

# TSt 2700c MP USA welding pro- gram table

Pos.		inch	mm		Pos.
1	Steel				
2	Steel dynamic	.030	0.8		
3	Steel root	.035	0.9	CO <sub>2</sub> 100%	A
4	Rutil / E 71 T	.040	1.0	Ar + 8-12% CO <sub>2</sub>	B
5	Basic / E 70 T	.045	1.2	Ar + 15-25% CO <sub>2</sub>	C
6	Metal Cored	.052	1.4	Ar + 3-6% O <sub>2</sub>	D
7	Self-shielded	1/16	1.6	Ar 100%	E
8	SP	SP	SP	SP	F

## UID 3826 welding program database

Standard Programs									
Material		Gas		Diameter					
Pos.		Pos.		0,8 mm .030"	0,9 mm .035"	1,0 mm .040"	1,2 mm .045"	1,4 mm .052"	1,6 mm 1/16"
1	Steel	A	100 % CO <sub>2</sub>	2290	2300	2310	2322		
1	Steel	B	Ar + 8-12 % CO <sub>2</sub>	2418	2370	2308	2377		
1	Steel	C	Ar + 15-25 % CO <sub>2</sub>	2419	2369	2309	2376		
1	Steel	D	Ar + 3-6 % O <sub>2</sub>	2372	2371	2307	2378		
2	Steel dynamic	B	Ar + 8-12 % CO <sub>2</sub>	2374	2367	2312	2380		
2	Steel dynamic	C	Ar + 15-25 % CO <sub>2</sub>	2375	2366	2313	2379		
2	Steel dynamic	D	Ar + 3-6 % O <sub>2</sub>	2373	2368	2311	2381		
3	Steel root	A	100 % CO <sub>2</sub>	2502	2501	2499	2500		
3	Steel root	B	Ar + 8-12 % CO <sub>2</sub>	2295	2364	2315	2383		
3	Steel root	C	Ar + 15-25 % CO <sub>2</sub>	2296	2363	2316	2382		
3	Steel root	D	Ar + 3-6 % O <sub>2</sub>	2294	2365	2314	2384		
4	Rutil FCW	A	100 % CO <sub>2</sub>		2471		2472		
4	Rutil FCW	C	Ar + 15-25 % CO <sub>2</sub>		2470		2456		
5	Basic FCW	A	100 % CO <sub>2</sub>				2474		
5	Basic FCW	C	Ar + 15-25 % CO <sub>2</sub>				2473		
6	Metal cored	B	Ar + 8-12 % CO <sub>2</sub>		2420		2385		
6	Metal cored	C	Ar + 15-25 % CO <sub>2</sub>		2421		2386		
7	Self-shielded				2350		2349		

Special assignment									
Material		Gas		Diameter					
Pos.		Pos.		0,8 mm .030"	0,9 mm .035"	1,0 mm .040"	1,2 mm .045"	1,4 mm .052"	1,6 mm 1/16"
2	Steel dynamic	F	Ar + 8-12 % CO <sub>2</sub>		2462				
3	Stainless Steel root	F	Ar + 2,5 % CO <sub>2</sub>	2440	2441	2442	2443		
6	FCW Stainless Steel	F	Ar + 18 % CO <sub>2</sub>		2423		2424		
8	Stainless Steel	A	Ar + 90He + 2,5 % CO <sub>2</sub>		2404		2407		
8	Stainless Steel	B	Ar + 33He + 1 % CO <sub>2</sub>		2403		2406		
8	Stainless Steel	C	Ar + 2,5 % CO <sub>2</sub>	2427	2402	2426	2405		
6	FCW Stainless Steel	F	Ar + 18 % CO <sub>2</sub>		2423		2424		
8	FCW MAP409Ti	D	Ar + 2 % O <sub>2</sub>				2464		
8	AlMg5	E	100 % Ar			3639	3643		
1	AlSi5	E	100 % Ar			3640	3092		
8	CuSi3	F	100 % Ar (Ar + 2,5 % CO <sub>2</sub> )	2496	2495	2493	2497		