

BDH 320 Process library for synergic MIG/MAG

50113007

Process number	Wire material/size	Gas	Pulse	Polarity	Wire type
1	Fe 0.8 mm	CO ₂	No	+	
2	Fe 0.8 mm	Ar/CO ₂ (80/20) *1	No	+	
3	Fe 1.0 mm	CO ₂	No	+	
4	Fe 1.0 mm	Ar/CO ₂ (80/20) *2	No	+	
5	Fe 1.2 mm	CO ₂	No	+	
6	Fe 1.2 mm	Ar/CO ₂ (80/20) *3	No	+	
7	Fe 0.8 mm	Ar/CO ₂ /O ₂ (88/6/6)	Yes	+	
8	Fe 1.0 mm	Ar/CO ₂ /O ₂ (88/6/6)	Yes	+	
9	Fe 1.2 mm	Ar/CO ₂ /O ₂ (88/6/6) *4	Yes	+	
10	CrNi 0.8 mm	Ar/CO ₂ (97/3)	No	+	
11	CrNi 1.0 mm	Ar/CO ₂ (97/3)	No	+	
12	CrNi 1.2 mm	Ar/CO ₂ (97/3)	No	+	
13	CrNi 0.8 mm	Ar/CO ₂ (97/3)	Yes	+	
14	CrNi 1.0 mm	Ar/CO ₂ (97/3) *5	Yes	+	
15	CrNi 1.2 mm	Ar/CO ₂ (97/3) *6	Yes	+	
16	AlSi 1.0 mm	Ar	No	+	
17	AlSi 1.0 mm	Ar	Yes	+	
18	AlMg 1.0 mm	Ar	No	+	
19	AlMg 1.2 mm	Ar	No	+	
20	AlMg 0.8 mm	Ar	Yes	+	
21	AlMg 1.0 mm	Ar	Yes	+	
22	AlMg 1.2 mm	Ar	Yes	+	
23	Fe/flux 1.2mm	Ar/CO ₂ (80/20)	No	+	AWS A5.20 E 70T-G
24	Fe/flux 1.2mm	Ar/CO ₂ (80/20)	No	+	DIN 8559 SG R1 M21 Y4655
25	Fe/flux 1.6mm	Ar/CO ₂ (80/20)	No	+	DIN 8559 SG R1 M21 Y4655
26	CrNi/flux 1.2mm	Ar/CO ₂ (80/20)	No	+	DIN 8556 E 19 12 3LR
27	CrNi/flux 1.2mm	CO ₂	No	+	DIN 8556 E 19 12 3LR

Alternative Gases

*1		*5	Ar/CO ₂ /O ₂ (90/5/5) Ar/CO ₂ /H ₂ (95/3/2) Ar/O ₂ (96/4) Ar/He (80/20) Trim = + 2.0 Ar/He (50/50) Trim = + 4.0
*2			
*3			
*4		*6	Ar/CO ₂ /O ₂ (88/6/6)

Instructions:

RECALL + PROG: open library
 AUTO: exit library with load
 RECALL: exit library without load

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15	CrNi 1.2 mm	Ar/CO ₂ (97/3) *6	Yes	+	
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17	AlSi 1.0 mm	Ar	Yes	+	
18	AlMg 1.0 mm	Ar	No	+	
19	AlMg 1.2 mm	Ar	No	+	
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