

Synergic lines Standard

	Characteristic	Wire	Gas	0,6mm .023 inch	0,8mm .030 inch	0,9mm .035 inch	1,0mm .040 inch	1,2mm .045 inch	1,4mm .052 inch	1,6mm 1/16 inch	2,0mm 5/64 inch
Mild Steel	Steel Universal	G3Si1 ER 70 S-6	CO2 100%	S3183	S2671	S2680	S2563	S2564	S2699	S2706	
	Steel Universal	G3Si1 ER 70 S-6	Ar+3-5%O2		S2669	S2678	S2687	S2692	S2697	S2708	
	Steel Universal	G3Si1 ER 70 S-6	Ar 8-10%CO2		S2670	S2679	S2688	S2693	S2698	S2707	
	Steel Universal	G3Si1 ER 70 S-6	Ar 15-20%CO2	S3184	S2709	S2710	S2565	S2566	S2711	S2712	
	Steel Dynamic	G3Si1 ER 70 S-6	Ar+3-5%O2		S2672	S2681	S2689	S2694	S2700		
	Steel Dynamic	G3Si1 ER 70 S-6	Ar 15-20%CO2		S2674	S2683	S3503	S2630	S2702		
	Steel Dynamic	G3Si1 ER 70 S-6	Ar 8-10CO2		S2673	S2682	S2567	S2568	S2701		
	Steel Root	G3Si1 ER 70 S-6	CO2 100%		S2713	S2714	S2715	S2716		S2717	
	Steel Root	G3Si1 ER 70 S-6	Ar 3-5%O2		S2675	S2684	S2690	S2695	S2703		
	Steel Root	G3Si1 ER 70 S-6	Ar 8-10%CO2		S2676	S2685	S2691	S2696	S2704		
	Steel Root	G3Si1 ER 70 S-6	Ar 15-20%CO2		S2677	S2686	S2569	S2570	S2705		
	Hardfacing	Hardfacing	Ar 15-20%CO2				S2721	S2722			
Stainless Steel	Universal	CrNi 19 9 /19 12 3 ER 308L / ER 316LSi	Ar 2,5%CO2		S2759	S2754	S2571	S2572		S2760	
	Root	CrNi 19 9 ER 308 L	Ar 2,5%CO2		S2761	S2762	S2573	S2631			
	Universal	CrNi 19 9 /19 12 3 ER 308L / ER 316LSi	Ar+33He+1CO2			S2755		S2757			
	Universal	CrNi 19 9 /19 12 3 ER 308L / ER 316LSi	Ar+90He+2,5CO2			S2756		S2758			
	Universal	CrNi 18 8 /18 8 6 ER 307	Ar 2,5%CO2		S2763		S2632	S2633			
	Universal	CrNi 13 4 ER 410 NiMo	Ar 2,5%CO2				S3164				
	Universal	EC 409 Ti	Ar 2-5%O2					S3362			
	Universal	Cr 18 L Nb	Ar 2,5%CO2				S3512				
	Universal	CrNi 23 12 ER 309	Ar 2,5%CO2				S3515				
	Universal	CrNi 22 12	Ar 2,5%CO2				S3516				
	Universal	EC 439 Ti	Ar 2-5%O2					S3363			
Cu Base	Brazing	CuSi 3 ER CuSi	Ar 100%		S2723	S2724	S2574	S2634		S2725	
	Brazing	CuAl 8 ER CuAl	Ar 100%		S2726	S2727	S2635	S2636		S2728	
Alu	Universal	AlSi 5 ER 4043	Ar 100%				S4091	S2616			
	Universal	AlMg 5 ER 5356	Ar 100%				S4092	S2612		S2614	
	Universal	AlMg 4,5Mn ER 5183	Ar 100%					S2613		S2615	
Flux Cored Wire	Universal	Metal Cored	Ar 15-20%CO2					S3168		S2731	
	Universal	Metal Cored	Ar 8-10%CO2			S2748		S2734	S2736	S2746	
	Universal	Metal Cored	Ar 25%CO2			S2749		S2735	S2737	S2747	
	Retro	Metal Cored DC-	Ar 15-20%CO2					S3848			
	Universal	FCW Rutil E 71 T	CO2 100%			S2744		S2638	S2740	S2733	
	Universal	FCW Rutil E 71 T	Ar 15-20%CO2					S2639		S2732	
	Universal	FCW Rutil E 71 T	Ar 25%CO2			S2745		S2738	S2739	S2741	
	Universal	FCW Basic E 70 T	CO2 100%					S2640	S2753	S2730	
	Universal	FCW Basic E 70 T	Ar 15-20%CO2					S2641	S2752	S2729	
	Universal	FCW Basic E 70 T	Ar 25%CO2					S2742		S2743	
	Universal	FCW CrNi	Ar 15-20%CO2			S3745		S2642		S2751	
		self shielded	no gas			S2718		S2719		S2720	S3653

HINWEIS: Neue hinzugefügte Kennlinien sind in der Tabelle **ROT** markiert / **NOTE:** Newly added synergic lines are marked **RED** in the table

HINWEIS: S2750 ersetzt durch **S3745** / **NOTE:** S2750 replaced by **S3745**

Synergic lines Pulse

	Characteristic	Wire	Gas	0,8mm .030 inch	0,9mm .035 inch	1,0mm .040 inch	1,2mm .045 inch	1,4mm .052 inch	1,6mm 1/16 inch
Mild Steel	Steel Universal	G3Si1 ER 70 S-6	Ar 15-20%CO2	P2769	P2783	P3695	P3449	P3733	P3844
	Steel Universal	G3Si1 ER 70 S-6	Ar 8-10%CO2		P3356	P3220	P3042	P3369	
	Dynamic	G3Si1 ER 70 S-6	Ar 15-20%CO2			P3792	P3696		
	Dynamic	G3Si1 ER 70 S-6	Ar 8-10%CO2			P3794	P3792		
	Hardfacing	Hardfacing	Ar 15-20%CO2			P2794	P2795		P2796
Stainless Steel	Universal	CrNi 19 9 / 19 12 3 ER 308L / ER 316LSi	Ar 2,5%CO2	P3670	P2813	P3871	P2818		P2821
	Universal	CrNi 19 9 / 19 12 3 ER 308L / ER 316LSi	Ar+26,5He+7,5CO2		P2815		P2820		
	Universal	CrNi 19 9 / 19 12 3 ER 308L / ER 316LSi	Ar+30He+2,5CO2		P2814	P2817	P2819		P2822
	Universal	CrNi 18 8 / 18 8 6 ER 307	Ar 2,5%CO2	P2804		P2809	P2810		P2811
	Universal	CrNi 13 4 ER 410 NiMo	Ar 2,5%CO2			P3158	P3117		
	Universal	Cr 18 L Nb ER 430 L Nb	Ar 2,5%CO2			P3153			
	Universal	Cr 18 L Nb ER 430 L Nb	Ar 5-10%CO2			P3151			
	Universal	EC 409 Ti	Ar 2,5%O2				P3292		
	Universal	CrNi 23 12	Ar 2,5%O2			P3519			
	Universal	CrNi 22 12	Ar 2,5%O2			P3521			
	Universal	EC 439 Ti	Ar 2,5%O2				P3372		
Cu Base	Brazing	CuSi 3 ER CuSi	Ar 100%	P2828	P2829	P2830	P2831		
	Brazing	CuAl 8 ER CuAl	Ar 100%	P2823	P2824	P2825	P2826		P2827
Alu	Universal	Al99,5 ER 1050	Ar 100%				P3898		P3899
	Universal	AlSi 5 ER 4043	Ar 100%	P3364	P3236	P3048	P3555		P3071
	Universal	AlMg 5 ER 5356	Ar 100%	P3360	P3247	P3046	P3044		P3069
	Universal	AlMg 4,5Mn ER 5183	Ar 100%				P3086		
Ni-Bas e	Universal	NiCrMo-3 ER NiCrMo-3	Ar 100%			P3135	P3138		
	Universal	NiCrMo-3 ER NiCrMo-3	Ar 2,5%CO2			P3137	P3139		
Flux Cored Wire	Universal	Metal Cored	Ar 15-20%CO2				P2838	P3074	P2839
	Universal	Metal Cored	Ar 8-10%CO2				P3390	P3382	
	Universal	FCW Rutil E 71 T	Ar 15-20%CO2				P2836		P2837
	Universal	FCW Basic E 70 T	Ar 15-20%CO2				P2832		P2833
	Universal	FCW CrNi	Ar 15-20%CO2				P2834		P2835

HINWEIS: Neue hinzugefügte Kennlinien sind in der Tabelle **ROT** markiert / **NOTE:** Newly added synergic lines are marked **RED** in the table

HINWEIS: P2812 ersetzt durch **P3670** / **NOTE:** P2812 replaced by **P3670**
 HINWEIS: P2786 ersetzt durch **P3733** / **NOTE:** P2786 replaced by **P3733**
 HINWEIS: P2784 ersetzt durch **P3695** / **NOTE:** P2784 replaced by **P3695**
 HINWEIS: P2787 ersetzt durch **P3844** / **NOTE:** P2787 replaced by **P3844**
 HINWEIS: P3105 ersetzt durch **P3871** / **NOTE:** P3105 replaced by **P3871**
 HINWEIS: P2797 ersetzt durch **P3898** / **NOTE:** P2797 replaced by **P3898**
 HINWEIS: P2798 ersetzt durch **P3899** / **NOTE:** P2798 replaced by **P3899**

Synergic lines LSC

	Characteristic	Wire	Gas	0,8mm .030 inch	0,9mm .035 inch	1,0mm .040 inch	1,2mm .045 inch	1,4mm .052 inch	1,6mm 1/16 inch	2,0mm 5/64 inch
Mild Steel	Steel Universal	G3Si1 ER 70 S-6	CO2 100%	LSC2873	LSC2844	LSC2788	LSC2790	LSC2882	LSC3322	
	Steel Universal	G3Si1 ER 70 S-6	Ar 15-20%CO2	LSC2937	LSC2840	LSC3359	LSC2765	LSC2875	LSC3077	LSC3447
	Steel Universal	G3Si1 ER 70 S-6	Ar 8-10%CO2		LSC3311					
	Steel Root	G3Si1 ER 70 S-6	CO2 100%	LSC2874				LSC2883		
	Steel Root	G3Si1 ER 70 S-6	Ar 15-20%CO2	LSC2872				LSC2876		
	Open Root	G3Si1 ER 70 S-6	CO2 100%		LSC3065	LSC3058	LSC3053			
	Open Root	G3Si1 ER 70 S-6	Ar 15-20%CO2		LSC3062	LSC3060	LSC3049			
	Steel Galvanized	G3Si1 ER 70 S-6	Ar 8-10%CO2		LSC3434	LSC3436				
	Steel Galvanized	G3Si1 ER 70 S-6	Ar 15-20%CO2		LSC3432 LSC3532	LSC3435 LSC3531				
Stainless Steel	Universal	CrNi 19 9 /19 12 3 ER 308L / ER 316LSi	Ar 2,5%CO2	LSC3019	LSC2847	LSC2793	LSC2792			
	Root	CrNi 19 9 ER 308 L	Ar 2,5%CO2		LSC2848	LSC2852	LSC3690			
	Universal	CrNi 18 8 / 18 8 6 ER 307	Ar 2,5%CO2			LSC2854	LSC2855			
	Universal	CrNi 23 12 ER309	Ar 2,5%CO2			LSC3110	LSC3107			
	Universal	CrNi 23 12 ER309	Ar 2,5%CO2			LSC3378				
	Universal	Cr 18 L Nb ER 430 L Nb	Ar 2,5%CO2			LSC3126				
	Universal	Cr 18 L Nb ER 430 L Nb	Ar 5-10%CO2			LSC3125				
	Universal	CrNi 13 4 ER 410 NiMo	Ar 2,5%CO2			LSC3162	LSC3082			
	Universal	EC 409 Ti	Ar 2-5%O2				LSC3337			
	Universal	EC 439 Ti	Ar 2-5%O2				LSC3341			
Ni-Base	Cladding	NiCrMo-3 ER NiCrMo-3	Ar 100%		LSC3234	LSC3091	LSC3104			
Cu Base	Brazing	CuSi 3 ER CuSi	Ar 100%	LSC3650	LSC3232	LSC2936	LSC3567			
	Universal	CuAl 8 ER CuAl	Ar 100%			LSC2983	LSC3570			
Flux Cored Wire	Universal	Metal Cored	Ar 15-20%CO2			LSC3680	LSC2857	LSC3095	LSC2858	LSC2858
	Universal	Metal Cored	CO2 100%			LSC3676	LSC3677			

HINWEIS: Neue hinzugefügte Kennlinien sind in der Tabelle **ROT** markiert / **NOTE:** Newly added synergic lines are marked **RED** in the table

HINWEIS: LSC3432 ersetzt durch **LSC3532** / **NOTE:** LSC3432 replaced by **LSC3532**

HINWEIS: LSC3435 ersetzt durch **LSC3531** / **NOTE:** LSC3435 replaced by **LSC3531**

HINWEIS: LSC3101 ersetzt durch **LSC3650** / **NOTE:** LSC3101 replaced by **LSC3650**

HINWEIS: LSC2853 ersetzt durch **LSC3690** / **NOTE:** LSC2853 replaced by **LSC3690**

Synergic lines LSC Advanced

	Characteristic	Wire	Gas	0,8mm .030 inch	0,9mm .035 inch	1,0mm .040 inch	1,2mm .045 inch	1,4mm .052 inch	1,6mm 1/16 inch
Mild Steel	Steel Universal	G3Si1 ER 70 S-6	CO2 100%	LSC2892	LSC2926	LSC2870	LSC2865		
	Steel Universal	G3Si1 ER 70 S-6	Ar 15-20%CO2	LSC2897	LSC2924	LSC2866	LSC2860	LSC3021	
	Steel Root	G3Si1 ER 70 S-6	CO2 100%	LSC2901	LSC3066	LSC3059	LSC3055		
	Steel Root	G3Si1 ER 70 S-6	Ar 15-20%CO2	LSC2899	LSC3064	LSC3061	LSC3052	LSC3022	
Stainless Steel	Universal	CrNi 19 9 / 19 12 3 ER 308L / ER 316LSi	Ar 2,5%CO2		LSC2928	LSC2884	LSC2889		
	Root	CrNi 19 9 ER 308 L	Ar 2,5%CO2		LSC2929	LSC2885	LSC2922		
	Universal	CrNi 18 8 / 18 8 6 ER 307	Ar 2,5%CO2			LSC2887	LSC2888		
Ni-Base	Cladding	NiCrMo-3 ER NiCrMo-3	Ar 100%			LSC3096	LSC3109		
Cu-Base	Brazing	CuSi 3 ER CuSi	Ar 100%	LSC3103		LSC2886			
Flux Cored Wire	Universal	Metal Cored	Ar 15-20%CO2				LSC2903	LSC3100	LSC2923

HINWEIS: Neue hinzugefügte Kennlinien sind in der Tabelle **ROT** markiert / **NOTE:** Newly added synergic lines are marked **RED** in the table

Synergic lines PMC

	Characteristic	Wire	Gas	0,8mm .030 inch	0,9mm .035 inch	1,0mm .040 inch	1,1mm .043 inch	1,2mm .045 inch	1,4mm .052 inch	1,6mm 1/16 inch	2,0mm 5/64 inch
Mild Steel	Steel Universal	G3Si1 ER 70 S-6	Ar 15-20%CO2	PMC2915	PMC2907	PMC2851		PMC3189	PMC2904	PMC2902	PMC3425
	Steel Universal	G3Si1 ER 70 S-6	Ar 8-10%CO2		PMC3194		PMC3244	PMC3245	PMC3573		
	Steel PCS	G3Si1 ER 70 S-6	Ar 15-20%CO2	PMC2916	PMC2911	PMC2868		PMC2890	PMC2905	PMC2906	
	Steel PCS	G3Si1 ER 70 S-7	Ar 8-10%CO2					PMC3836		PMC3842	
	Arc blow	G3Si1 ER 70 S-6	Ar 15-20%CO2	PMC3855		PMC3700		PMC3824			
	Arc blow	G3Si1 ER 70 S-6	Ar 8-10%CO2	PMC3856	PMC3376			PMC3835			
	Dynamic	G3Si1 ER 70 S-6	Ar 8-10%CO2		PMC3395	PMC3465	PMC3703	PMC3706	PMC3741	PMC3843	
	Dynamic	G3Si1 ER 70 S-6	Ar 15-20%CO2		PMC3396	PMC3450		PMC3300	PMC3744	PMC3799	
	Mix	G3Si1 ER 70 S-6	Ar 8-10%CO2		PMC3297	PMC3301		PMC3299			
	Mix	G3Si1 ER 70 S-6	Ar 15-20%CO2		PMC3192	PMC3286		PMC3502			
	Multi Arc	G3Si1 ER 70 S-7	Ar 15-20%CO2			PMC3928		PMC3839			
	Multi Arc	G3Si1 ER 70 S-6	Ar 8-10%CO2			PMC3929		PMC3802	PMC3572		
	Galvannealed	G3Si1 ER 70 S-6	Ar 8-10%CO2				PMC3890				
Stainless Steel	Universal	CrNi 19 9 / 19 12 3 ER 308L / ER 316LSi	Ar 2,5%CO2	PMC2970	PMC3054	PMC2864		PMC3204		PMC3497	
	Universal	CrNi 19 9 / 19 12 3 ER 308L / ER 316LSi	Ar 9%He2%CO2					PMC3424			
	PCS	CrNi 19 9 / 19 12 3 ER 308L / ER 316LSi	Ar 2,5%CO2		PMC3401	PMC3215		PMC3217			
	Dynamic	CrNi 19 9 / 19 12 3 ER 308L / ER 316LSi	Ar 2,5%CO2			PMC3876					
	Mix	CrNi 18 8 / 18 8 6 ER 307	Ar 2,5%CO2					PMC3500			
	Mix	CrNi 19 9 / 19 12 3 ER 308L / ER 316LSi	Ar 2,5%CO2		PMC3402	PMC3385		PMC3499			
	Mix Drive	CrNi 18 8 / 18 8 6 ER 307	Ar 2,5%CO2			PMC3259					
	Mix Drive	CrNi 19 9 / 19 12 3 ER 308L / ER 316LSi	Ar 2,5%CO2			PMC3318		PMC3559			
	Universal	CrNi 18 8 / 18 8 6 ER 307	Ar 2,5%CO2	PMC3279		PMC3206		PMC3202			
	PCS	CrNi 18 8 / 18 8 6 ER 307	Ar 2,5%CO2			PMC3211		PMC3226			
	Mix	CrNi 18 8 / 18 8 6 ER 307	Ar 2,5%CO2			PMC3393					
	Universal	CrNi 23 12 ER 309	Ar 2,5%CO2					PMC3134			
	Universal	Cr 18 L Nb ER 430 L Nb	Ar 2,5%CO2			PMC3155					
	Universal	Cr 18 L Nb ER 430 L Nb	Ar 5-10%CO2			PMC3123					
	Universal	CrNi 13 4 ER 410 NiMo	Ar 2,5%CO2			PMC3159		PMC3102			
	Universal	EC 409 Ti	Ar 2-5%O2					PMC3290			
	Dynamic	EC 409 Ti	Ar 2-5%O2					PMC3707			
	Gap bridging	EC 409 Ti	Ar 2-5%O2					PMC3721			
	Universal	CrNi 23 12	Ar 2,5%CO2			PMC3520					
	Universal	EC 439 Ti	Ar 2-5%O2					PMC3342			
	Dynamic	EC 439 Ti	Ar 2-5%O2					PMC3593			
	Gap bridging	EC 439 Ti	Ar 2-5%O2					PMC3768			
Cu Base	Brazing	CuSi 3 ER CuSi	Ar 100%		PMC3233	PMC2940		PMC2941			
	Dynamic	CuSi 3 ER CuSi	Ar 100%					PMC3885			
	Brazing	CuAl 8 ER CuAl	Ar 100%			PMC2938		PMC2939			
	Galvanized	CuAl 8 ER CuAl	Ar 100%			PMC3377					
Alu	Universal	AlSi 5 ER 4043	Ar 100%	PMC3361	PMC3238	PMC3050		PMC3529		PMC3070	
	Dynamic	AlSi 5 ER 4043	Ar 100%					PMC3498			
	ripple drive	AlMg 5 ER 5356	Ar 100%					PMC3405			
	ripple drive	AlSi 5 ER 4043	Ar 100%					PMC3332		PMC4105	
	Mix Drive	AlSi 5 ER 4043	Ar 100%			PMC3289		PMC3209			
	Universal	AlMg 5 ER 5356	Ar 100%	PMC3353	PMC3246	PMC3072		PMC3045		PMC3068	
	Mix Drive	AlMg 5 ER 5356	Ar 100%			PMC3296		PMC3397		PMC3400	
	Universal	AlMg 4,5Mn (Zr) ER 5183	Ar 100%					PMC3047		PMC3067	PMC3803
	Dynamic	AlMg 4,5Mn (Zr) ER 5183	Ar 100%							PMC4037	
	Mix Drive	AlMg 4,5Mn (Zr) ER 5087	Ar 100%					PMC3221		PMC3404	
Ni-Base	Cladding	NiCrMo-3 ER NiCrMo-3	Ar 100%		PMC3235	PMC3288		PMC4057		PMC3231	
	Mix	NiCrMo-3 ER NiCrMo-3	Ar 100%			PMC3291					
	Universal	NiCrMo-3 ER NiCrMo-3	Ar 2,5%CO2			PMC3161		PMC3154			
Flux	Universal	Metal Cored	Ar 15-20%CO2					PMC2898	PMC3075	PMC2900	
	Dynamic	Metal Cored	Ar 15-20%CO2					PMC3388	PMC3384		
	Mix	Metal Cored	Ar 15-20%CO2					PMC3394	PMC3386		

Synergic lines PMC

Cored Wire	Arc blow	Metal Cored	Ar 15-20%CO ₂					PMC3925			
	Universal	Metal Cored	Ar 8-10%CO ₂					PMC3389	PMC3381	PMC3900	
	Galvanized	Metal Cored	Ar 8-10%CO ₂			PMC3698					
	Dynamic	Metal Cored	Ar 8-10%CO ₂					PMC3387	PMC3380		
	Mix	Metal Cored	Ar 8-10%CO ₂					PMC3391	PMC3385		
	Arc blow	Metal Cored	Ar 8-10%CO ₂					PMC3924			

Einbrandstabilisator für alle Kennlinien verfügbar! / *Penetration stabilizer available for all synergic lines!*

Lichtbogenlängen Stabilisator für alle Kennlinien verfügbar! / *Arc length stabilizer available for all synergic lines!*

SFI Hotstart für alle Aluminium kennlinien verfügbar! / *SFI Hotstart available for all Aluminum synergic lines!*

HINWEIS: Neue hinzugetügte Kennlinien sind in der Tabelle **ROT** markiert / **NOTE:** Newly added synergic lines are marked **RED** in the table

HINWEIS: Der Mix Drive Prozess ist nur in Kombination mit der RA Drive - RA Drive CMT - PullMIG CMT möglich

NOTE: The Mix Drive process is only possible in combination with RA Drive - RA Drive CMT - PullMIG CMT

HINWEIS: PMC3586 ersetzt durch **PMC3700** / **NOTE:** PMC3586 replaced by **PMC3700**

HINWEIS: PMC3264 ersetzt durch **PMC3706** / **NOTE:** PMC3264 replaced by **PMC3706**

HINWEIS: PMC3160 ersetzt durch **PMC4057** / **NOTE:** PMC3160 replaced by **PMC4057**

Synergic lines CMT

	Characteristic	Wire	Gas	0,8mm .030 inch	0,9mm .035 inch	1,0mm .040 inch	1,2mm .045 inch	1,4mm .052 inch	1,6mm 1/16 inch
Mild Steel	Steel Universal	G3Si1 ER 70 S-6	CO2 100%	CMT3413	CMT3429	CMT3283	CMT3867		
	Steel Universal	G3Si1 ER 70 S-6	Ar 8-10%CO2		CMT3427	CMT3902	CMT3638		
	Steel Universal	G3Si1 ER 70 S-6	Ar 15-20%CO2	CMT3280	CMT3428	CMT3248	CMT3542		
	Dynamic	G3Si1 ER 70 S-6	Ar 15-20%CO2	CMT3772		CMT3392	CMT3552		
	Mix	G3Si1 ER 70 S-6	Ar 8-10%CO2		CMT3782	CMT3781			
	Mix	G3Si1 ER 70 S-6	Ar 15-20%CO2			CMT3691	CMT3545		
	Gap bridging	G3Si1 ER 70 S-6	Ar 15-20%CO2			CMT3406	CMT3673		
	Galvanized	G3Si1 ER 70 S-6	CO2 100%			CMT3493	CMT3492		
	Galvanized	G3Si1 ER 70 S-6	Ar 8-10%CO2			CMT3847			
	Root	G3Si1 ER 70 S-6	Ar 15-20%CO2			CMT3697	CMT3801		
Stainless Steel	Universal	CrNi 19 9 / 19 12 3 ER 308L / ER 316LSi	Ar 2,5%CO2		CMT3462	CMT3437	CMT3262 CMT3558		
	Dynamic	CrNi 19 9 / 19 12 3 ER 308L / ER 316LSi	Ar 2,5%CO2			CMT3554	CMT3551		
	Mix	CrNi 19 9 / 19 12 3 ER 308L / ER 316LSi	Ar 2,5%CO2			CMT3374	CMT3302		
	Universal	CrNi 18 8 / 18 8 6 ER 307	Ar 2,5%CO2		CMT3568	CMT3459	CMT3263 CMT3556		
	Mix	CrNi 18 8 / 18 8 6 ER 307	Ar 2,5%CO2			CMT3526	CMT3353		
	Dynamic	CrNi 18 8 / 18 8 6 ER 307	Ar 2-5%CO2				CMT4036		
	Universal	CR 18 L Nb	Ar 2,5%CO2			CMT3569			
	Mix	EC 409 Ti	Ar 2-5%O2				CMT3629		
Alu	Universal	AlSi 5 ER 4043	Ar 100%			CMT3408	CMT3912		
	Dynamic	AlSi 5 ER 4043	Ar 100%				CMT4093		
	Universal	AlMg 5 ER 5356	Ar 100%			CMT3426	CMT3804		
	Universal	AlMg 4,5Mn ER 5183	Ar 100%				CMT3727		
	Universal	AlMg 4,5Mn (Zr) ER 5087	Ar 100%			CMT3410			
	Mix	AlSi 5 ER 4043	Ar 100%				CMT3911 CMT3870		CMT3755
	Mix	AlMg 4,5Mn (Zr) ER 5087	Ar 100%				CMT3315		CMT3596
	Mix	AlMg 5 ER 5356	Ar 100%				CMT4033		
	weld +	AlSi 3 Mn1 ER 4020	Ar 100%				CMT3688		
Ni-Base	Universal	NiCrMo-3 ER NiCrMo-3	Ar 100%				CMT3818		
	Universal	NiCrMo-3 ER NiCrMo-3	Ar 2,5%CO2			CMT3535	CMT3476		
	Cladding	NiCrMo-3 ER NiCrMo-3	Ar 2,5%CO2			CMT3534	CMT3528		
	Cladding	NiCrMo-3 ER NiCrMo-3	Ar 100%	CMT3886					
Cu Base	braze	CuSi 3 ER CuSi	Ar 100%	CMT3412	CMT3524	CMT3270	CMT3522		
	braze +	CuSi 3 ER CuSi	Ar 100%	CMT3889		CMT3767			
	braze +	CuSi 3 ER CuSi	Ar 2,5%CO2	CMT3766					
	Mix	CuSi 3 ER CuSi	Ar 100%			CMT3541			
	hotspot	CuSi 3 ER CuSi	Ar 100%	CMT4039					
	braze	CuAl 8 ER CuAl	Ar 100%	CMT3527	CMT3525	CMT3368	CMT3523		
	Mix	CuAl 8 ER CuAl	Ar 100%			CMT3544			

SFI für alle Kennlinien verfügbar! / SFI available for all synergic lines!

SFI Hotstart für alle Aluminium kennlinien verfügbar! / SFI Hotstart available for all Aluminum synergic lines!

HINWEIS: Neue hinzugefügte Kennlinien sind in der Tabelle **ROT** markiert / **NOTE:** Newly added synergic lines are marked **RED** in the tableHINWEIS: CMT3148 ersetzt durch **CMT3542** / **NOTE:** CMT3148 replaced by **CMT3542**HINWEIS: CMT3263 ersetzt durch **CMT3556** / **NOTE:** CMT3263 replaced by **CMT3556**HINWEIS: CMT3262 ersetzt durch **CMT3558** / **NOTE:** CMT3262 replaced by **CMT3558**HINWEIS: CMT3250 ersetzt durch **CMT3672** / **NOTE:** CMT3250 replaced by **CMT3672**HINWEIS: CMT3249 ersetzt durch **CMT3727** / **NOTE:** CMT3249 replaced by **CMT3727**HINWEIS: CMT3411 ersetzt durch **CMT3749** / **NOTE:** CMT3411 replaced by **CMT3749**HINWEIS: CMT3592 ersetzt durch **CMT3755** / **NOTE:** CMT3592 replaced by **CMT3755**HINWEIS: CMT3672 ersetzt durch **CMT3762** / **NOTE:** CMT3672 replaced by **CMT3762**HINWEIS: CMT3749 ersetzt durch **CMT3766** / **NOTE:** CMT3749 replaced by **CMT3766**HINWEIS: CMT3501 ersetzt durch **CMT3767** / **NOTE:** CMT3501 replaced by **CMT3767**HINWEIS: CMT3416 ersetzt durch **CMT3869** / **NOTE:** CMT3416 replaced by **CMT3867**HINWEIS: CMT3749 ersetzt durch **CMT3889** / **NOTE:** CMT3749 replaced by **CMT3889**HINWEIS: CMT3448 ersetzt durch **CMT3911** / **NOTE:** CMT3448 replaced by **CMT3911**HINWEIS: CMT3762 ersetzt durch **CMT3912** / **NOTE:** CMT3762 replaced by **CMT3912**HINWEIS: CMT3466 ersetzt durch **CMT4093** / **NOTE:** CMT3466 replaced by **CMT4093**

Synergic lines TWIN

	Characteristic	Wire	Gas	0,8mm .030 inch	0,9mm .035 inch	1,0mm .040 inch	1,1mm .043 inch	1,2mm .045 inch	1,3mm .052 inch	1,4mm .052 inch	1,6mm 1/16 inch	2,0mm 5/64 inch
Mild Steel	TWIN Universal	G3Si1 ER 70 S-6	Ar 15-20%CO2			PMC3940		PMC3564		PMC3845	PMC3734	
	TWIN Universal	G3Si1 ER 70 S-6	Ar 8-10%CO2			PMC4019		PMC3565	PMC3892		PMC3735	
	TWIN PCS	G3Si1 ER 70 S-6	Ar 15-20%CO2			PMC4018		PMC3833		PMC3846	PMC3840	
	TWIN PCS	G3Si1 ER 70 S-7	Ar 8-10%CO2			PMC4020		PMC3834	PMC3893		PMC3841	
	TWIN Multi Arc	G3Si1 ER 70 S-7	Ar 15-20%CO2			PMC4021		PMC3837				
	TWIN Multi Arc	G3Si1 ER 70 S-6	Ar 8-10%CO2			PMC4023		PMC3838				
Stainless Steel	Universal	CrNi 19 9 / 19 12 3 ER 308L / ER 316LSi	Ar 2-5%CO2					PMC4024				
	PCS	CrNi 19 9 / 19 12 3 ER 308L / ER 316LSi	Ar 2-5%CO2					PMC4026				
	Universal	CrNi 18 8 / 18 8 6 ER 307	Ar 2-5%CO2					PMC4027				
	PCS	CrNi 18 8 / 18 8 6 ER 307	Ar 2-5%CO2					PMC4028				
Ni-Base	Universal	NiCrMo-3 ER NiCrMo-3	Ar 2-5%CO2					PMC4030				
	PCS	NiCrMo-3 ER NiCrMo-3	Ar 2-5%CO2					PMC4032				
	Cladding	NiCrMo-3 ER NiCrMo-3	Ar 30%He+2%H2+0,05%CO2					PMC4034				
	Cladding	NiCrMo-3 ER NiCrMo-3	Ar 100%					PMC4035				
Flux Cored Wire	TWIN Universal	Metal Cored	Ar 15-20%CO2					PMC3903			PMC3905	
	TWIN Universal	Metal Cored	Ar 8-10%CO2					PMC3894			PMC3897	
	TWIN PCS	Metal Cored	Ar 15-20%CO2					PMC3904			PMC3906	
	TWIN PCS	Metal Cored	Ar 8-10%CO2					PMC3896			PMC3901	

Einbrandstabilisator für alle Kennlinien verfügbar! / Penetration stabilizer available for all synergic lines!

Lichtbogenlängen Stabilisator für alle Kennlinien verfügbar! / Arc length stabilizer available for all synergic lines!

HINWEIS: Neue hinzugefügte Kennlinien sind in der Tabelle **ROT** markiert / **NOTE:** Newly added synergic lines are marked **RED** in the table

Synergic lines DB/i Steel

	Characteristic	Wire	Gas	0,6mm .023 inch	0,8mm .030 inch	0,9mm .035 inch	1,0mm .040 inch	1,2mm .045 inch	1,4mm .052 inch	1,6mm 1/16 inch	2,0mm 5/64 inch
Mild Steel	Steel Universal	G3Si1 ER 70 S-6	CO2 100%	S3183	S2671	S2680	S2563	S2564	S2699	S2706	
	Steel Universal	G3Si1 ER 70 S-6	Ar+3-5%O2		S2669	S2678	S2687	S2692	S2697	S2708	
	Steel Universal	G3Si1 ER 70 S-6	Ar 8-10%CO2		S2670	P3356	P3220	P3042	P3369	S2707	
	Steel Universal	G3Si1 ER 70 S-6	Ar 15-20%CO2	S3184	S2709 P2769	S2710 P2783	S2565 P3695	S2566 P3449	S2711 P3733	S2712 P2787	
	Steel Dynamic	G3Si1 ER 70 S-6	Ar+3-5%O2		S2672	S2681	S2689	S2694	S2700		
	Steel Dynamic	G3Si1 ER 70 S-6	Ar 15-20%CO2		S2674	S2683	P3793	P3696	S2702		
	Steel Dynamic	G3Si1 ER 70 S-6	Ar 8-10CO2		S2673	S2682	P3794	P3792	S2701		
	Steel PCS	G3Si1 ER 70 S-6	Ar 15-20%CO2				P3795	P3796	P3797	P3798	
	Steel PCS	G3Si1 ER 70 S-6	Ar 8-10CO2				P3820	P3817	P3819		
	Steel Root	G3Si1 ER 70 S-6	CO2 100%		S2713	S2714	S2715	S2716		S2717	
	Steel Root	G3Si1 ER 70 S-6	Ar 3-5%O2		S2675	S2684	S2690	S2695	S2703		
	Steel Root	G3Si1 ER 70 S-6	Ar 8-10%CO2		S2676	S2685	S2691	S2696	S2704		
	Steel Root	G3Si1 ER 70 S-6	Ar 15-20%CO2		S2677	S2686	S2569	S2570	S2705		
Flux Cored Wire	Universal	Metal Cored	Ar 15-20%CO2					S3168 P2838	P3074 P2839	S2731 P2839	
	Universal	Metal Cored	Ar 8-10%CO2			S2748		S2734 P3390	S2736 P3382	S2746	
	Universal	Metal Cored	Ar 25%CO2			S2749		S2735	S2737	S2747	
	Universal	FCW Rutil E 71 T	CO2 100%			S2744		S2638	S2740	S2733	
	Universal	FCW Rutil E 71 T	Ar 15-20%CO2					S2639 P2836		S2732 P2837	
	Universal	FCW Rutil E 71 T	Ar 25%CO2			S2745		S2738	S2739	S2741	
	Universal	FCW Basic E 70 T	CO2 100%					S2640	S2753	S2730	
	Universal	FCW Basic E 70 T	Ar 15-20%CO2					S2641 P2832	S2752	S2729 P2833	
	Universal	FCW Basic E 70 T	Ar 25%CO2					S2742		S2743	
		self shielded	no gas			S2718		S2719		S2720	S3653

Available Special Characteristics

	Material	Characteristic	Diameter	Gas	Process	Order number
Mild Steel	G3Si1 ER 70 S-6	Universal	0,8mm 0.030 inch	Ar 15-20%CO2	LSC3124	41,0060,3124
Mild Steel	G3Si1 ER 70 S-6	Universal	1,0mm 0.040 inch	Ar 15-20%CO2	LSC3173	41,0060,3173
Mild Steel	G3Si1 ER 70 S-6	ADV root	1,0mm 0.040 inch	Ar 50%CO2	LSC3317	41,0060,3317
Mild Steel	G3Si1 ER 70 S-6	Pipe	1,0mm 0.040 inch	Ar 15-20%CO2	PMC3333	41,0060,3333
Mild Steel	G3Si1 ER 70 S-6	ADV root	1,0mm 0.040 inch	He+49%Ar+1%CO2	LSC3327	41,0060,3327
Mild Steel	G3Si1 ER 70 S-6	retro	0,8mm 0.030 inch	Ar 15-20%CO2	LSC3328	41,0060,3328
Mild Steel	G3Si1 ER 70 S-6	retro	1,0mm 0.040 inch	Ar 15-20%CO2	LSC3330	41,0060,3330
Mild Steel	G3Si1 ER 70 S-6	ADV root	1,2mm 0.045 inch	Ar 50%CO2	LSC3357	41,0060,3357
Mild Steel	G3Si1 ER 70 S-6	Universal	1,2mm 0.045 inch	Ar 2-5%O2	PMC3561	41,0060,3561
Mild Steel	G3Si1 ER 70 S-6	Universal	1,0mm 0.040 inch	Ar 5%CO2+5%O2	PMC3577	41,0060,3577
Mild Steel	G3Si1 ER 70 S-6	Mix	1,0mm 0.040 inch	Ar 5%CO2+5%O2	CMT3579	41,0060,3579
Mild Steel	G3Si1 ER 70 S-6	Universal	1,0mm 0.040 inch	Ar 5%CO2+5%O2	CMT3578	41,0060,3578
Mild Steel	G3Si1 ER 70 S-6	Dynamic	1,2mm 0.045 inch	Ar 15-20%CO2	PMC3615	41,0060,3615
Mild Steel	G3Si1 ER 70 S-6	Universal	1,0mm 0.040 inch	Ar 2-5%O2	PMC3701	41,0060,3701
Mild Steel	G3Si1 ER 70 S-6	TIME	1,2mm 0.045 inch	TIME I	PMC3731	41,0060,3731
Mild Steel	G3Si1 ER 70 S-6	TIME	1,6mm 1/16 inch	TIME I	PMC3732	41,0060,3732
Mild Steel	G3Si1 ER 70 S-6	Universal	1,2mm 0.045 inch	Ar 15-20%CO2	LSC3729	41,0060,3729
Mild Steel	G3Si1 ER 70 S-6	Universal	1,2mm 0.045 inch	CO2 100%	CMT3671	41,0060,3671
Mild Steel	G3Si1 ER 70 S-6	Universal	1,0mm 0.040 inch	Ar 2-5%O2	CMT3705	41,0060,3705
Mild Steel	G3Si1 ER 70 S-6	retro	1,0mm 0.040 inch	Ar 2-5%O2	PMC3783	41,0060,3783
Mild Steel	G3Si1 ER 70 S-6	retro	1,0mm 0.040 inch	Ar 15-20%CO2	CMT3355	41,0060,3355
Mild Steel	G3Si1 ER 70 S-6	retro	1,2mm 0.045 inch	Ar 15-20%CO2	CMT3873	41,0060,3873
Mild Steel	G3Si1 ER 70 S-6	retro	1,2mm 0.045 inch	CO2 100%	CMT3874	41,0060,3874
Mild Steel	G3Si1 ER 70 S-6	retro	0,9mm 0.035 inch	CO2 100%	CMT3880	41,0060,3880
Mild Steel	G3Si1 ER 70 S-6	retro	0,9mm 0.035 inch	Ar 15-20%CO2	CMT3881	41,0060,3881
Mild Steel	G3Si1 ER 70 S-6	Galvanized	1,2mm 0.045 inch	Ar 15-20%CO2	PMC4073	41,0060,4073
Mild Steel	G3Si1 ER 70 S-6	mix	1,2mm 0.045 inch	Ar 15-20%CO2	CMT4074	41,0060,4074
Mild Steel	G3Si1 ER 70 S-6	Universal	0,9mm 0.035 inch	Ar+30%He+1%CO2	PMC4076	41,0060,4076
Stainless Steel	CrNi 22 9 ER 2209	Root	1,0mm 0.040 inch	Ar+30%He+2%CO2	LSC2981	41,0060,2981
Stainless Steel	FCW CrNi 22 9 ER 2209 T1	Universal	1,2mm 0.045 inch	Ar 15-20%CO2	LSC2982	41,0060,2982
Stainless Steel	CrNi 22 11 ER	Universal	1,2mm 0.045 inch	Ar 2,5%CO2	PMC3129	41,0030,3129
Stainless Steel	CrNi 22 11 ER	Universal	1,2mm 0.045 inch	Ar 2,5%CO2	LSC3132	41,0060,3132
Stainless Steel	CrNi 22 9 ER 2209	Universal	1,0mm 0.040 inch	Ar+30%He+2%CO2	PMC3142	41,0060,3142
Stainless Steel	CrNi 22 9 ER 2209	Universal	1,2mm 0.045 inch	Ar+30%He+2%CO2	PMC3143	41,0060,3143
Stainless Steel	CrNi 25 9 Mo-4 ER 2594	Universal	1,0mm 0.040 inch	Ar 2,5%CO2	PMC3150	41,0060,3150
Stainless Steel	CrNi 25 9 Mo-4 ER 2594	Universal	1,2mm 0.045 inch	Ar 2,5%CO2	PMC3152	41,0060,3152
Stainless Steel	CrNi 22 9 ER 2209	Universal	1,0mm 0.040 inch	Ar 2,5%CO2	PMC3163	41,0060,3163
Stainless Steel	CrNi 25 9 Mo-4 ER 2594	Universal	1,0mm 0.040 inch	Ar+20-30%He+2%CO2	PMC3165	41,0060,3165
Stainless Steel	CrNi 25 9 Mo-4 ER 2594	Universal	1,2mm 0.045 inch	Ar+20-30%He+2%CO2	PMC3169	41,0060,3169
Stainless Steel	CrNi 22 9 ER 2209	Universal	1,2mm 0.045 inch	Ar 2,5%CO2	PMC3170	41,0060,3170
Stainless Steel	DO*04	Cladding	1,2mm 0.045 inch	Ar 2,5%CO2	LSC3181	41,0060,3181
Stainless Steel	DO*04	Cladding	1,2mm 0.045 inch	Ar 2,5%CO2	PMC3182	41,0060,3182
Stainless Steel	CrNi 13 4 ER 410NiMo	Universal	1,2mm 0.045 inch	Ar 5-10%CO2	LSC3188	41,0060,3188

Available Special Characteristics

	Material	Characteristic	Diameter	Gas	Process	Order number
Stainless Steel	CrNi 18 8/ 18 8 6 ER 307	Universal	1,6mm 1/16 inch	CO2 100%	LSC3200	41,0060,3200
Stainless Steel	CrNi 18 8/ 18 8 6 ER 307	Universal	1,2mm 0.045 inch	CO2 100%	LSC3223	41,0060,3223
Stainless Steel	FCW CrNi 19 12 3 E316	Universal	1,2mm 0.045 inch	Ar 2%O2	PMC3271	41,0060,3271
Stainless Steel	FCW CrNi A7 MC EC307	Universal	1,2mm 0.045 inch	Ar 2,5%CO2	PMC3284	41,0060,3284
Stainless Steel	DO*04	Cladding	1,6mm 1/16 inch	Ar 2,5%CO2	PMC3312	41,0060,3312

Available Special Characteristics

	Material	Characteristic	Diameter	Gas	Process	Order number
Stainless Steel	CrNi 20 25 ER 385	Universal	1,0mm 0.040 inch	Ar+30%He+2%H+0,05%CO ₂	PMC3306	41,0060,3306
Stainless Steel	EC 409 Ti	Universal	1,3mm 0.051 inch	Ar 2-5%O ₂	PMC3336	41,0060,3336
Stainless Steel	EC 409 Ti	Universal	1,6mm 1/16 inch	Ar 2-5%O ₂	PMC3339	41,0060,3339
Stainless Steel	EC 439 Ti	Universal	1,6mm 1/16 inch	Ar 2-5%O ₂	PMC3346	41,0060,3346
Stainless Steel	EC 439 Ti	Universal	1,3mm 0.051 inch	Ar 2-5%O ₂	PMC3350	41,0060,3350
Stainless Steel	CrNi 22 12 ER 309	Universal	1,0mm 0.040 inch	Ar 2,5%CO ₂	PMC3375	41,0060,3375
Stainless Steel	EC 410NiMo	Universal	1,2mm 0.045 inch	Ar 8-10%CO ₂	PMC3379	41,0060,3379
Stainless Steel	EC 409 Ti	Universal	1,2mm 0.045 inch	Ar 2-5%CO ₂	LSC3334	41,0060,3334
Stainless Steel	EC 439 Ti	Universal	1,2mm 0.045 inch	Ar 2-5%CO ₂	LSC3340	41,0060,3340
Stainless Steel	EC 409 Ti	Universal	1,3mm 0.051 inch	Ar 2-5%CO ₂	LSC3343	41,0060,3343
Stainless Steel	EC 409 Ti	Universal	1,3mm 0.051 inch	Ar 2-5%CO ₂	LSC3344	41,0060,3344
Stainless Steel	EC 439 Ti	Universal	1,3mm 0.051 inch	Ar 2-5%CO ₂	LSC3345	41,0060,3345
Stainless Steel	EC 439 Ti	Universal	1,3mm 0.051 inch	Ar 2-5%CO ₂	LSC3347	41,0060,3347
Stainless Steel	EC 409 Ti	Universal	1,6mm 1/16 inch	Ar 2-5%CO ₂	LSC3348	41,0060,3348
Stainless Steel	EC 409 Ti	Universal	1,6mm 1/16 inch	Ar 2-5%CO ₂	LSC3349	41,0060,3349
Stainless Steel	EC 439 Ti	Universal	1,6mm 1/16 inch	Ar 2-5%CO ₂	LSC3351	41,0060,3351
Stainless Steel	EC 439 Ti	Universal	1,6mm 1/16 inch	Ar 2-5%CO ₂	LSC3352	41,0060,3352
Stainless Steel	EC 410NiMo	Universal	1,2mm 0.045 inch	Ar 8-10%CO ₂	LSC3373	41,0060,3373
Stainless Steel	CrNi 23 12 ER 309L	Universal	1,0mm 0.040 inch	Ar 2,5%CO ₂	LSC3378	41,0060,3378
Stainless Steel	CrNi 22 12 ER 309	Universal	1,0mm 0.040 inch	Ar 2,5%CO ₂	LSC3383	41,0060,3383
Stainless Steel	CrNi 18 8/ 18 8 6 ER 307	arc blow	1,2mm 0.045 inch	Ar 2,5%CO ₂	PMC3419	41,0060,3419
Stainless Steel	Cr 18 Ti ER439	Universal	1,0mm 0.040 inch	Ar 2-5%CO ₂	LSC3494	41,0060,3494
Stainless Steel	Cr 18 Ti ER439	Universal	1,0mm 0.040 inch	Ar 2-5%O ₂	LSC3495	41,0060,3495
Stainless Steel	Cr 18 Ti ER439	Universal	1,0mm 0.040 inch	Ar 5-10%CO ₂	LSC3496	41,0060,3496
Stainless Steel	Cr 18 Ti ER439	Universal	1,2mm 0.045 inch	Ar 2-5%O ₂	PMC3581	41,0060,3581
Stainless Steel	Cr 18 L Nb ER 430 L Nb	Universal	1,2mm 0.045 inch	Ar 2-5%O ₂	PMC3588	41,0060,3588
Stainless Steel	Cr 18 Ti ER439	Universal	0,9mm 0.035 inch	Ar 2-5%O ₂	PMC3598	41,0060,3598
Stainless Steel	Cr 18 L Nb ER 430 L Nb	Universal	0,9mm 0.035 inch	Ar 2-5%O ₂	PMC3614	41,0060,3614
Stainless Steel	Cr 18 Ti ER439	Universal	1,2mm 0.045 inch	Ar 2-5%O ₂	LSC3576	41,0060,3576
Stainless Steel	Cr 18 L Nb ER 430 L Nb	Universal	1,2mm 0.045 inch	Ar 2-5%O ₂	LSC3587	41,0060,3587
Stainless Steel	Cr 18 Ti ER439	Universal	0,9mm 0.035 inch	Ar 2-5%O ₂	LSC3589	41,0060,3589
Stainless Steel	Cr 18 L Nb ER 430 L Nb	Universal	0,9mm 0.035 inch	Ar 2-5%O ₂	LSC3590	41,0060,3590
Stainless Steel	Cr 18 Ti ER439	Universal	1,2mm 0.045 inch	Ar 2-5%O ₂	CMT3574	41,0060,3574
Stainless Steel	EC 439 Ti	Universal	1,2mm 0.045 inch	Ar 2-5%O ₂	CMT3575	41,0060,3575
Stainless Steel	EC 439 Ti	Mix	1,2mm 0.045 inch	Ar 2-5%O ₂	CMT3580	41,0060,3580
Stainless Steel	EC 409 Ti	Universal	1,2mm 0.045 inch	Ar 2-5%O ₂	CMT3585	41,0060,3585
Stainless Steel	Cr 18 L Nb ER 430 L Nb	Universal	1,2mm 0.045 inch	Ar 2-5%O ₂	CMT3597	41,0060,3597
Stainless Steel	Cr 18 Ti ER439	Universal	0,9mm 0.035 inch	Ar 2-5%O ₂	CMT3599	41,0060,3599
Stainless Steel	Cr 18 L Nb ER 430 L Nb	Universal	0,9mm 0.035 inch	Ar 2-5%O ₂	CMT3600	41,0060,3600
Stainless Steel	Cr 18 L Nb ER 430 L Nb	Mix	1,2mm 0.045 inch	Ar 2-5%O ₂	CMT3610	41,0060,3610
Stainless Steel	Cr 18 Ti ER439	Mix	0,9mm 0.035 inch	Ar 2-5%O ₂	CMT3613	41,0060,3613
Stainless Steel	Cr 18 Ti ER439	Mix	0,9mm 0.035 inch	Ar 2-5%O ₂	CMT3618	41,0060,3618
Stainless Steel	Cr 18 Ti ER439	Mix	1,2mm 0.045 inch	Ar 2-5%O ₂	CMT3628	41,0060,3628

Available Special Characteristics

	Material	Characteristic	Diameter	Gas	Process	Order number
Stainless Steel	CrNi 18 8 / 18 8 6 ER 307	Universal	1,0mm 0.040 inch	Ar 2-5%CO ₂	S3662	41,0060,3662
Stainless Steel	CrNi 18 8 / 18 8 6 ER 307	Universal	1,0mm 0.040 inch	Ar 2-5%CO ₂	P3663	41,0060,3663
Stainless Steel	CrNi 23 12 ER 309L	Universal	1,0mm 0.040 inch	Ar 2-5%CO ₂	S3664	41,0060,3664
Stainless Steel	CrNi 23 12 ER 309L	Universal	1,0mm 0.040 inch	Ar 2-5%CO ₂	P3665	41,0060,3665
Stainless Steel	Cr 18 L NbTi ER 430 L NbTi	Universal	1,0mm 0.040 inch	Ar 2-5%CO ₂	S3666	41,0060,3666
Stainless Steel	Cr 18 L NbTi ER 430 L NbTi	Universal	1,0mm 0.040 inch	Ar 2-5%CO ₂	P3667	41,0060,3667
Stainless Steel	Cr 18 L Nb ER 430 L Nb	Universal	1,0mm 0.040 inch	Ar 2-5%CO ₂	P3668	41,0060,3668
Stainless Steel	Cr 18 L Nb ER 430 L Nb	Universal	1,0mm 0.040 inch	Ar 2-5%CO ₂	S3669	41,0060,3669
Stainless Steel	Cr 18 L NbTi ER 430 L NbTi	Universal	1,0mm 0.040 inch	Ar 2-5%CO ₂	PMC3757	41,0060,3757
Stainless Steel	Cr 18 L Nb ER 430 L Nb	Universal	1,0mm 0.040 inch	Ar 2-5%CO ₂	PMC3758	41,0060,3758
Stainless Steel	CrNi 18 8 / 18 8 6 ER 307	Universal	1,0mm 0.040 inch	Ar 2-5%CO ₂	PMC3759	41,0060,3759
Stainless Steel	CrNi 23 12 ER 309L	Universal	1,0mm 0.040 inch	Ar 2-5%CO ₂	PMC3760	41,0060,3760
Stainless Steel	CrNi 22 12 ER 309	Universal	1,0mm 0.040 inch	Ar 2-5%CO ₂	PMC3761	41,0060,3761
Stainless Steel	CrNi 19 9 / 19 12 3 ER 308L / ER 316LSi	Universal	1,0mm 0.040 inch	Ar+2-5%O ₂	PMC3858	41,0060,3858
Stainless Steel	Cr 18 L Nb ER 430 L Nb	Universal	1,0mm 0.040 inch	Ar+2-5%O ₂	PMC3952	41,0060,3952
Stainless Steel	CrNi 18 14 Mn 11	Universal	1,2mm 0.045 inch	Ar+5%He+5%N ₂ +0,05%CO ₂	PMC3878	41,0060,3878
Stainless Steel	CrNi 25 9 CuT ER 2594	Universal	1,0mm 0.040 inch	Ar+30%He+0,25%CO ₂	PMC3140	41,0060,3140
Stainless Steel	CrNi 25 9 MCuT ER 2594	Universal	1,2mm 0.045 inch	Ar+30%He+0,25%CO ₂	PMC3141	41,0060,3141
Stainless Steel	CrNi 18 14 Mn 11	Universal	1,2mm 0.045 inch	Ar+2-5%CO ₂ +1-3%O ₂	PMC3875	41,0060,3875
Stainless Steel	CrNi 18 14 Mn 11	Universal	1,2mm 0.045 inch	Ar+2-5%CO ₂ +1-3%O ₂	LSC3877	41,0060,3877
Stainless Steel	CrNi 18 14 Mn 11	Universal	1,2mm 0.045 inch	Ar+5%He+5%N ₂ +0,05%CO ₂	LSC3882	41,0060,3882
Stainless Steel	CrNi 22 9 ER 2209	Universal	1,2mm 0.045 inch	Ar 2,5%CO ₂	CMT3872	41,0060,3872
Stainless Steel	CrNi 19 9 / 19 12 3 ER 308L / ER 316LSi	hotspot	1,0mm 0.040 inch	Ar 5-10%CO ₂	CMT3884	41,0060,3884
Stainless Steel	CrNi 18 14 Mn 11	ripple drive	1,2mm 0.045 inch	Ar 2-5%CO ₂ +1-3%O ₂	PMC3939	41,0060,3939
Stainless Steel	CrNi 20 25 ER 385	Universal	1,2mm 0.045 inch	Ar+20%He+0,11%CO ₂	PMC4059	41,0060,4059
Alu	AlMg 4,5Mn ER 5183	Universal	1,6mm 1/16 inch	Ar 50%He	PMC3063	41,0060,3063
Alu	AlMg 4,5Mn ER 5183	Universal	1,2mm 0.045 inch	Ar 30%He	PMC3088	41,0060,3088
Alu	AlMg 4,5Mn ER 5183	Universal	2,4mm 3/32 inch	Ar 100%	PMC3178	41,0060,3178
Alu	AlSi 5 ER 4043	Universal	1,2mm 0.045 inch	Ar 100%	PMC3198	41,0060,3198
Alu	AlMg 4,5Mn ER 5183	Universal	2,4mm 3/32 inch	Ar+50%He	PMC3258	41,0060,3258
Alu	AlMg 5 ER 5356	Universal	2,4mm 3/32 inch	Ar+50%He	PMC3260	41,0060,3260
Alu	AlMg 5 ER 5356	Universal	2,4mm 3/32 inch	Ar 100%	PMC3261	41,0060,3261
Alu	AlMg 4,5Mn ER 5183	PCS	1,2mm 0.045 inch	Ar 100%	PMC3324	41,0060,3324
Alu	AlMg 4,5Mn ER 5183	retro	1,6mm 1/16 inch	Ar 100%	PMC3399	41,0060,3399
Alu	AlMg 2,7Mn ER 5454	Universal	1,6mm 1/16 inch	Ar 100%	PMC3407	41,0060,3407
Alu	AlMg 5 ER 5356	Universal	1,2mm 0.045 inch	Ar+70%He	PMC3506	41,0060,3506
Alu	AlSi 5 ER 4043	Mix	1,2mm 0.045 inch	Ar 100%	CMT3530	41,0060,3530
Alu	AlMg 5Mn1Ti ER 5556	Universal	1,2mm 0.045 inch	Ar+25%He	PMC3747	41,0060,3747
Alu	Al 99,5 ER 1050	Universal	1,2mm 0.045 inch	Ar 100%	CMT3756	41,0060,3756
Alu	AlSi 5 ER 4043	Universal	1,6mm 1/16 inch	Ar 75%He	PMC3754	41,0060,3754
Alu	AlMg 5 ER 5356	Universal	1,0mm 0.040 inch	Ar 100%	PMC3769	41,0060,3769
Alu	AlMg 4,5Mn ER 5183	Dynamic	1,6mm 1/16 inch	Ar+50%He	PMC3829	41,0060,3829

Available Special Characteristics

	Material	Characteristic	Diameter	Gas	Process	Order number
Alu	AlMg 5 ER 5356	Universal	0,8mm 0.030 inch	Ar+He	PMC3832	41,0060,3832
Alu	AlCu6MnZrTi ER2319	Universal	1,6mm 1/16 inch	Ar+30%He	PMC3765	41,0060,3765
Alu	AlCu6MnZrTi ER2319	Universal	1,6mm 1/16 inch	He 100%	PMC3919	41,0060,3919
Alu	AlMg 4,5Mn (Zr) ER 5183	Universal	2,0mm 5/64 inch	Ar+50%He	PMC3862	41,0060,3862
Alu	AlSi 5 ER 4043	Universal	1,2mm 0.045 inch	Ar 100%	PMC3942	41,0060,3942
Alu	AlMg 4,5Mn (Zr) ER 5087	Dynamic	1,6mm 1/16 inch	Ar+30%He	PMC4051	41,0060,4051
Alu	AlMg 4,5Mn (Zr) ER 5087	Additive	1,2mm 0.045 inch	Ar 100%	CMT4062	41,0060,4062
Ni-Base	NiCr20Mn3Nb ER NiCr-3	Universal	1,2mm 0.045 inch	Ar 100%	PMC3127	41,0060,3127
Ni-Base	NiCr20Mn3Nb ER NiCr-3	Universal	1,2mm 0.045 inch	Ar 100%	LSC3128	41,0060,3128
Ni-Base	NiCrMo-3 ER NiCrMo-3	Cladding	1,0mm 0.040 inch	Ar+30%He+2%H2+0,05%CO2	PMC3144	41,0060,3144
Ni-Base	NiCrMo-3 ER NiCrMo-3	Cladding	1,2mm 0.045 inch	Ar+30%He+2%H2+0,05%CO2	PMC3145	41,0060,3145
Ni-Base	NiCr23Mo16 ER NiCrMo-13	Universal	1,0mm 0.040 inch	Ar+20-30%He+2%CO2	PMC3146	41,0060,3146
Ni-Base	NiCr23Mo16 ER NiCrMo-13	Universal	1,2mm 0.045 inch	Ar+20-30%He+2%CO2	PMC3147	41,0060,3147
Ni-Base	NiCrMo-3 ER NiCrMo-3	Universal	1,0mm 0.040 inch	Ar+20-30%He+2%CO2	PMC3166	41,0060,3166
Ni-Base	NiCrMo-3 ER NiCrMo-3	Universal	1,2mm 0.045 inch	Ar+20-30%He+2%CO2	PMC3167	41,0060,3167
Ni-Base	Ni 36 ER Ni-36	Universal	1,2mm 0.045 inch	Ar+30%He+2%H2+0,05%CO2	PMC3191	41,0060,3191
Ni-Base	Ni 36 ER Ni-36	Universal	1,2mm 0.045 inch	Ar+30%He	PMC3207	41,0060,3207
Ni-Base	NiCr20Mn3Nb ER NiCr-3	Cladding	1,2mm 0.045 inch	Ar+30%He+2%H2+0,05%CO2	PMC3213	41,0060,3213
Ni-Base	DO*23	Universal	1,2mm 0.045 inch	Ar 15-20%CO2	PMC3218	41,0060,3218
Ni-Base	NiCrMo-4 ER NiCrMo-4	Universal	1,2mm 0.045 inch	Ar 100%	PMC3305	41,0060,3305
Ni-Base	Ni 36 ER Ni-36	Universal	1,0mm 0.040 inch	Ar 100%	LSC3417	41,0060,3417
Ni-Base	NiCrMo-3 ER NiCrMo-3	Pipe	1,0mm 0.040 inch	He+49%Ar+1%CO2	PMC3331	41,0060,3331
Ni-Base	NiCrMo2,5-IG ER 110S-G	Universal	1,2mm 0.045 inch	Ar 15-20%CO2	PMC3539	41,0060,3539
Ni-Base	NiMoCr ER 100S-G	Universal	1,2mm 0.045 inch	Ar 15-20%CO2	PMC3540	41,0060,3540
Ni-Base	NiCrMo-2 ER NiCrMo2.005	Universal	0,9mm 0.035 inch	Ar 100%	PMC3594	41,0060,3594
Ni-Base	NiCrMo-3 ER NiCrMo-3	Mix Drive	1,0mm 0.040 inch	He+49%Ar+1%CO2	PMC3611	41,0060,3611
Ni-Base	NiCrMo-2 ER NiCrMo2.005	Root	0,9mm 0.035 inch	Ar 100%	LSC3591	41,0060,3591
Ni-Base	NiCr19NbMo ER NiFeCr-2	Cladding	1,2mm 0.045 inch	Ar 100%	PMC3645	41,0060,3645
Ni-Base	NiCr19NbMo ER NiFeCr-2	Additive	1,2mm 0.045 inch	Ar 100%	CMT3637	41,0060,3637
Ni-Base	NiCr19NbMo ER NiFeCr-2	Mix	1,2mm 0.045 inch	Ar 100%	CMT3647	41,0060,3647
Ni-Base	NiCu30MnTi ER NiCu-7	Cladding	1,2mm 0.045 inch	Ar 100%	PMC3654	41,0060,3654
Ni-Base	NiCu30MnTi ER NiCu-7	Cladding	1,2mm 0.045 inch	Ar+30%He	PMC3655	41,0060,3655
Ni-Base	NiCu30MnTi ER NiCu-7	Cladding	1,2mm 0.045 inch	Ar+30%He+0,5%CO2	PMC3656	41,0060,3656
Ni-Base	Ni 36 ER Ni-36	Additive	1,2mm 0.045 inch	Ar 2-5%CO2	CMT3742	41,0060,3742
Ni-Base	NiCrMo-3 ER NiCrMo-3	Cladding	1,2mm 0.045 inch	Ar+30%He+0,5%CO2	PMC3543	41,0060,3543
Ni-Base	NiCu30MnTi ER NiCu-7	Mix	1,2mm 0.045 inch	Ar 100%	CMT3441	41,0060,3441
Ni-Base	NiCu30MnTi ER NiCu-7	Cladding	1,2mm 0.045 inch	Ar 100%	CMT3737	41,0060,3737
Ni-Base	NiCrMo-3 ER NiCrMo-3	retro	1,2mm 0.045 inch	Ar 100%	CMT3816	41,0060,3816
Ni-Base	Ni Fe-2 ER Ni Fe-2	Cladding	1,2mm 0.045 inch	Ar+2,5%CO2	CMT3828	41,0060,3828
Ni-Base	NiCrMo-3 ER NiCrMo-3	Cladding	1,0mm 0.040 inch	Ar+30%He+2%H2+0,05%CO2	CMT3921	41,0060,3921
Ni-Base	NiCrMo-3 ER NiCrMo-3	Cladding	1,2mm 0.045 inch	Ar+30%He+2%H2+0,05%CO2	CMT3922	41,0060,3922
Ni-Base	NiCrMo-3 ER NiCrMo-3	Pipe cladding	1,0mm 0.040 inch	Ar+30%He+2%H2+0,05%CO2	CMT3948	41,0060,3948

Available Special Characteristics

	Material	Characteristic	Diameter	Gas	Process	Order number
Ni-Base	NiCrMo-3 ER NiCrMo-3	Pipe cladding	1,0mm 0.040 inch	Ar+30%He+2%H ₂ +0,05%CO ₂	PMC3945	41,0060,3945
Ni-Base	NiCrMo-3 ER NiCrMo-3	Pipe cladding	1,2mm 0.045 inch	Ar+30%He+2%H ₂ +0,05%CO ₂	PMC3946	41,0060,3946
Ni-Base	NiCr23Mo16 ER NiCrMo-13	flanged edge	1,2mm 0.045 inch	Ar 2-5%CO ₂	CMT3868	41,0060,3868
Ni-Base	Ni 36 ER Ni-36	Universal	1,2mm 0.045 inch	Ar 2-5%CO ₂	PMC3774	41,0060,3774
Ni-Base	NiCr23Mo16 ER NiCrMo-13	ripple drive	1,2mm 0.045 inch	Ar 2,5%CO ₂	PMC3866	41,0060,3866
Ni-Base	NiCrMo-3 ER NiCrMo-3	Mix	1,2mm 0.045 inch	Ar+30%He+0,5%CO ₂	CMT4084	41,0060,4084
Cu-Base	CuNi30Mn	Universal	1,0mm 0.040 inch	Ar 100%	PMC3634	41,0060,3634
Flux Cored Wire	SK ABRA-MAX O/G	Cladding	1,6mm 1/16 inch	Ar 15-20%CO ₂	PMC3228	41,0060,3228
Flux Cored Wire	Metal cored DC-	Universal	0,9mm 0.035 inch	Ar 8-10%CO ₂	LSC3239	41,0060,3239
Flux Cored Wire	Metal cored DC-	Universal	1,0mm 0.040 inch	Ar 8-10%CO ₂	LSC3240	41,0060,3240
Flux Cored Wire	Metal cored DC-	Universal	1,2mm 0.045 inch	Ar 8-10%CO ₂	LSC3241	41,0060,3241
Flux Cored Wire	Metal cored	Galvanized	1,0mm 0.040 inch	Ar 8-10%CO ₂	LSC3242	41,0060,3242
Flux Cored Wire	Metal cored	Galvanized	1,0mm 0.040 inch	Ar 8-10%CO ₂	PMC3243	41,0060,3243
Flux Cored Wire	DO*30	Cladding	1,2mm 0.045 inch	Ar 15-20%CO ₂	PMC3308	41,0060,3308
Flux Cored Wire	Corodur 55	Cladding	2,4mm 3/32 inch	no Gas	LSC3326	41,0060,3326
Flux Cored Wire	CrNi 25 9 4 E2594 T1-4/-1 ER 309L	Universal	1,2mm 0.045 inch	Ar 15-20%CO ₂	LSC3504	41,0060,3504
Flux Cored Wire	Steel Metal Core	Universal	1,4mm 0.052 inch	Ar 15-20%CO ₂	PMC3582	41,0060,3582
Flux Cored Wire	FCW Rutil E71 T-1 H4	Universal	1,2mm 0.045 inch	Ar 15-20%CO ₂	PMC3583	41,0060,3583
Flux Cored Wire	Steel Metal Core	Universal	1,2mm 0.045 inch	Ar 15-20%CO ₂	PMC3584	41,0060,3584
Flux Cored Wire	FCW Hardfacing CoCrMo	Cladding	1,6mm 1/16 inch	Ar 100%	PMC3505	41,0060,3505
Flux Cored Wire	FCW Basic	Universal	2,4mm 3/32 inch	Ar 25%CO ₂	PMC3660	41,0060,3660
Flux Cored Wire	FCW Basic	Universal	2,4mm 3/32 inch	100% CO ₂	LSC3657	41,0060,3657
Flux Cored Wire	FCW Basic	Universal	2,4mm 3/32 inch	Ar 25%CO ₂	LSC3658	41,0060,3658
Flux Cored Wire	MC CMnSi DC- E 70C GS	Universal	1,0mm 0.040 inch	Ar 15-20%CO ₂	CMT3736	41,0060,3736
Flux Cored Wire	MC CrC DC-	Cladding	1,2mm 0.045 inch	100% CO ₂	CMT3725	41,0060,3725
Flux Cored Wire	FCW CrNi E410NiMoT1-4	Universal	1,6mm 1/16 inch	Ar 20-25%CO ₂	LSC3789	41,0060,3789
Flux Cored Wire	Metal cored	Galvanized	1,2mm 0.045 inch	Ar 15-20%CO ₂	CMT3861	41,0060,3861
Flux Cored Wire	Metal cored	Galvanized	1,2mm 0.045 inch	Ar 15-20%CO ₂	CMT3865	41,0060,3865
Flux Cored Wire	MC NiW42C	Cladding	1,6mm 1/16 inch	100% CO ₂	CMT3947	41,0060,3947
Flux Cored Wire	FCE Hardfacing Cr30	Cladding	1,6mm 1/16 inch	no Gas	CMT4088	41,0060,4088
HS Steel	Mn3Ni1CrMo ER110S-G	Universal	1,0mm 0.040 inch	Ar 15-20%CO ₂	PMC3370	41,0060,3370
HS Steel	Steel Cr1,5Mo1V	Universal	0,8mm 0.030 inch	Ar 15-20%CO ₂	PMC3764	41,0060,3764
HS Steel	High strenght steel	arc blow	0,8mm 0.030 inch	Ar 15-20%CO ₂	PMC3857	41,0060,3857
Titanium	Ti 99	Universal	1,0mm 0.040 inch	Ar 100%	CMT3538	41,0060,3538
Titanium	Ti 6 Al 4V	Universal	1,2mm 0.045 inch	Ar 100%	PMC3627	41,0060,3627
Titanium	Ti 6 Al 4V	Additive	1,0mm 0.040 inch	Ar 100%	CMT3622	41,0060,3622
Titanium	Ti 6 Al 4V	Additive	1,2mm 0.045 inch	Ar 100%	CMT3626	41,0060,3626
Titanium	Ti 6 Al 4V	Mix	1,2mm 0.045 inch	Ar 100%	CMT3632	41,0060,3632
Magnesium	AZ61A	Universal	1,2mm 0.045 inch	Ar 100%	PMC3621	41,0060,3621
	EIPA 150B	Universal	1,2mm 0.045 inch	Ar 15-18%CO ₂	PMC3195	41,0060,3195
	Stellite 6 ER CCoCr-A	Cladding	1,2mm 0.045 inch	Ar 100%	PMC3298	41,0060,3298

Available Special Characteristics

	Material	Characteristic	Diameter	Gas	Process	Order number
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Notiz / Note :

WAAM / Additive Characteristic name change from WAAM to additive

- LSC3124

Schweißigenschaften speziell im Übergangslichtbogenbereich angepasst an TPS Kennlinie S0008 (Kundenwunsch)
Welding characteristics in the intermediate arc range modified according to TPS synergic line S0008 (customer request)
- LSC3173

Schweißigenschaften speziell im Übergangslichtbogenbereich angepasst an TPS Kennlinie S0370 (Kundenwunsch)
Welding characteristics in the intermediate arc range modified according to TPS synergic line S0370 (customer request)

Welding characteristics

Je nach Schweißprozess und Schutzgas-Kombination stehen bei der Auswahl des Zusatzmaterials verschiedene Prozess-optimierte Schweiß-Kennlinien zur Verfügung. Die neben dem Schweißprozess zusätzliche Kennzeichnung gibt Auskunft über besondere Eigenschaften und die Verwendung der Schweiß-Kennlinie:
Depending on the welding process and shielding gas mix, various process-optimised welding characteristics are available when selecting the filler metal. The additional labelling next to the welding process provides information about the special properties and use of the welding characteristic:

arc blow	Kennlinien mit verbesserten Eigenschaften gegen Lichtbogen-Abriss durch Ablenkung bei äußeren magnetischen Feldern <i>Characteristic with improved arc break properties by deflecting the external magnetic fields</i>
braze	Kennlinien für Lötprozesse (hohe Lötgeschwindigkeit, sichere Benetzung und gutes Ausfließen des Lotwerkstoffes) <i>Characteristic for brazing processes (high brazing speed, reliable wetting and good flow of braze material)</i>
braze +	Kennlinien für Lötprozesse mit speziell verengter Gasdüse mit kleiner Öffnung für hohen Gas Strömungsgeschwindigkeiten (hohe Lötgeschwindigkeit, sichere Benetzung und gutes Ausfließen des Lotwerkstoffes) <i>Characteristic for brazing processes with special narrow gas nozzle with tight opening for high gas flow rate (high brazing speed, reliable wetting and good flow of braze material)</i>
cladding	Kennlinien für Auftragsschweißungen mit wenig Einbrand, geringer Aufmischung und breitem Naht-Ausfließen für bessere Benetzung <i>Characteristic for cladding with low penetration, low dilution and wide weld seam flow for improved wetting</i>
dynamic	Kennlinien für hohe Schweißgeschwindigkeiten mit konzentriertem Lichtbogen <i>Characteristic for high welding speeds with concentrated arc</i>
galvanized	Kennlinien für verzinkte Blechoberflächen (geringe Zinkporen-Gefahr, reduzierter Zinkabbrand/reduzierter Zinkabbrand) <i>Characteristic for galvanised sheet surfaces (low zinc pore risk, reduced zinc melting loss)</i>
root	Kennlinien für Wurzelschweißungen mit druckvollem Lichtbogen <i>Characteristic for root passes with powerful arc</i>
open root	Kennlinien für Wurzelschweißungen mit angepassten Lichtbogen-Druck, lässt die Wurzel nicht durchfallen <i>Characteristic for root passes with modified arc pressure, prevents the root pass from falling through</i>
universal	Kennlinien für konventionelle Schweißaufgaben <i>Characteristic for conventional welding tasks</i>
mix	Kennlinien mit einem Prozesswechsel zwischen Impuls- und Kurzlichtbogen Speziell für das Steгнаht-Schweißen mit zyklischem Wechsel einer heißen und kalten, stützenden Prozessphase. <i>Characteristic with process switch between pulsed and dip transfer arc Specifically designed for welding vertical-up seams with cyclical switching between a hot and cold supporting process phase.</i>
PCS Pulse Controlled Sprayarc	Direkter Übergang vom konzentrierten Impuls- in einen kurzen Sprühlichtbogen. Die Vorteile vom Impuls- und Standardlichtbogen werden in einer Kennlinie vereint. <i>Direct transition from the concentrated pulsed arc to a short spray arc. The advantages of pulsed and standard arcs combined in a single characteristic.</i>
mix drive	Nur möglich mit zusätzlicher Hardware: PulMIG CMT; RA Drive; RA Drive CMT Kennlinien mit einem Prozesswechsel zwischen Impuls- und Kurzlichtbogen, wobei der Kurzlichtbogen mit einer Drahtbewegungs-Umkehr eingeleitet wird <i>Only possible with additional hardware: PulMIG CMT; RA Drive; RA Drive CMT Characteristic with process switch between pulsed and dip transfer arc, where the dip transfer arc is initiated by wire movement reversal.</i>
ripple drive	Nur möglich mit zusätzlicher Hardware: PulMIG CMT; RA Drive; RA Drive CMT Kennlinien mit einem Prozesswechsel zwischen Impuls- und Kurzlichtbogen, wobei der Kurzlichtbogen mit einer Drahtbewegungs-Umkehr eingeleitet wird Speziell für schön gegliedertes Nahtaussehen! <i>Only possible with additional hardware: PulMIG CMT; RA Drive; RA Drive CMT Characteristic with process switch between pulsed and dip transfer arc, where the dip transfer arc is initiated by wire movement reversal. Special for nice scaled weklings seams!</i>
Multi Arc	Kennlinie mit verbesserten Eigenschaften wenn mehrere Lichtbögen auf einem Bauteil schweißen die sich gegenseitig beeinflussen Verbesserte Eigenschaften auch bei langen Verbindungsschlauchpaketen, oder wenn mehrere Schlauchpakete parallel verlegt sind <i>Synergic line with improved characteristic if multiple arcs are welding on one part who influence each other Improved characteristic with long connection hose packs or if multiple hose packs are arranged parallel to each other</i>
Additive	Wire Arc Additive manufacturing
Gap bridging	Kennlinien mit verbesserten Eigenschaften zur Spaltüberbrückung <i>Synergic line with impoved characteristic for gap bridging</i>
Arcing	Kennlinien für eine spezielle Form der Hartauftragung auf trockenem und nassen Untergrund (z.B. auf Zerkleinerungswalzen in der Zucker- und Ethanolindustrie) <i>Characteristic for a special type of hardfacing on a wet or dry surface (e.g. grinding rollers in the sugar and ethanol industries)</i>
Pipe	Kennlinien für Rohranwendungen und Positionsschweißungen an Engspalt Anwendungen <i>Characteristic for pipe applications and positional welding on narrow gap applications</i>
Pipe cladding	Kennlinien für Rohranwendungen, wenig Einbrand und geringe Aufmischung mit breitem Nahtausfließen <i>Characteristic for pipe applications, low penetration and low fusion with wide seam bead for improved wetting</i>
TIME	Kennlinien für das Schweißen mit langem Stick-Out und TIME-Schutzgasen, welche Vorteile im Sprühlichtbogen bieten <i>Characteristics for welding with long stick out and TIME shielding gases, advantages in the spray arc</i>
Retro	Eigenschaften ähnlich der TPS Charakteristik <i>similar properties to TPS characteristic</i>
Weld +	Kennlinien für kurzen Stickout mit speziell verengter Gasdüse mit kleiner Öffnung für hohen Gas Strömungsgeschwindigkeit <i>Characteristic for short stickout with special narrow gas nozzle with tight opening for high gas flow rate</i>
hotspot	CMT Kennlinien mit heißer Startabfolge, speziell für Lochnähte und MIG/MAG Punktschweißverbindungen <i>CMT characteristics with hot start sequence, especially for plug welds and MIG/MAG spot-welded joints</i>