

**Synergy lines / welding programmes
for KMX 550 + MWF 11 / 21 (ver. 1.0)**

Welding programmes						Application: Fillet weld									
						1.0mm	1.5mm	2.0mm	3.0mm	4.0mm	5.0mm	6.0mm	8.0mm	10.0mm	
Material	Wire dia(mm)	Gas	Programme	Trim (V)	Inductance	Guidance to setting of Wire Speed (m/mm)									
Fe	0.8	CO2	P2	26.0	1	3.0	4.9	5.6	8.0	10.0	12.3	15.5	17.0	20.0	
Fe	1.0	CO2	P5	24.5	2	1.9	2.5	3.2	5.4	7.4	9.4	11.2	12.5	14.0	
Fe	1.2	CO2	P9	24.3	3	1.8	2.0	2.2	2.6	5.1	5.7	7.2	9.0	10.6	
Fe	0.8	ArCO2(80/20)	P3	23.7	1	3.8	6.1	7.5	9.5	10.7	12.1	13.4	15.0	17.0	
Fe	1.0	ArCO2(80/20)	P7	22.7	2	2.2	3.3	4.6	5.9	7.0	8.1	9.3	11.0	12.8	
Fe	1.2	ArCO2(80/20)	P9	22.5	3	1.8	2.5	3.0	3.8	4.5	6.0	7.7	7.8	8.4	
Fe	1.6	ArCO2(80/20)	P10	22.2	4		1.2	1.3	2.3	3.6	4.3	4.7	4.9	5.1	
Fe flux	1.2	ArCO2(80/20)	P7	22.8	3		3.9	4.4	5.9	6.9	9.0	11.5	14.3	16.5	
CrNi	0.8	ArCO2(98/2)	P2	23.8	1	4.6	7.0	10.0	13.2	16.2	17.3	19.0	21.0	24.0	
CrNi	1.0	ArCO2(98/2)	P5	23.5	2	2.5	4.2	5.1	6.2	8.0	9.3	10.5	12.5	15.5	
CrNi	1.2	ArCO2(98/2)	P7	23.6	3	2.2	3.3	3.9	5.2	6.3	7.2	8.0	8.7	9.4	
CrNi flux	1.2	ArCO2(80/20)	P5	25.0	2		3.9	4.5	6.0	7.0	8.5	10.0	11.2	12.5	
AlMg	1.0	Ar	P5	20.0	1		8.2	9.8	12.0	13.7	14.4	15.5	17.3	19.0	
AlMg	1.2	Ar	P7	19.5	1		7.0	8.2	10.5	12.3	13.7	14.5	15.1	16.0	
AlSi	1.0	Ar	P5	21.0	1		7.1	8.4	9.5	10.2	11.0	12.6	14.5	17.5	
AlSi	1.2	Ar	P7	21.4	1		4.5	5.8	6.8	7.8	8.2	8.8	9.8	11.3	

**Synergy lines / welding programmes
for MIGA FLEX 400 + MWF 11 / 21 (ver. 1.1)**

Material	Wire diameter	Gas	Programme	Trim (V)	Inductance	Short circuit	Spray transfer
Fe	0.8	ArCO2(80/20)	P6	16.0	1	Yes	
Fe	0.8	ArCO2(80/20)	P7	23.0	7		Yes
Fe	1.0	ArCO2(80/20)	P10	15.0	3	Yes	
Fe	1.0	ArCO2(80/20)	P9	24.0	5		Yes
Fe	1.2	ArCO2(80/20)	P11	16.0	4	Yes	
Fe	1.2	ArCO2(80/20)	P10	23.5	6		Yes
Fe Flux Metal	1.2	ArCO2(80/20)	P11	13.5	4	Yes	
Fe Flux Metal	1.2	ArCO2(80/20)	P11	17.5	6		Yes
Fe Flux Rutil	1.2	ArCO2(80/20)	P11	13.6	5		Yes
CrNi	0.8	ArO2(98/2)	P6	14.0	2	Yes	
CrNi	0.8	ArO2(98/2)	P7	18.0	7		Yes
CrNi	1.0	ArO2(98/2)	P5	17.0	2	Yes	
CrNi	1.0	ArO2(98/2)	P8	22.0	5		Yes
CrNi	1.2	ArO2(98/2)	P7	15.5	2	Yes	
CrNi	1.2	ArO2(98/2)	P10	20.0	4		Yes
AlSi	1.0	Ar	P6	12.5	4	Yes	
AlSi	1.0	Ar	P8	19.0	4		Yes
AlSi	1.2	Ar	P7	17.0	7	Yes	
AlSi	1.2	Ar	P11	12.0	4		Yes
AlMg	1.0	Ar	P7	10.0	4	Yes	
AlMg	1.0	Ar	P8	14.0	4		Yes
AlMg	1.2	Ar	P9	10.0	5	Yes	
AlMg	1.2	Ar	P9	16.0	7		Yes

Please be aware of the fact that the tabel above should only be regarded as a guidance to horizontal and fillet welds. Fine adjustment is always required for each welding position and condition.

