

BDH 550 Process library for synergic MIG/MAG

50113013

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)	No	+	
3	Fe 1.0 mm	CO ₂	No	+	
4	Fe 1.0 mm	Ar/CO ₂ (80/20)	No	+	
5	Fe 1.2 mm	CO ₂	No	+	
6	Fe 1.2 mm	Ar/CO ₂ (80/20)	No	+	
7	Fe 1.6 mm	CO ₂	No	+	
8	Fe 1.6 mm	Ar/CO ₂ (80/20)	No	+	
9	Fe 0.8 mm	Ar/CO ₂ /O ₂ (88/6/6)	Yes	+	
10	Fe 1.0 mm	Ar/CO ₂ /O ₂ (88/6/6)	Yes	+	
11	Fe 1.2 mm	Ar/CO ₂ /O ₂ (88/6/6)	Yes	+	
12	Fe 1.6 mm	Ar/CO ₂ /O ₂ (88/6/6)	Yes	+	
13	CrNi 0.8 mm	Ar/CO ₂ (98/2)	No	+	
14	CrNi 1.0 mm	Ar/CO ₂ (98/2)	No	+	
15	CrNi 1.2 mm	Ar/CO ₂ (98/2)	No	+	
16	CrNi 1.6 mm	Ar/CO ₂ (98/2)	No	+	
17	CrNi 0.8 mm	Ar/CO ₂ (98/2)	Yes	+	
18	CrNi 1.0 mm	Ar/CO ₂ (98/2)	Yes	+	
19	CrNi 1.2 mm	Ar/CO ₂ (98/2)	Yes	+	
20	CrNi 1.6 mm	Ar/CO ₂ (98/2)	Yes	+	
21	AlSi 1.0 mm	Ar	No	+	
22	AlSi 1.2 mm	Ar	No	+	
23	AlSi 1.6 mm	Ar	No	+	
24	AlSi 1.0 mm	Ar	Yes	+	
25	AlSi 1.2 mm	Ar	Yes	+	
26	AlSi 1.6 mm	Ar	Yes	+	
27	AlMg 1.0 mm	Ar	No	+	
28	AlMg 1.2 mm	Ar	No	+	
29	AlMg 1.6 mm	Ar	No	+	
30	AlMg 1.0 mm	Ar	Yes	+	
31	AlMg 1.2 mm	Ar	Yes	+	
32	AlMg 1.6 mm	Ar	Yes	+	
33	Fe/flux 1.2 mm	Ar/CO ₂ (80/20)	No	+	EN 758: T 38 2 M M 5 H10
34	Fe/flux 1.6 mm	Ar/CO ₂ (80/20)	No	+	EN 758: T 38 2 M M 5 H10
35	Fe/flux 1.2 mm	Ar/CO ₂ (80/20)	No	+	EN 758: T 38 2 R M 1 H10
36	Fe/flux 1.6 mm	Ar/CO ₂ (80/20)	No	+	EN 758: T 38 2 R M 1 H10
37	CrNi/flux 0.9 mm	Ar/CO ₂ (80/20)	No	+	DIN: MF 19 12 3L
38	CrNi/flux 0.9 mm	CO ₂	No	+	DIN: MF 19 12 3L
39	CrNi/flux 1.6 mm	Ar/CO ₂ (80/20)	No	+	DIN: MF 19 12 3L
40	CrNi/flux 1.6 mm	CO ₂	No	+	DIN: MF 19 12 3L

Instructions:

RECALL + PROG: open library
 AUTO: exit library with load
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19	CrNi 1.2 mm	Ar/CO ₂ (98/2)	Yes	+	
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23	AlSi 1.6 mm	Ar	No	+	
24	AlSi 1.0 mm	Ar	Yes	+	
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