

WELDING PROGRAMS

STEEL

	OP	MAT	WIRE	GAS
Fe0.6	-	Fe	0,6/0,024"	Ar+18%-25% CO ₂
Fe0.8	-	Fe	0,8/0,030"	Ar+18%-25% CO ₂
Fe1.0	-	Fe	1,0/0,039"	Ar+18%-25% CO ₂
OP	102	Fe	0,9/0,035"	Ar+18%-25% CO ₂
OP	110	Fe	0,6	CO ₂ 100%
OP	111	Fe	0,8	CO ₂ 100%
OP	112	Fe	0,9/0,035"	CO ₂ 100%
OP	113	Fe	1,0	CO ₂ 100%
OP	130	Fe Aw	0,9/0,035"	NO GAS
OP	131	Fe Aw	1,1/0,045"	NO GAS
OP	174	Fe FC rutile	1,2	Ar+18%-25% CO ₂
OP	194	Fe FC basic	1,2	Ar+18%-25% CO ₂

STAINLESS STEEL

	OP	MAT	WIRE	GAS
SS0.8	-	Ss-316	0,8/0,030"	Ar+2% CO ₂
SS1.0	-	Ss-316	1,0/0,039"	Ar+2% CO ₂
OP	221	Ss-309	0,8	Ar+2% CO ₂
OP	222	Ss-309	0,9/0,035"	Ar+2% CO ₂
OP	223	Ss-309	1,0	Ar+2% CO ₂
OP	244	Fc-316	1,2	Ar+18%-25% CO ₂

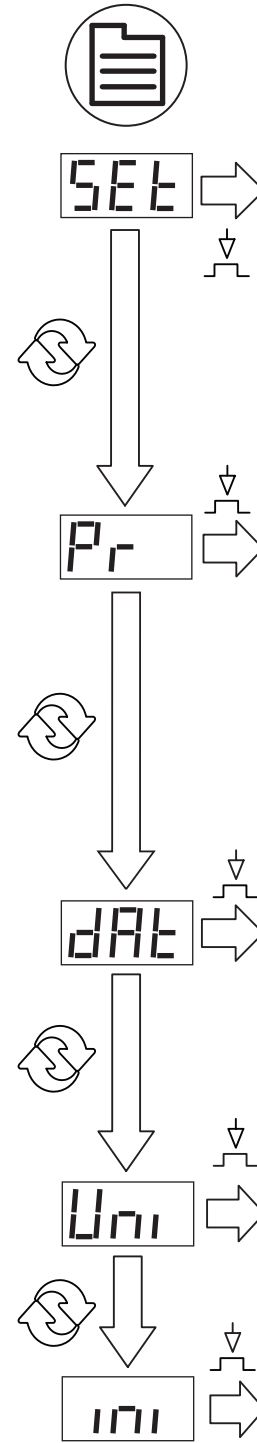
ALUMINIUM

	OP	MAT	WIRE	GAS
Al 0.8	-	Al-5356	0,8/0,030"	Ar 100%
Al 1.0	-	Al-5356	1,0/0,039"	Ar 100%
Al 1.2	-	Al-5356	1,2/0,045"	Ar 100%
OP	303	Al-4043	1,0	Ar 100%
OP	304	Al-4043	1,2	Ar 100%

SPECIAL

	OP	MAT	WIRE	GAS
OP	401	CuSi 3	0,8	Ar 100%
OP	403	CuSi 3	1,0	Ar 100%
OP	411	CuSi 3	0,8	Ar+2% CO ₂
OP	413	CuSi 3	1,0	Ar+2% CO ₂

IN / OUT MENU



MENU

MMA

Hot
HOT START CURRENT

tHt
HOT START TIME

For
FORCE-ARC CURRENT

TIG

t dn
SLOP DOWN TIME

PLG
POST-GAS TIME

MIG/MAG

bb
BURN-BACK

SSt
SOFT START

J-L
SPOT TIME

7-F
SPOT REPETITION

PLG
POST GAS TIME



POSITIVE POLARITY

NEGATIVE POLARITY

OP 130
OP 131

L-P
LOAD PROGRAM

S-P
SAFE PROGRAM

Con
WIRE CONSUMED

rSt
RESET WIRE CONSUMED

CAL
SET WIRE METER

LAB
TIME WORKED

SOL
LAST WELDING DATA VALID

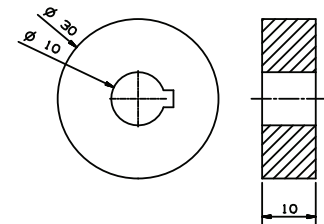
nn
SPEED m / min

-11-
THICKNESS

IPn
SPEED IPM

FACTORY SETTINGS

ROLLERS



	MAT.	WIRE	REF.
☺	Fe	0,6 - 0,8	56105
		0,8 - 1,0	56106
		1,0 - 1,2	55986
☹	Al	0,8 - 1,0	55987
		1,0 - 1,2	55988
☼	Tub	0,8 - 1,0	56116
		1,0 - 1,2	55989

MODE

MMA

MMA TIG
TIG Pulse

MIG 2T 4T
TIG Pulse

TIG

MMA TIG
TIG Pulse

MIG 2T 4T
TIG Pulse

TIG PULSED

MMA TIG
TIG Pulse

MIG 2T 4T
TIG Pulse

MIG 2T SPOT

MIG 4T

MIG 2T