



















































Welding program tables

Welding program label on the device

A label with the most common welding programs is affixed to the power source:

Standard welding characteristics									
Tst - 4000&5000 Pulse KL-DB: 3994	Configuration		Ø [mm / inch]						
			0.8 .030	0.9 .035	1.0 .040	1.2 .045	1.4 .052	1.6 1/16	
Steel ER 70-120 CO ₂ 100%	1 		A	—	—	—	—	—	
Steel ER 70-120 Ar+2-12%CO ₂	1 		B	—	—	—	—	—	
Steel ER 70-120 Ar+13-25%CO ₂	1 		C	—	—	—	—	—	
Steel ER 70-120 Ar+2-8%CO ₂	1 		D	—	—	—	—	—	
CrNi Stainless Ar+2-12%CO ₂	2 		B	—	—	—	—	—	
CuSi3 ER CuSi-A Ar 100%	3 		E	—	—	—	—	—	
AlMg ER 5xxx Ar 100%	4 		E	—	—	—	—	—	
AlSi ER 4xxx Ar 100%	5 		E	—	—	—	—	—	
Metal Cored Ar+2-12%CO ₂	6 		B	—	—	—	—	—	
Metal Cored Ar+13-25%CO ₂	6 		C	—	—	—	—	—	
Shelf-shielded	7 			—	—	—	—	—	

Additional welding characteristics									
Tst - 4000&5000 Pulse KL-DB: 3994	SP Configuration		Ø [mm / inch]						
			0.8 .030	0.9 .035	1.0 .040	1.2 .045	1.4 .052	1.6 1/16	
CrNi Stainless FCW Ar+ 15-25%CO ₂	8 	SP 	A	—	—	—	—	—	
CrNi Stainless root Ar+ 2,5%CO ₂	8 	SP 	B	—	—	—	—	—	
Rutil FCW E71T FCW CO ₂ 100%	8 	SP 	C	—	—	—	—	—	
Rutil FCW E71T FCW Ar+ 15-25%CO ₂	8 	SP 	D	—	—	—	—	—	
Basic FCW E70T FCW CO ₂ 100%	8 	SP 	E	—	—	—	—	—	
Basic FCW E70T FCW Ar+ 15-25%CO ₂	8 	SP 	F	—	—	—	—	—	
Steel dyn ER70-120 Ar+ 8-10%CO ₂	1 	SP 	F	—	—	—	—	—	
Steel dyn ER70-120 Ar+ 15-25%CO ₂	2 	SP 	F	—	—	—	—	—	
Steel dyn ER70-120 Ar+ 4%CO ₂	3 	SP 	F	—	—	—	—	—	
Steel root CO ₂ 100%	4 	SP 	F	—	—	—	—	—	
Steel root / PCS Ar+ 8-10%CO ₂	5 	SP 	F	—	—	—	—	—	
Steel root / PCS Ar+ 15-25%CO ₂	6 	SP 	F	—	—	—	—	—	

42,0409,0732 — Standard  Pulse

Welding program label on the power source



Welding program tables for Trans-Steel 4000 Pulse, TransSteel 5000 Pulse









































1	Steel/ER 70-120	inch	mm			
2	CrNi/Stainless	.030	0,8			
3	CuSi/ER CuSi-A	.035	0,9	CO ₂ 100%	A	
4	AlMg/ER 5xxx	.040	1,0	Ar + 2-12% CO ₂	B	
5	AlSi/ER 4xxx	.045	1,2	Ar + 13-25% CO ₂	C	
6	Metal Cored	.052	1,4	Ar + 2-8% O ₂	D	
7	Self-shielded	1/16	1,6	Ar 100%	E	
8	SP	SP	SP	SP	F	

The welding programs are active if

- The "SEI" setup parameter is set to "Std" (Standard) or
- The VR 5000 Remote wirefeeder is equipped with the VR Pulse control panel option.

Welding program database: DB 3994

Standard welding characteristics										
Material	Gas	Configuration		Diameter						
				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"	SP
Steel/ER70-120	CO ₂ 100%	1	A	S2290	S2300	S2310	S2322	S2334		
Steel/ER70-120	Ar + 2-12% CO ₂	1	B	S2288 P4000	S2298 P4001	S2308 P3977	S2324 P3979	S2332 P4002	S2394 P4003	
Steel/ER70-120	Ar + 13-25% CO ₂	1	C	S2485 P4006	S2486 P3990	S2487 P3958	S2488 P3987	S2489 P4005	S2490 P4004	
Steel/ER70-120	Ar + 2-8% O ₂	1	D	S2285	S2297	S2307	S2323	S2331	S2395	
CrNi/Stainless	Ar + 2-12% CO ₂	2	B	S2427 P3969	S2402 P3970	S2426 P3968	S2405 P3966		S2428 P3965	
CuSi/ER-CuSi-A	Ar 100%	3	E	S2496 P3973	S2495 P3974	S2493 P3976	S2497 P3975		S2498 P3972	
AlMg/ER 5xxx	Ar 100%	4	E		P3955	S3639 P3956	S3643 P3953		P3957	
AlSi/ER 4xxx	Ar 100%	5	E			S3640 P3961	S3092 P3960		P3959	
Metall Cored	Ar + 2-12% CO ₂	6	B		S2420		S2385 P3980	S2387 P3984	S2415 P3982	
Metall Cored	Ar + 13-25% CO ₂	6	C		S2421		S2536 P3983	S2388 P3981	S2343 P3985	
Self-shielded	(no Gas)	7			S2350		S2349		S2348	

Additional welding characteristics										
Material	Gas	Configuration		Diameter						SP
				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"	
CrNi/Stainless FCW	Ar + 18% CO ₂	8  SP	 A		S2423 P4014		S2424 P4013		S2425 P4015	
CrNi/Stainless root	Ar + 18% CO ₂	8  SP	 A	S2440	S2441	S2442	S2443			
Rutil FCW/E71T FCW	CO ₂ 100%	8  SP	 C		S2471		S2472	S2467	S2469	
Rutil FCW/E71T FCW	Ar + 18% CO ₂	8  SP	 D		S2411		S2320 P4007	S2390 P4009	S2344 P4008	
Basic FCW/E70T FCW	CO ₂ 100%	8  SP	 E				S2474	S2433	S2476	
Basic FCW/E70T FCW	Ar + 25% CO ₂	8  SP	SP  F				S2473 P4011	S2432 P4010	S2475 P4012	
Steel dyn/ER70-120	Ar + 8% CO ₂	1 	SP  F	S2292	S2302	S2312	S2326	S2336		
Steel dyn/ER70-120	Ar + 18% CO ₂	2 	SP  F	S2293	S2303	S2313	S2327	S2337		
Steel dyn/ER70-120	Ar + 4% CO ₂	3 	SP  F	S2291	S2301	S2311	S2325	S2335		
Steel/root	CO ₂ 100%	4 	SP  F	S2502	S2501	S2499	S2500			
Steel/root PCS	Ar + 8% CO ₂	5 	SP  F	S3962	S2305 P3997	S2315 P3978	S2329 P3986	S2339 P3998	P3999	
Steel/root PCS	Ar + 18% CO ₂	6 	SP  F	S4017	S2306 P3993	S2316 P3967	S2330 P3989	S2340 P3996	P3995	
Steel/root	Ar + 4% O ₂	8 	SP  F	S2294	S2304	S2314				S2328 (1)
CrNi/Stainless	Ar + 90He + 2,5% CO ₂	2 	 A							S2404 (2)
CrNi/Stainless	Ar + 90He + 2,5% CO ₂	2 	 B							S2407 (1)
CrNi/Stainless	Ar + 33He + 1% CO ₂	2 	 C							S2403 (2)
CrNi/Stainless	Ar + 33He + 1% CO ₂	2 	 D							S2406 (1)
MAP409Ti FCW	Ar + 2% O ₂	2 	 E							S2464 (1)
MAP409Ti FCW	Ar + 2% O ₂	2 	SP  F							S2465 (3)

























(1) d = 1.2 mm






















































(2) d = 0.9 mm

(3) d = 1.4 mm

	Steel/ER 70-120	Inch	mm	
2	CrNi/Stainless	.030	0,8	
3	CuSi/ER CuSi-A	.035	0,9	CO ₂ 100%
4	AlMg/ER 5xxx	.040	1,0	Ar + 2-12% CO ₂
5	AlSi/ER 4xxx	.045	1,2	Ar + 13-25% CO ₂
6	Metal Cored	.052	1,4	Ar + 2-8% O ₂
7	Self-shielded	1/16	1,6	Ar 100%
8	SP	SP	SP	SP

- The VR 5000 Remote wirefeeder is equipped with the VR Pulse control panel option.

Standard welding characteristics										
Material	Gas	Configuration		 Diameter						SP
				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"	
Steel/ER70-120	CO ₂ 100%	1 	 A	S2290	S2300	S2310	S2322	S2334	S2347	
Steel/ER70-120	Ar + 2-12% CO ₂	1 	 B	S2418 P4000	S2370 P4001	S2308 P3977	S2377 P3979	S2409 P4002	S2394 P4003	
Steel/ER70-120	Ar + 13-25% CO ₂	1 	 C	S2419 P4006	S2369 P3990	S2309 P3958	S2376 P3987	S2333 P4005	S2490 P4004	
Steel/ER70-120	Ar + 2-8% O ₂	1 	 D	S2285	S2297	S2307		S2331	S2395	
CrNi/Stainless	Ar + 2-12% CO ₂	2 	 B	S2427 P3969	S2402 P3970	S2426 P3968	S2405 P3966		S2428 P3965	
CuSi/ER-CuSi-A	Ar 100%	3 	 E	S2496 P3973	S2495 P3974	S2493 P3976	S2497 P3975			
AlMg/ER 5xxx	Ar 100%	4 	 E	P3955	P3956	S3639 P3954	S3643 P3953			
AlSi/ER 4xxx	Ar 100%	5 	 E			S3640 P3961	S3092 P3960		P3959	
Metall Cored	Ar + 2-12% CO ₂	6 	 B		S2420		S2385 P3980	S2387 P3984	S2415 P3982	
Metall Cored	Ar + 13-25% CO ₂	6 	 C				S2386 P3983	S2388 P3981	S2416 P3985	
Self-shielded	(no Gas)	7 			S2350		S2349		S2348	

Additional welding characteristics									
Material	Gas	Configuration		Diameter					
				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"
CrNi/Stainless FCW	Ar + 15-25% CO ₂	8  SP	 A		S2423 P4014		S2424 P4013		S2425 P4015
CrNi/Stainless root	Ar + 2,5% CO ₂	8  SP	 B	S2440	S2441	S2442	S2443		
Rutil FCW/E71T FCW	CO ₂ 100%	8  SP	 C		S2471		S2472	S2467	S2469
Rutil FCW/E71T FCW	Ar + 15-25% CO ₂	8  SP	 D		S2470		S2456 P4007	S2466 P4009	S2468 P4008
Basic FCW/E70T FCW	CO ₂ 100%	8  SP	 E				S2474	S2433	S2476
Basic FCW/E70T FCW	Ar + 15-25% CO ₂	8  SP	SP  F				S2473 P4011	S2432 P4010	S2475 P4012
Steel dyn/ER70-120	Ar + 8-10% CO ₂	1  	SP  F	S2374	S2367	S2312	S2380	S2336	
Steel dyn/ER70-120	Ar + 15-25% CO ₂	2  	SP  F	S2375	S2366	S2313	S2379	S2337	
Steel dyn/ER70-120	Ar + 4% O ₂	3  	SP  F	S2291	S2301	S2311	S2325	S2335	
Steel/root	CO ₂ 100%	4  	SP  F	S2502	S2501	S2499	S2500		
Steel/root PCS	Ar + 8-10% CO ₂	5  	SP  F	S2295	S2364 P3997	S2315 P3978	S2383 P3986	S2339 P3998	P3999
Steel/root PCS	Ar + 15-25% CO ₂	6  	SP  F	S2296	S2363 P3993	S2316 P3967	S2382 P3989	S2340 P3996	P3995
Steel/root	Ar + 4% O ₂	8  	SP  F	S2294	S2304	S2314			S2328 (1)
CrNi/Stainless	Ar + 90He + 2,5% CO ₂	2  	 A						S2404 (2)
CrNi/Stainless	Ar + 90He + 2,5% CO ₂	2  	 B						S2407 (1)
CrNi/Stainless	Ar + 33He + 1% CO ₂	2  	 C						S2403 (2)
CrNi/Stainless	Ar + 33He + 1% CO ₂	2  	 D						S2406 (1)
MAP409Ti FCW	Ar + 2% O ₂	2  	 E						S2464 (1)
MAP409Ti FCW	Ar + 2% O ₂	2  	SP  F						S2465 (3)

(1) d = 1.2 mm

(2) d = 0.9 mm

(3) d = 1.4 mm