

*Maximum Range is limited by power source rating

| Type | Size | Procedure | Waveform | Gas Type | Mode # | Arc Control | Max. Range (*) | |
|-----------------------|------------------|-----------------------|-----------------------------------|-----------------------------------|------------------------------------|------------------------------------|------------------------------------|-----------------------------------|
| All | All | GMAW CV | STD CV | | 5 | Pinch | 10 – 45 V | |
| | | GMAW Power | Power Mode® | | 40 | Pinch | 0.1 – 9.00 kW | |
| GMAW | Steel | 0.030 | GMAW CV | CV | CO ₂ | 93 | Pinch | 75 – 700 ipm (1.91 – 17.78 m/min) |
| | | | | Argon Mix | 94 | | 75 – 700 ipm (1.91 – 17.78 m/min) | |
| | | GMAW Pulse | Pulse | Argon Mix | 95 | UltimArc® | 65 – 700 ipm (1.65 – 17.78 m/min) | |
| | | 0.035 | GMAW CV | CV | CO ₂ | 10 | Pinch | 50 – 700 ipm (1.27 – 17.78 m/min) |
| | | | | Argon Mix | 11 | | 50 – 700 ipm (1.27 – 17.78 m/min) | |
| | | | | Pulse | Argon Mix | 12 | | 60 – 700 ipm (1.52 – 17.78 m/min) |
| | GMAW Pulse | RapidArc® | Argon Mix | 13 | UltimArc® | 60 – 700 ipm (1.52 – 17.78 m/min) | | |
| | | Precision Pulse™ | Argon Mix | 411 | | 100 – 600 ipm (2.54 – 15.24 m/min) | | |
| | | 0.040 | GMAW CV | CV | CO ₂ | 138 | Pinch | 50 – 695 ipm (1.27 – 17.65 m/min) |
| | Argon Mix | | | 139 | | 50 – 630 ipm (1.27 – 16 m/min) | | |
| | GMAW Pulse | | Pulse | Argon Mix | 140 | | 60 – 665 ipm (1.52 – 16.89 m/min) | |
| | | | RapidArc® | Argon Mix | 141 | UltimArc® | 60 – 700 ipm (1.52 – 17.78 m/min) | |
| | Precision Pulse™ | Argon Mix | 412 | | 75 – 600 ipm (1.91 – 15.24 m/min) | | | |
| | 0.045 | GMAW CV | CV | CO ₂ | 20 | Pinch | 50 – 400 ipm (1.27 – 10.16 m/min) | |
| | | | Argon Mix | 21 | | 50 – 390 ipm (1.27 – 9.91 m/min) | | |
| | | GMAW Pulse | Pulse | Argon Mix | 22 | | 50 – 435 ipm (1.27 – 11.05 m/min) | |
| | | | RapidArc® | Argon Mix | 18 | UltimArc® | 75 – 535 ipm (1.91 – 13.59 m/min) | |
| | Precision Pulse™ | Argon Mix | 413 | | 75 – 480 ipm (1.91 – 12.19 m/min) | | | |
| Stainless | 0.030 | GMAW CV | CV | Argon Mix | 61 | Pinch | 100 – 700 ipm (2.54 – 17.78 m/min) | |
| | | | He Ar CO ₂ | 63 | | 100 – 700 ipm (2.54 – 17.78 m/min) | | |
| | | GMAW Pulse | Pulse | He Ar CO ₂ | 64 | UltimArc® | 90 – 700 ipm (2.29 – 17.78 m/min) | |
| | | | Argon Mix | 66 | | 80 – 700 ipm (2.03 – 17.78 m/min) | | |
| | Precision Pulse™ | Argon Mix | 420 | UltimArc® | 100 – 700 ipm (2.54 – 17.78 m/min) | | | |
| | | He Ar CO ₂ | 430 | | 100 – 700 ipm (2.54 – 17.78 m/min) | | | |
| | | 0.035 | GMAW CV | CV | Argon Mix | 31 | Pinch | 75 – 700 ipm (1.91 – 17.78 m/min) |
| | | | | He Ar CO ₂ | 33 | | 75 – 700 ipm (1.91 – 17.78 m/min) | |
| | GMAW Pulse | Pulse | He Ar CO ₂ | 34 | UltimArc® | 75 – 700 ipm (1.91 – 17.78 m/min) | | |
| | | Argon Mix | 36 | | 60 – 700 ipm (1.52 – 17.78 m/min) | | | |
| | | Precision Pulse™ | Argon Mix | 421 | | 100 – 600 ipm (2.54 – 15.24 m/min) | | |
| | | He Ar CO ₂ | 431 | UltimArc® | 100 – 700 ipm (2.54 – 17.78 m/min) | | | |
| 0.045 | GMAW CV | CV | Argon Mix | 41 | Pinch | 75 – 390 ipm (1.91 – 9.91 m/min) | | |
| | | He Ar CO ₂ | 43 | | 75 – 475 ipm (1.91 – 12.07 m/min) | | | |
| | GMAW Pulse | Pulse | He Ar CO ₂ | 44 | UltimArc® | 75 – 505 ipm (1.91 – 12.83 m/min) | | |
| | | Argon Mix | 46 | | 50 – 415 ipm (1.27 – 10.54 m/min) | | | |
| Precision Pulse™ | Argon Mix | 423 | | 50 – 400 ipm (1.27 – 10.16 m/min) | | | | |
| He Ar CO ₂ | 433 | UltimArc® | 60 – 400 ipm (1.52 – 10.16 m/min) | | | | | |
| Metal Core | 0.045 | GMAW CV | CV | Argon Mix | 81 | Pinch | 100 – 530 ipm (2.54 – 13.46 m/min) | |
| | | | Pulse | Argon Mix | 82 | | 50 – 535 ipm (1.27 – 13.59 m/min) | |
| | GMAW Pulse | RapidArc® | Argon Mix | 87 | UltimArc® | 75 – 625 ipm (1.91 – 15.88 m/min) | | |
| | | CV | Argon Mix | 83 | Pinch | 50 – 345 ipm (1.27 – 8.76 m/min) | | |
| 0.052 | GMAW Pulse | Pulse | Argon Mix | 84 | | 50 – 370 ipm (1.27 – 9.4 m/min) | | |
| | | RapidArc® | Argon Mix | 88 | UltimArc® | 60 – 370 ipm (1.52 – 9.4 m/min) | | |

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| GMAW | Type | Size | Procedure | Waveform | Gas Type | Mode # | Arc Control | Max. Range (*) | |
|----------------------|----------------------|----------------------|-----------------|------------------|-----------|------------------------------------|------------------------------------|------------------------------------|------------------------------------|
| | Aluminum 4XXX | 0.035 | | GMAW CV | CV | Argon | 148 | Pinch | 150 — 700 ipm (3.81 — 17.78 m/min) |
| GMAW Pulse | | | | Pulse | Argon | 149 | UltimArc® | 125 — 700 ipm (3.18 — 17.78 m/min) | |
| | | | | CC Pulse | Argon | 150 | | 125 — 700 ipm (3.18 — 17.78 m/min) | |
| GMAW Pulse on Pulse® | | Pulse on Pulse® | Argon | 98 | Frequency | 125 — 700 ipm (3.18 — 17.78 m/min) | | | |
| 3/64 | | | GMAW CV | CV | Argon | 71 | Pinch | 125 — 500 ipm (3.18 — 12.7 m/min) | |
| | | | GMAW Pulse | Pulse | Argon | 72 | UltimArc® | 85 — 565 ipm (2.16 — 14.35 m/min) | |
| | | | | CC Pulse | Argon | 69 | | 85 — 565 ipm (2.16 — 14.35 m/min) | |
| GMAW Pulse on Pulse® | | Pulse on Pulse® | Argon | 99 | Frequency | 85 — 500 ipm (2.16 — 12.7 m/min) | | | |
| Aluminum 5XXX | | 0.035 | | GMAW CV | CV | Argon | 151 | Pinch | 175 — 700 ipm (4.45 — 17.78 m/min) |
| | | | | GMAW Pulse | Pulse | Argon | 152 | UltimArc® | 150 — 700 ipm (3.81 — 17.78 m/min) |
| | | | | | CC Pulse | Argon | 153 | | 150 — 700 ipm (3.81 — 17.78 m/min) |
| | | GMAW Pulse on Pulse® | Pulse on Pulse® | Argon | 101 | Frequency | 140 — 700 ipm (3.56 — 17.78 m/min) | | |
| | 3/64 | | GMAW CV | CV | Argon | 75 | Pinch | 125 — 700 ipm (3.18 — 17.78 m/min) | |
| | | | GMAW Pulse | Pulse | Argon | 76 | UltimArc® | 85 — 700 ipm (2.16 — 17.78 m/min) | |
| | | | | CC Pulse | Argon | 70 | | 85 — 700 ipm (2.16 — 17.78 m/min) | |
| | GMAW Pulse on Pulse® | Pulse on Pulse® | Argon | 102 | Frequency | 100 — 600 ipm (2.54 — 15.24 m/min) | | | |
| | SiBr | 0.035 | | GMAW Pulse | Pulse | Argon | 192 | UltimArc® | 80 — 700 ipm (2.03 — 17.78 m/min) |
| 0.045 | | | GMAW Pulse | Pulse | Argon | 191 | UltimArc® | 50 — 470 ipm (1.27 — 11.94 m/min) | |
| Cu | 0.035 | | GMAW Pulse | Pulse | Ar He | 198 | UltimArc® | 100 — 640 ipm (2.54 — 16.26 m/min) | |
| | 0.045 | | GMAW Pulse | Pulse | Ar He | 196 | UltimArc® | 75 — 430 ipm (1.91 — 10.92 m/min) | |
| Ni Alloy | 0.035 | | GMAW Pulse | Pulse | Ar He | 170 | UltimArc® | 80 — 700 ipm (2.03 — 17.78 m/min) | |
| | | | | Precision Pulse™ | Ar He | 451 | UltimArc® | 75 — 600 ipm (1.91 — 15.24 m/min) | |
| | 0.045 | | GMAW Pulse | Pulse | Ar He | 175 | UltimArc® | 75 — 460 ipm (1.91 — 11.68 m/min) | |
| | | | GMAW Pulse | Precision Pulse™ | Ar He | 453 | UltimArc® | 75 — 520 ipm (1.91 — 13.21 m/min) | |

| FCAW | Type | Size | Procedure | Waveform | Gas Type | Mode # | Arc Control | Max. Range (*) |
|------------|-----------|--------|-----------|-----------------|----------|--------|------------------------------------|----------------|
| | Flux Core | All | FCAW-S | Self Shield CV | NA | 6 | Pinch | 10 — 45 V |
| | | | FCAW-G | Gas Shield CV | NA | 7 | Pinch | 10 — 45 V |
| Cored Wire | 0.045 | FCAW-G | CV | CO ₂ | 90 | Pinch | 175 — 600 ipm (4.45 — 15.24 m/min) | |
| | | | | Argon Mix | 91 | | 175 — 600 ipm (4.45 — 15.24 m/min) | |

| SMAW | Type | Size | Procedure | Waveform | Gas Type | Mode # | Arc Control | Max. Range (*) |
|------|------|------|-----------|------------|----------|--------|----------------------|----------------|
| | All | All | DCEP SMAW | SMAW Soft | NA | 1 | Arc Force, Hot Start | 15 — 295 A |
| | | | | SMAW Crisp | NA | 2 | Arc Force, Hot Start | 15 — 295 A |
| | | | | SMAW Pipe | NA | 4 | Arc Force | 50 — 250 A |

| GTAW | Type | Size | Procedure | Waveform | Gas Type | Mode # | Arc Control | Max. Range (*) |
|-----------------------|------|------|-----------|-----------------|----------|----------------------------------|-------------|----------------|
| | NA | NA | DCEN GTAW | Touch Start TIG | Ar / He | 3 | Hot Start | 5 — 300 A |
| Touch Start TIG Pulse | | | | Ar / He | 8 | Frequency, Background, Hot Start | 5 — 300 A | |

| CAG | Type | Size | Procedure | Waveform | Gas Type | Mode # | Arc Control | Max. Range (*) |
|-----|------|------|-----------|-----------|----------------|--------|-------------|----------------|
| | NA | NA | CAG | Arc Gouge | Compressed Air | 9 | | 60 — 300 A |