



Line	Wire	Gas	Shielding	Speed	Feed	Mode
1	0.8 mm	CO ₂	Ar/CO ₂	[82/18]		
2	0.8 mm	Ar/CO ₂	[82/18]			
3	1.0 mm	CO ₂				
4	1.0 mm	Ar/CO ₂	[82/18]			
5	1.2 mm	CO ₂				
6	1.2 mm	Ar/CO ₂	[82/18]			
7	1.2 mm	Ar/CO ₂	[82/18]			
8	1.6 mm	Ar/CO ₂	[82/18]			
9	0.8 mm	Ar/CO ₂	[82/18]			
10	1.0 mm	Ar/CO ₂	[92/8]			
11	1.2 mm	Ar/CO ₂	[82/18]			
12	1.6 mm	Ar/CO ₂	[82/18]			
13	0.8 mm	Ar/CO ₂	(98/2)			
14	1.0 mm	Ar/CO ₂	(98/2)			
15	1.2 mm	Ar/CO ₂	(98/2)			
16	1.6 mm	Ar/CO ₂	(98/2)			
17	0.8 mm	Ar/CO ₂	(98/2)			
18	1.0 mm	Ar/CO ₂	(98/2)			
19	1.2 mm	Ar/CO ₂	(98/2)			
20	1.6 mm	Ar/CO ₂	(98/2)			
21	1.0 mm	Ar				
22	1.2 mm	Ar				
23	1.6 mm	Ar				
24	1.0 mm	Ar				
25	1.2 mm	Ar				
26	1.6 mm	Ar				
27	1.0 mm	Ar				
28	1.2 mm	Ar				
29	1.6 mm	Ar				
30	1.0 mm	Ar				
31	1.2 mm	Ar				
32	1.6 mm	Ar				
33	1.0 mm	Ar				
34	1.0 mm	Ar				
35	1.0 mm	Ar				
37	1.2 mm	Ar				
38	1.2 mm	Ar				
39	1.2 mm	Ar				
40						
41	1.2 mm	Ar/CO ₂	[82/18]			
42	1.0 mm	Ar				
43	1.2 mm	Ar				
44	1.0 mm	Ar				
45	1.2 mm	Ar				
46	1.0 mm	Ar				
47	1.0 mm	Ar				
48	1.0 mm	Ar/He	(70/30)			
49	0.6 mm	CO ₂				
50	0.6 mm	Ar/CO ₂	[82/18]			

- DK : Programskema isættes plastlomme på indersiden af trådboksens sidelåge
- GB : The programm table is placed in a plastic pocket on the inner side of the door on the wire feed unit
- D : Das Programmschema wird in die Plastiktasche auf die Innenseite der Seitentür auf die Drahtvorschubeinheit eingesetzt.
- F : Le table des programmes est placée dans une pochette plastique sur la face interne de la porte du dévidoir.
- S : Programschema sätts i plastfickan på innersidan av matarverkets sidolock
- FIN : Säilyttäkää ohjelmakaavio langansyöttölaitteen kannen sisällä olevassa kotelossa.

FLEX PSA 2.01

micatronic
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		ϕ			+/-
MMA					
1	Fe	0.8 mm	CO ₂	[82/18]	+
2		0.8 mm	Ar/CO ₂	[82/18]	
3		1.0 mm	CO ₂		
4		1.0 mm	Ar/CO ₂	[82/18]	
5		1.2 mm	CO ₂		
6		1.2 mm	Ar/CO ₂	[82/18]	
7		1.2 mm	Ar/CO ₂	[82/18]	
8		1.6 mm	Ar/CO ₂	[82/18]	
9	CrNi	0.8 mm	Ar/CO ₂	[82/18]	+
10		1.0 mm	Ar/CO ₂	[92/8]	
11		1.2 mm	Ar/CO ₂	[82/18]	
12		1.6 mm	Ar/CO ₂	[82/18]	
13	AlSi 3 - 5	0.8 mm	Ar/CO ₂	(98/2)	+
14		1.0 mm	Ar/CO ₂	(98/2)	
15		1.2 mm	Ar/CO ₂	(98/2)	
16		1.6 mm	Ar/CO ₂	(98/2)	
17	AlMg 3 - 5	0.8 mm	Ar/CO ₂	(98/2)	+
18		1.0 mm	Ar/CO ₂	(98/2)	
19		1.2 mm	Ar/CO ₂	(98/2)	
20		1.6 mm	Ar/CO ₂	(98/2)	
21	AlSi 3 - 5	1.0 mm	Ar		+
22		1.2 mm	Ar		
23		1.6 mm	Ar		
24	AlMg 3 - 5	1.0 mm	Ar		+
25		1.2 mm	Ar		
26		1.6 mm	Ar		
27	AlMg 3 - 5	1.0 mm	Ar		+
28		1.2 mm	Ar		
29		1.6 mm	Ar		
30	Fe Aluzink	1.0 mm	Ar		+
31		1.2 mm	Ar		
32		1.6 mm	Ar		
33	CuAl 8	1.0 mm	Ar		+
34		1.0 mm	Ar		
35		1.0 mm	Ar		
37	AlMg5	1.2 mm	Ar		+
38		1.2 mm	Ar		
39		1.2 mm	Ar		
40					
41	Fe Flux/metal with Ni	1.2 mm	Ar/CO ₂	[82/18]	+
42	AlSi 12	1.0 mm	Ar		+
43		1.2 mm	Ar		
44	CuAl 8	1.0 mm	Ar		+
45		1.2 mm	Ar		
46	CuSi 3	1.0 mm	Ar		+
47		1.0 mm	Ar		
48	Super Duplex	1.0 mm	Ar/He	(70/30)	+
49	Fe SG 2-3	0.6 mm	CO ₂		+
50		0.6 mm	Ar/CO ₂	[82/18]	



+ : Open library : Exit library with load : Exit library without load