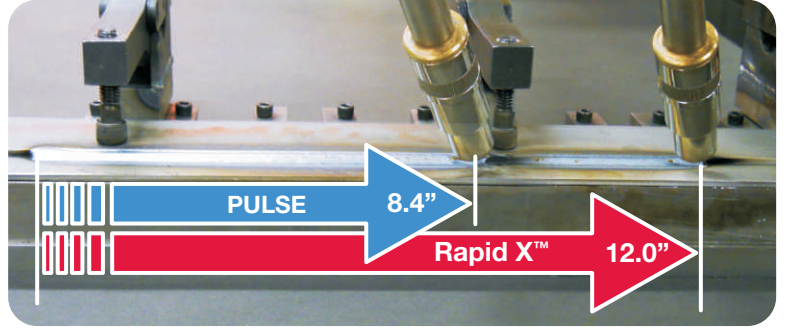


# Rapid X™ Weld Process Overview

**Rapid X™** revolutionizes the productivity of welding.\*

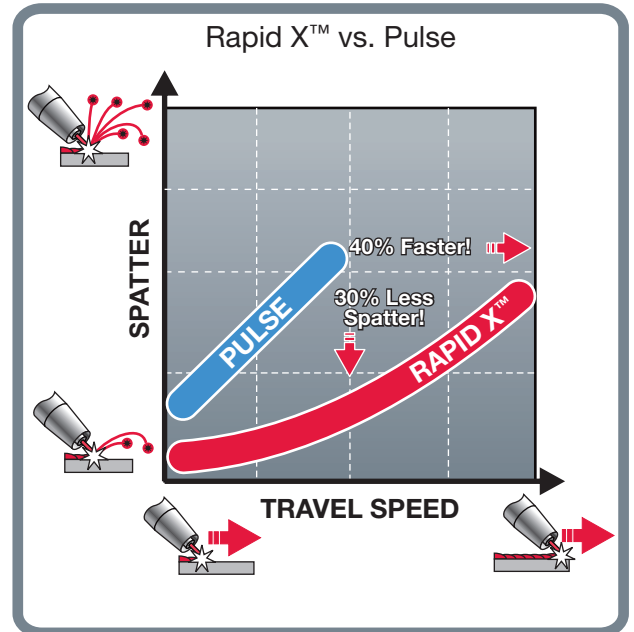
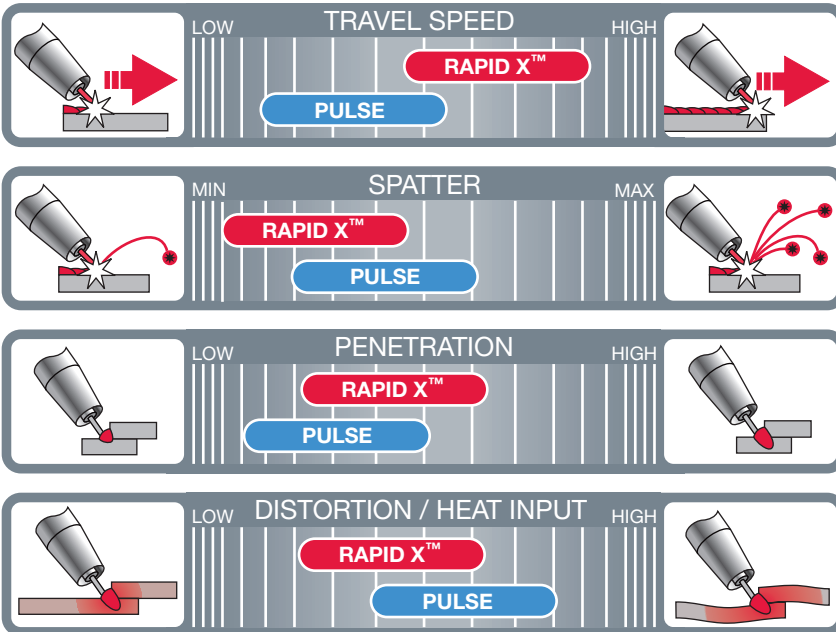
- **Increases Travel Speed by 40%**
- **Reduces Spatter by 30%**
- **Increases Penetration**
- **Reduces Heat Input**
- **Reduces Distortion**



Traditional Pulse welding consists of a peak and background current to deposit a molten droplet after each pulse. Patented RapidArc®, a breakthrough in Pulse welding, provides excellent arc stability at shorter arc lengths, resulting in a significant increase in travel speed.

Patent Pending **Rapid X™** revolutionizes Pulse Welding. Inspired by RapidArc®, **Rapid X™** also uses an extremely short arc length, but now with a significant reduction in spatter generation. Low current wet-in technology momentarily drops the current producing spatter-free welds. UltimArc™ and synergic precision controls complete the **Rapid X™** revolution. The resulting **Rapid X™** process provides extremely fast travel speeds and clean welds to deliver increased productivity.

## FEATURES

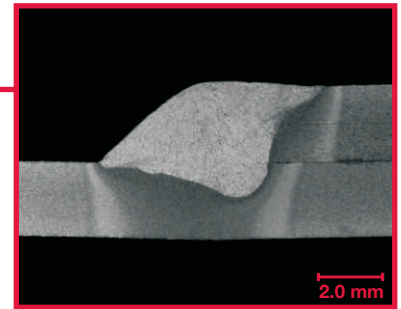
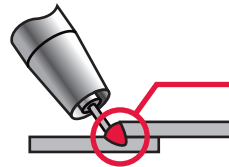
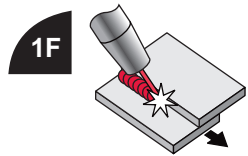


\*Based on a side by side comparison of Rapid X™ and Pulse using a Power Wave® S350 with SuperArc® 0.045" L-56 wire. Rapid X™ parameters: WFS 450 in/min, Travel Speed 50 in/min, 22 Volts. Pulse parameters: WFS 350 in/min, Travel Speed 35 in/min, 22.5 Volts.

**LINCOLN**  
**ELECTRIC**

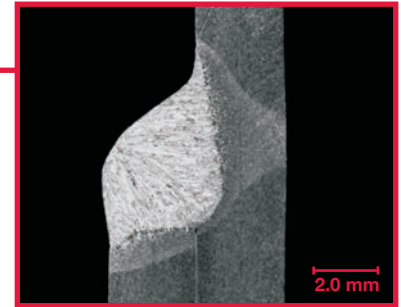
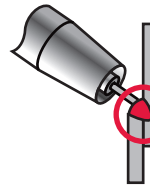
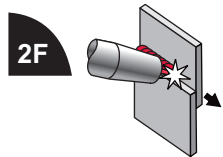
The Performance You Need.  
The Quality You Expect.™

# Applications



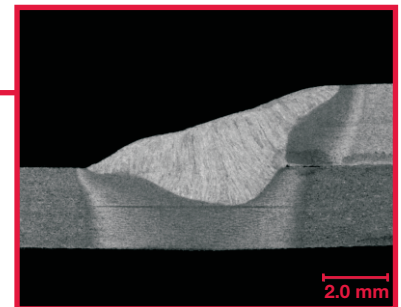
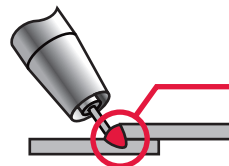
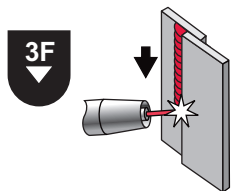
\* Setting used for macro image.

* .045 L-56	90Ar / 10CO <sub>2</sub>	Mild Steel	12ga	3/4 in.	400 in/min	55 in/min	21.0	240
1.2 mm	80Ar / 20CO <sub>2</sub>	Mild Steel	2.6 mm	19 mm	9.5 m/min	140 cm/min	21.5	235



\* Setting used for macro image.

* .045 L-56	90Ar / 10CO <sub>2</sub>	Mild Steel	12ga	3/4 in.	400 in/min	55 in/min	19.5	235
1.2 mm	80Ar / 20CO <sub>2</sub>	Mild Steel	2.6 mm	19 mm	9.9 m/min	140 cm/min	20.5	240



\* Setting used for macro image.

* .045 L-56	90Ar / 10CO <sub>2</sub>	Mild Steel	12ga	3/4 in.	400 in/min	60 in/min	21.0	260
1.2 mm	80Ar / 20CO <sub>2</sub>	Mild Steel	2.6 mm	19 mm	9.7 m/min	152 cm/min	21.5	250

See the Rapid X™ weld process guide for: technical data, proper set-up, application settings and troubleshooting.

## Recommended Equipment

### Power Source

Power Wave® S350, R350, S500 or R500 w/ Digital STT® Module

### Wire Feeder

Power Feed® 10M or 25M

### Accessories

SuperArc® Wire  
SupraMig®  
Magnum® Pro Gun

### Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customer and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customer's particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

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