
























































TSt 3500c MP USA welding pro- gram table

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

UID 3787 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"	SP
1	 Steel	A	 100 % CO2	2290	2300	2310	2322	2334		
1	 Steel	B	 Ar + 10 % CO2	2418	2370	2308	2377	2409		
1	 Steel	C	 Ar + 25 % CO2	2419	2369	2309	2376	2333		
1	 Steel	D	 Ar + 5 % O2	2372	2371	2307	2378	2408		
2	 Steel dynamic	B	 Ar + 10 % CO2	2374	2367	2312	2380	2336		
2	 Steel dynamic	C	 Ar + 25 % CO2	2375	2366	2313	2379	2337		
2	 Steel dynamic	D	 Ar + 5 % O2	2373	2368	2311	2381	2335		
3	 Steel root	A	 100 % CO2	2502	2501	2499	2500			
3	 Steel root	B	 Ar + 10 % CO2	2295	2364	2315	2383	2339		
3	 Steel root	C	 Ar + 25 % CO2	2296	2363	2316	2382	2340		2643*
3	 Steel root	D	 Ar + 5 % O2	2294	2365	2314	2384	2338		
4	 Rutil FCW	A	 100 % CO2		2471		2472	2467	2469	
4	 Rutil FCW	C	 Ar + 25 % CO2		2470		2456	2466	2468	
5	 Basic FCW	A	 100 % CO2				2474	2433	2476	
5	 Basic FCW	C	 Ar + 25 % CO2				2473	2432	2475	
6	 Metal cored	B	 Ar + 10 % CO2		2420		2385	2387	2415	
6	 Metal cored	C	 Ar + 25 % CO2		2421		2386	2388	2416	
7	 Self-shielded		Self-shielded		2350		2349		2348	

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"	SP
2	 Steel dynamic	F	 Ar + 10 % CO2		2462					
3	 Stainless Steel root	F	 Ar + 2,5 % CO2	2440	2441	2442	2443			
6	 FCW Stainless Steel	F	 Ar + 18 % CO2		2423		2424		2425	
8	 Stainless Steel	A	 Ar + 90 % He + 2,5 % CO2		2404		2407			
8	 Stainless Steel	B	 Ar + 33 % He + 1 % CO2		2403		2406			
8	 Stainless Steel	C	 Ar + 2,5 % CO2	2427	2402	2426	2405			
8	 FCW MAP409Ti	D	 Ar + 2 % O2				2464	2465		
8	 AlMg 5	E	 100 % Ar			3639	3643			
1	 AlSi	E	 100 % Ar			3640	3092			
8	 CuSi 3	F	 SP	2496	2495	2493	2497			

* Diameter = 1.2 mm (0.45 inch)