



















































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 - 3000 Pulse KL-DB: 3992		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	CO2 100%	1 	 A	—	—	—	—	—	—
Steel ER 70-120	Ar+2-12%CO2	1 	 B	—	—	—	—	—	—
Steel ER 70-120	Ar+13-25%CO2	1 	 C	—	—	—	—	—	—
Steel ER 70-120	Ar+2-8%O2	1 	 D	—	—	—	—	—	—
CrNi Stainless	Ar+2-12%CO2	2 	 B	—	—	—	—	—	—
CuSi3 ER CuSi-A	Ar 100%	3 	 E	—	—	—	—	—	—
AlMg ER5xxx	Ar 100%	4 	 E	—	—	—	—	—	—
AISI ER 4xxx	Ar 100%	5 	 E	—	—	—	—	—	—
Metal Cored	Ar+2-12%CO2	6 	 B	—	—	—	—	—	—
Metal Cored	Ar+13-25%CO2	6 	 C	—	—	—	—	—	—
Shelf-shielded		7 		—	—	—	—	—	—

Additional welding characteristics									
Tst - 3000 Pulse KL-DB: 3992		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%CO2	8  SP	 A	—	—	—	—	—	—
CrNi Stainless root	Ar+ 2.5%CO2	8  SP	 B	—	—	—	—	—	—
Rutil FCW E71T FCW	CO2 100%	8  SP	 C	—	—	—	—	—	—
Rutil FCW E71T FCW	Ar+ 15-25%CO2	8  SP	 D	—	—	—	—	—	—
Basic FCW E70T FCW	CO2 100%	8  SP	 E	—	—	—	—	—	—
Basic FCW E70T FCW	Ar+ 15-25%CO2	8  SP	 F	—	—	—	—	—	—
Steel dyn ER70-120	Ar+ 8-10%CO2	1  SP	 F	—	—	—	—	—	—
Steel dyn ER70-120	Ar+ 15-25%CO2	2  SP	 F	—	—	—	—	—	—
Steel dyn ER70-120	Ar+ 4%CO2	3  SP	 F	—	—	—	—	—	—
Steel root	CO2 100%	4  SP	 F	—	—	—	—	—	—
Steel root / PCS	Ar+ 8-10%CO2	5  SP	 F	—	—	—	—	—	—
Steel root / PCS	Ar+ 15-25%CO2	6  SP	 F	—	—	—	—	—	—
42,0409,0729				— Standard  Pulse					



Welding program label on the power source







































Welding program tables for Trans-Steel 3000c 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 "SET" setup parameter is set to "Std" (Standard)

Welding program database: DB 3992

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			
Steel/ER70-120	Ar + 2-12% CO ₂	1	B	S2288 P4000	S2298 P4001	S2308 P3977	S2324 P3979			
Steel/ER70-120	Ar + 13-25% CO ₂	1	C	S2485 P4006	S2486 P3990	S2487 P3958	S2488 P3987			
Steel/ER70-120	Ar + 2-8% O ₂	1	D	S2285	S2297	S2307	S2323			
CrNi/Stainless	Ar + 2-12% CO ₂	2	B	S2427 P3969	S2402 P3970	S2426 P3968	S2405 P3966			
CuSi/ER-CuSi-A	Ar 100%	3	E	S2496 P3973	S2495 P3974	S2493 P3976	S2497 P3975			
AlMg/ER 5xxx	Ar 100%	4	E		P3955	S3639 P3956	S3643 P3953			
AlSi/ER 4xxx	Ar 100%	5	E			S3640 P3961	S3092 P3960			
Metall Cored	Ar + 2-12% CO ₂	6	B		S2420		S2385 P3980			
Metall Cored	Ar + 13-25% CO ₂	6	C		S2421		S2536 P3983			
Self-shielded	(no Gas)	7			S2350		S2349			

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"	SP
CrNi/Stainless FCW	Ar + 18% CO ₂	8 	SP 		S2423 P4014		S2424 P4013			
CrNi/Stainless root	Ar + 18% CO ₂	8 	SP 	S2440	S2441	S2442	S2443			
Rutil FCW/E71T FCW	CO ₂ 100%	8 	SP 		S2471		S2472			
Rutil FCW/E71T FCW	Ar + 18% CO ₂	8 	SP 		S2411		S2320 P4007			
Basic FCW/E70T FCW	CO ₂ 100%	8 	SP 				S2474			
Basic FCW/E70T FCW	Ar + 25% CO ₂	8 	SP 				S2473 P4011			
Steel dyn/ER70-120	Ar + 8% CO ₂	1 	SP 	S2292	S2302	S2312	S2326			
Steel dyn/ER70-120	Ar + 18% CO ₂	2 	SP 	S2293	S2303	S2313	S2327			
Steel dyn/ER70-120	Ar + 4% CO ₂	3 	SP 	S2291	S2301	S2311	S2325			
Steel/root	CO ₂ 100%	4 	SP 	S2502	S2501	S2499	S2500			
Steel/root PCS	Ar + 8% CO ₂	5 	SP 	S3962	S2305 P3997	S2315 P3978	S2329 P3986			
Steel/root PCS	Ar + 18% CO ₂	6 	SP 	S4017	S2306 P3993	S2316 P3967	S2330 P3989			
Steel/root	Ar + 4% O ₂	8 	SP 	S2294	S2304	S2314				S2328 (1)
CrNi/Stainless	Ar + 90He + 2,5% CO ₂	2 								S2404 (2)
CrNi/Stainless	Ar + 90He + 2,5% CO ₂	2 								S2407 (1)
CrNi/Stainless	Ar + 33He + 1% CO ₂	2 								S2403 (2)
CrNi/Stainless	Ar + 33He + 1% CO ₂	2 								S2406 (1)
MAP409Ti FCW	Ar + 2% O ₂	2 								S2464 (1)
























(1) d = 1.2 mm (2) d = 0.9 mm







































Welding program tables for Trans-Steel 3000c Pulse - US

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 "SET" setup parameter is set to "US" (USA).

Welding program database: UID 3992

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			
Steel/ER70-120	Ar + 2-12% CO ₂	1 	B 	S2418 P4000	S2370 P4001	S2308 P3977	S2377 P3979			
Steel/ER70-120	Ar + 13-25% CO ₂	1 	C 	S2419 P4006	S2369 P3990	S2309 P3958	S2376 P3987			
Steel/ER70-120	Ar + 2-8% O ₂	1 	D 	S2285	S2297	S2307				
CrNi/Stainless	Ar + 2-12% CO ₂	2 	B 	S2427 P3969	S2402 P3970	S2426 P3968	S2405 P3966			
CuSi/ER-CuSi-A	Ar 100%	3 	E 	S2496 P3973	S2495 P3974	S2493 P3976	S2497 P3975			
AlMg/ER 5xxx	Ar 100%	4 	E 		P3955	S3639 P3956	S3643 P3953			
AlSi/ER 4xxx	Ar 100%	5 	E 			S3640 P3961	S3092 P3960			
Metall Cored	Ar + 2-12% CO ₂	6 	B 		S2420		S2385 P3980			
Metall Cored	Ar + 13-25% CO ₂	6 	C 				S2386 P3983			
Self-shielded	(no Gas)	7 			S2350		S2349			

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		
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		
Rutil FCW/E71T FCW	Ar + 15-25% CO ₂	8  SP	 D		S2470		S2456 P4007		
Basic FCW/E70T FCW	CO ₂ 100%	8  SP	 E				S2474		S2476
Basic FCW/E70T FCW	Ar + 15-25% CO ₂	8  SP	SP  F				S2473 P4011		
Steel dyn/ER70-120	Ar + 8-10% CO ₂	1 	SP  F	S2374	S2367	S2312	S2380		
Steel dyn/ER70-120	Ar + 15-25% CO ₂	2 	SP  F	S2375	S2366	S2313	S2379		
Steel dyn/ER70-120	Ar + 4% O ₂	3 	SP  F	S2291	S2301	S2311	S2325		
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		
Steel/root PCS	Ar + 15-25% CO ₂	6 	SP  F	S3962	S2363 P3993	S2316 P3967	S2382 P3989		
Steel/root	Ar + 4% O ₂	8 	SP  F	S4017	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)

(1) d = 1.2 mm (2) d = 0.9 mm