

PROGRAM TABLE

| Prog. No | Diameter | Program description | Gas specification | | Function Polarity | Standard 10645421 Version C8 | StandardPlus 10645422 Version C8 | Special 10645423 Version D5 |
|----------|----------|-------------------------------|---------------------|------------|-------------------|------------------------------|----------------------------------|-----------------------------|
| 444 | Ø 1.6 mm | FCW FeRutil 215 | CO ₂ | 100 | DC + | x | x | x |
| 445 | Ø 1.6 mm | FCW 115 Fe Metal | CO ₂ | 100 | DC + | x | x | x |
| 446 | Ø 1.6 mm | FCW PZ6111-HS | CO ₂ | 100 | DC + | | | x |
| 447 | Ø 1.2 mm | FCW FeRutil PZ6114S | CO ₂ | 100 | DC + | | | x |
| 448 | Ø 1.2 mm | FCW FeR Nittetsu SF-1E | CO ₂ | 100 | DC + | | | x |
| 451 | Ø 1.2 mm | FCW FeRutil DWA 55E | ArCO ₂ | 82/18 | DC + | x | x | x |
| 452 | Ø 1.2 mm | FCW FeRutil Tubrod 15.14 | ArCO ₂ | 82/18 | DC + | x | x | x |
| 453 | Ø 1.2 mm | FCW217 FeRutil | ArCO ₂ | 82/18 | DC + | x | x | x |
| 454 | Ø 1.2 mm | FCW FeRutil 713R | ArCO ₂ | 82/18 | DC + | x | x | x |
| 456 | Ø 1.2 mm | FCW FeRutil PZ6104 | ArCO ₂ | 82/18 | DC + | | | x |
| 457 | Ø 1.2 mm | FCW FeRutil PZ6138 | ArCO ₂ | 82/18 | DC + | | | x |
| 458 | Ø 1.2 mm | FCW FeRutil 6114 | ArCO ₂ | 82/18 | DC + | | | x |
| 474 | Ø 1.6 mm | FCW FeCr | ArCO ₂ | 82/18 | DC + | | x | x |
| 483 | Ø 1.2 mm | FCW CrNi E316LT-1 | ArCO ₂ | 82/18 | DC + | x | x | x |
| 484 | Ø 1.2 mm | FCW 2205 | ArCO ₂ | 82/18 | DC + | | | x |
| 485 | Ø 1.2 mm | FCW 2507 | ArCO ₂ | 82/18 | DC + | | | x |
| 486 | Ø 1.2 mm | FCW CrNi 15.31 | ArO ₂ | 98/2 | DC/P + | | | x |
| 493 | Ø 1.2 mm | FCW CrNi 309 | CO ₂ | 100 | DC + | | x | x |
| 494 | Ø 1.2 mm | FCW CrNi 316L | CO ₂ | 100 | DC + | | x | x |
| 495 | Ø 1.2 mm | FCW FeR 15.14 | CO ₂ | 100 | DC + | | x | x |
| 501 | Ø 0.8 mm | CuAl8 Brazing | Ar | 100 | DC/P + | x | x | x |
| 502 | Ø 1.0 mm | CuAl8 Brazing | Ar | 100 | DC/P + | x | x | x |
| 509 | Ø 0.9 mm | CuAl8 Brazing | Ar | 100 | DC + | x | x | x |
| 523 | Ø 1.2 mm | CuSn Brazing | Ar | 100 | P + | | x | x |
| 554 | Ø 1.6 mm | AlBz9Fe Welding | Ar | 100 | DC + | | | x |
| 561 | Ø 0.8 mm | CuSi3 Brazing | Ar | 100 | DC/P + | x | x | x |
| 562 | Ø 1.0 mm | CuSi3 Brazing | Ar | 100 | DC/P + | x | x | x |
| 567 | Ø 1.0 mm | CuSi3 Brazing | ArCO ₂ | 98/2 | DC/P + | | x | x |
| 569 | Ø 0.9 mm | CuSi3 Brazing | Ar | 100 | DC/P + | x | | x |
| 571 | Ø 0.8 mm | CuAl8 Welding | Ar | 100 | P + | | x | x |
| 572 | Ø 1.0 mm | CuAl8 Welding | Ar | 100 | P + | | x | x |
| 573 | Ø 1.2 mm | CuAl8 Welding | Ar | 100 | P + | | x | x |
| 583 | Ø 1.2 mm | Inconel 625 | ArHe | 85/15 | DC/P + | | x | x |
| 584 | Ø 1.6 mm | Inconel 625 | ArHe | 85/15 | DC/P + | | | x |
| 588 | Ø 1.2 mm | Inconel 625 | Ar | 100 | DC/P + | | | x |
| 589 | Ø 1.2 mm | Monel 400. Inconel 82 | Ar | 100 | DC/P + | | | x |
| 590 | Ø 1.2 mm | Inconel 825 | ArHeCO ₂ | 81/18/1 | DC/P + | | | x |
| 591 | Ø 1.2 mm | Inconel 718 | ArHeCO ₂ | 95.8/4/0.2 | DC/P + | | | x |
| 593 | Ø 1.2 mm | FCW Inconel 625-PW | ArCO ₂ | 82/18 | DC + | | | x |
| 595 | Ø 1.2 mm | UTP A 8051 Ti | ArCO ₂ | 98/2 | P + | | | x |
| 596 | Ø 1.0 mm | SMO | ArHeCO ₂ | 68/30/2 | DC/P + | | | x |
| 597 | Ø 1.2 mm | SMO | ArHeCO ₂ | 68/30/2 | DC/P + | | | x |
| 704 | Ø 1.6 mm | Titanium Gr. 2 | ArHe | 70/30 | P + | | | x |
| 712 | Ø 1.0 mm | Fe SG2 ER70S6 Seam track | ArCO ₂ | 82/18 | DC/P + | | | x |
| 713 | Ø 1.2 mm | Fe SG2 ER70S6 Seam track | ArCO ₂ | 82/18 | DC/P + | | | x |
| 743 | Ø 1.2 mm | FCW Nittetsu SF-1A Seam track | ArCO ₂ | 82/18 | DC + | | | x |

SIGMA² PROGRAM TABLE

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|----------|----------|---------------------|------------------------------------|-------------|-------------------|------------------------------|----------------------------------|-----------------------------|
| 001 | | MMA | - | | DC + | x | x | x |
| 002 | | Manuel MIG/MAG | CO ₂ | 100 | DC + | x | x | x |
| 003 | | Manuel MIGMAG | ArCO ₂ | 82/18 | DC + | x | x | x |
| 004 | | ArcGouging | - | | DC + | | | x |
| 101 | Ø 0.8 mm | Fe SG2 ER70S6 | CO ₂ | 100 | DC + | x | x | x |
| 102 | Ø 1.0 mm | Fe SG2 ER70S6 | CO ₂ | 100 | DC + | x | x | x |
| 103 | Ø 1.2 mm | Fe SG2 ER70S6 | CO ₂ | 100 | DC + | x | x | x |
| 104 | Ø 1.6 mm | Fe SG2 ER70S6 | CO ₂ | 100 | DC + | x | x | x |
| 106 | Ø 0.6 mm | Fe SG2 ER70S6 | CO ₂ | 100 | DC + | x | x | x |
| 109 | Ø 0.9 mm | Fe SG2 ER70S6 | CO ₂ | 100 | DC + | x | x | x |
| 111 | Ø 0.8 mm | Fe SG2 ER70S6 | ArCO ₂ | 82/18 | DC/P + | x | x | x |
| 112 | Ø 1.0 mm | Fe SG2 ER70S6 | ArCO ₂ | 82/18 | DC/P + | x | x | x |
| 113 | Ø 1.2 mm | Fe SG2 ER70S6 | ArCO ₂ | 82/18 | DC/P + | x | x | x |
| 114 | Ø 1.6 mm | Fe SG2 ER70S6 | ArCO ₂ | 82/18 | DC/P + | x | x | x |
| 115 | Ø 1.0 mm | Fe SG2 ER70S6 | ArCO ₂ | 92/8 | DC/P + | x | x | x |
| 116 | Ø 0.6 mm | Fe SG2 ER70S6 | ArCO ₂ | 82/18 | DC/P + | x | x | x |
| 117 | Ø 1.6 mm | Fe SG2 ER70S6 | ArCO ₂ | 92/8 | DC/P + | x | x | x |
| 118 | Ø 1.2 mm | Fe SG2 ER70S6 | ArCO ₂ | 92/8 | DC/P + | x | x | x |
| 119 | Ø 0.9 mm | Fe SG2 ER70S6 | ArCO ₂ | 82/18 | DC/P + | x | x | x |
| 120 | Ø 0.9 mm | Fe SG2 ER70S6 | ArCO ₂ | 92/8 | DC/P + | x | x | x |
| 121 | Ø 0.8 mm | Fe SG2 ER70S6 | ArCO ₂ O ₂ | 90/5/5 | DC/P + | | x | x |
| 122 | Ø 1.0 mm | Fe SG2 ER70S6 | ArCO ₂ O ₂ | 90/5/5 | DC/P + | | x | x |
| 123 | Ø 1.2 mm | Fe SG2 ER70S6 | ArCO ₂ O ₂ | 90/5/5 | DC/P + | | x | x |
| 124 | Ø 1.4 mm | Fe SG2 ER70S6 | ArCO ₂ | 82/18 | DC + | x | x | x |
| 125 | Ø 0.8 mm | Fe SG2 ER70S6 | ArHeCO ₂ O ₂ | 91/4/2/3 | DC/P + | | x | x |
| 126 | Ø 1.0 mm | Fe SG2 ER70S6 | ArHeCO ₂ O ₂ | 91/4/2/3 | DC/P + | | x | x |
| 127 | Ø 1.2 mm | Fe SG2 ER70S6 | ArHeCO ₂ O ₂ | 91/4/2/3 | DC/P + | | x | x |
| 128 | Ø 0.6 mm | Fe SG2 ER70S6 | ArCO ₂ O ₂ | 90/5/5 | DC + | | x | x |
| 129 | Ø 1.4 mm | Fe SG2 ER70S6 | ArCO ₂ | 92/8 | DC + | x | x | x |
| 130 | Ø 0.8 mm | Fe SG2 ER70S6 | ArCO ₂ | 92/8 | DC/P + | x | x | x |
| 131 | Ø 1.0 mm | Fe SG2 ER70S6 | ArCO ₂ | 98/2 | DC/P + | | x | x |
| 132 | Ø 1.0 mm | Fe SG2 ER70S6 | ArO ₂ | 97/3 | DC/P + | | x | x |
| 133 | Ø 1.2 mm | Fe SG2 ER70S6 | ArO ₂ | 97/3 | DC/P + | | x | x |
| 134 | Ø 1.0 mm | Fe SG2 ER70S6 | ArCO ₂ O ₂ | 90.5/7/2.5 | DC/P + | x | x | x |
| 135 | Ø 1.2 mm | Fe SG2 ER70S6 | ArCO ₂ O ₂ | 90.5/7/2.5 | DC/P + | x | x | x |
| 136 | Ø 1.0 mm | Fe SG2 ER70S6 | ArCO ₂ O ₂ | 82.5/15/2.5 | DC/P + | x | x | x |
| 137 | Ø 1.2 mm | Fe SG2 ER70S6 | ArCO ₂ O ₂ | 82.5/15/2.5 | DC/P + | x | x | x |
| 138 | Ø 1.0 mm | Fe SG2 ER70S6 | ArHeCO ₂ | 68/20/12 | DC/P + | x | x | x |
| 139 | Ø 1.2 mm | Fe SG2 ER70S6 | ArHeCO ₂ | 68/20/12 | DC/P + | x | x | x |
| 142 | Ø 1.0 mm | Fe SG2 PowerArc | ArCO ₂ O ₂ | 90.5/7/2.5 | DC + | | | x |
| 143 | Ø 1.2 mm | Fe SG2 PowerArc | ArCO ₂ O ₂ | 90.5/7/2.5 | DC + | | | x |
| 145 | Ø 1.0 mm | Fe SG2 PowerArc | ArCO ₂ O ₂ | 82.5/15/2.5 | DC + | | | x |
| 146 | Ø 1.2 mm | Fe SG2 PowerArc | ArCO ₂ O ₂ | 82.5/15/2.5 | DC + | | | x |



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| Prog. No | Diameter | Program description | Gas specification | | Function Polarity | Standard 10645421 Version C8 | StandardPlus 10645422 Version C8 | Special 10645423 Version D5 |
| 148 | Ø 1.0 mm | Fe SG2 PowerArc | ArHeCO ₂ | 68/20/12 | DC + | | | x |
| 149 | Ø 1.2 mm | Fe SG2 PowerArc | ArHeCO ₂ | 68/20/12 | DC + | | | x |
| 152 | Ø 1.0 mm | Fe SG2 PowerArc | ArCO ₂ | 82/18 | DC + | | | x |
| 153 | Ø 1.2 mm | Fe SG2 PowerArc | ArCO ₂ | 82/18 | DC + | | | x |
| 154 | Ø 1.6 mm | Fe SG2 PowerArc | ArCO ₂ | 82/18 | DC + | | | x |
| 155 | Ø 1.4 mm | Fe SG2 PowerArc | ArCO ₂ | 82/18 | DC + | | | x |
| 156 | Ø 1.0 mm | Fe SG2 PowerArc | ArCO ₂ | 92/8 | DC + | | | x |
| 157 | Ø 1.2 mm | Fe SG2 PowerArc | ArCO ₂ | 92/8 | DC + | | | x |
| 159 | Ø 1.4 mm | Fe SG2 PowerArc | ArCO ₂ | 92/8 | DC + | | | x |
| 163 | Ø 1.2 mm | Fe SG2 PowerArc | ArCO ₂ O ₂ | 90/5/5 | DC + | | | x |
| 166 | Ø 1.0 mm | Fe SG2 PowerArc | ArHeCO ₂ O ₂ | 91/4/2/3 | DC + | | | x |
| 167 | Ø 1.2 mm | Fe SG2 PowerArc | ArHeCO ₂ O ₂ | 91/4/2/3 | DC + | | | x |
| 172 | Ø 1.0 mm | Fe SG2 PowerArc | ArO ₂ | 97/3 | DC + | | | x |
| 173 | Ø 1.2 mm | Fe SG2 PowerArc | ArO ₂ | 97/3 | DC + | | | x |
| 176 | Ø 1.0 mm | Fe SG2 PowerArc | ArO ₂ | 92/8 | DC + | | | x |
| 177 | Ø 1.2 mm | Fe SG2 PowerArc | ArO ₂ | 92/8 | DC + | | | x |
| 201 | Ø 0.8 mm | ER 316 LSi | ArCO ₂ | 98/2 | DC/P + | x | x | x |
| 202 | Ø 1.0 mm | ER 316 LSi | ArCO ₂ | 98/2 | DC/P + | x | x | x |
| 203 | Ø 1.2 mm | ER 316 LSi | ArCO ₂ | 98/2 | DC/P + | x | x | x |
| 204 | Ø 1.6 mm | ER 316 LSi | ArCO ₂ | 98/2 | DC/P + | x | x | x |
| 209 | Ø 0.9 mm | ER 316 LSi | ArCO ₂ | 98/2 | DC/P + | x | x | x |
| 212 | Ø 1.0 mm | ER 316 LSi | ArO ₂ | 97/3 | DC/P + | | | x |
| 213 | Ø 1.2 mm | ER 316 LSi | ArO ₂ | 97/3 | DC/P + | | | x |
| 216 | Ø 1.0 mm | ER 316 LSi PowerArc | ArO ₂ | 97/3 | DC + | | | x |
| 217 | Ø 1.2 mm | ER 316 LSi PowerArc | ArO ₂ | 97/3 | DC + | | | x |
| 218 | Ø 1.6 mm | ER 316 LSi PowerArc | ArCO ₂ | 98/2 | DC + | | | x |
| 220 | Ø 1.0 mm | ER 308 LSi | ArO ₂ | 98/2 | DC/P + | | | x |
| 221 | Ø 0.8 mm | ER 308 LSi | ArCO ₂ | 98/2 | DC/P + | x | x | x |
| 222 | Ø 1.0 mm | ER 308 LSi | ArCO ₂ | 98/2 | DC/P + | x | x | x |
| 223 | Ø 1.2 mm | ER 308 LSi | ArCO ₂ | 98/2 | DC/P + | x | x | x |
| 224 | Ø 0.8 mm | ER 309 LSi | ArCO ₂ | 98/2 | DC/P + | x | x | x |
| 225 | Ø 1.0 mm | ER 309 LSi | ArCO ₂ | 98/2 | DC/P + | x | x | x |
| 226 | Ø 0.8 mm | ER 308 LSi | ArCO ₂ H ₂ | 96/3/1 | DC/P + | | | x |
| 227 | Ø 1.0 mm | ER 308 LSi | ArCO ₂ H ₂ | 96/3/1 | DC/P + | | | x |
| 228 | Ø 1.2 mm | ER 308 LSi | ArCO ₂ H ₂ | 96/3/1 | DC/P + | | | x |
| 229 | Ø 1.0 mm | ER 309 LSi | ArCO ₂ H ₂ | 96/3/1 | DC/P + | | | x |
| 230 | Ø 0.8 mm | ER 309 LSi | ArCO ₂ H ₂ | 96/3/1 | DC/P + | | | x |
| 231 | Ø 0.9 mm | ER 309 LSi | ArCO ₂ | 98/2 | DC/P + | x | x | x |
| 232 | Ø 1.0 mm | ER 309 LSi | ArO ₂ | 98/2 | DC/P + | | | x |
| 242 | Ø 1.0 mm | ER 347 Si | ArHeCO ₂ | 68/30/2 | DC/P + | | x | x |
| 243 | Ø 1.2 mm | ER 347 Si | ArHeCO ₂ | 68/30/2 | DC/P + | | x | x |
| 252 | Ø 1.0 mm | Duplex 2205 | ArHeCO ₂ | 83/15/2 | P + | | x | x |
| 253 | Ø 1.2 mm | Duplex 2205 | ArHeCO ₂ | 83/15/2 | P + | | x | x |
| 254 | Ø 1.0 mm | Duplex 2205 | ArO ₂ | 98/2 | DC/P + | x | | x |
| 255 | Ø 1.2 mm | Duplex 2205 | ArO ₂ | 98/2 | DC/P + | | x | x |
| 256 | Ø 1.0 mm | Super duplex 2507 | ArHeCO ₂ | 83/15/2 | P + | | x | x |
| 257 | Ø 1.2 mm | Super duplex 2507 | ArHeCO ₂ | 83/15/2 | P + | | x | x |
| 262 | Ø 1.0 mm | Super duplex 2507 | ArCO ₂ | 98/2 | P + | x | | x |
| 263 | Ø 1.2 mm | Super duplex 2507 | ArCO ₂ | 98/2 | P + | x | | x |
| 264 | Ø 1.0 mm | Super duplex 2507 | ArO ₂ | 98/2 | DC/P + | x | | x |
| 265 | Ø 1.2 mm | Super duplex 2507 | ArO ₂ | 98/2 | DC/P + | x | | x |
| 267 | Ø 1.0 mm | Super duplex 2507 | ArHeO ₂ | 69/30/1 | P + | | x | x |

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| Prog. No | Diameter | Program description | Gas specification | | Function Polarity | Standard 10645421 Version C8 | StandardPlus 10645422 Version C8 | Special 10645423 Version D5 |
| 273 | Ø 1.2 mm | CrNi Zecor | ArCO ₂ | 98/2 | DC/P + | | | x |
| 274 | Ø 1.0 mm | Super duplex 2507 | ArHeCO ₂ | 68/30/2 | P + | | x | x |
| 275 | Ø 1.2 mm | Super duplex 2507 | ArHeCO ₂ | 68/30/2 | P + | | x | x |
| 311 | Ø 0.8 mm | AlMg5 ER5356 | Ar | 100 | DC/P + | x | x | x |
| 312 | Ø 1.0 mm | AlMg5 ER5356 | Ar | 100 | DC/P + | x | x | x |
| 313 | Ø 1.2 mm | AlMg5 ER5356 | Ar | 100 | DC/P + | x | x | x |
| 314 | Ø 1.6 mm | AlMg5 ER5356 | Ar | 100 | DC/P + | x | x | x |
| 316 | Ø 1.0 mm | AlMg5 ER5356 | ArHe | 70/30 | DC/P + | | x | x |
| 317 | Ø 1.2 mm | AlMg5 ER5356 | ArHe | 70/30 | DC/P + | | x | x |
| 318 | Ø 1.6 mm | AlMg5 ER5356 | ArHe | 70/30 | DC/P + | | x | x |
| 319 | Ø 0.9 mm | AlMg5 ER5356 | Ar | 100 | DC + | x | | x |
| 321 | Ø 1.2 mm | AlMg4.5MnZr ER5087 | Ar | 100 | DC/P + | | x | x |
| 323 | Ø 1.2 mm | AlMg4.5 ER5183 | ArHe | 20/80 | DC/P + | | x | x |
| 328 | Ø 1.6 mm | AlMg4.5 ER5183 | ArHe | 70/30 | DC/P + | | x | x |
| 332 | Ø 1.0 mm | AlMg5 ER5356 | ArHe | 50/50 | DC/P + | | | x |
| 333 | Ø 1.2 mm | AlMg5 ER5356 | ArHe | 50/50 | DC/P + | | | x |
| 352 | Ø 1.0 mm | AlSi5 ER4043 | Ar | 100 | DC/P + | x | x | x |
| 353 | Ø 1.2 mm | AlSi5 ER4043 | Ar | 100 | DC/P + | x | x | x |
| 354 | Ø 1.6 mm | AlSi5 ER4043 | Ar | 100 | DC/P + | x | x | x |
| 356 | Ø 1.0 mm | AlSi5 ER4043 | ArHe | 70/30 | DC/P + | | x | x |
| 357 | Ø 1.2 mm | AlSi5 ER4043 | ArHe | 70/30 | DC/P + | | x | x |
| 358 | Ø 1.6 mm | AlSi5 ER4043 | ArHe | 70/30 | DC/P + | | x | x |
| 359 | Ø 0.9 mm | AlSi5 ER4043 | Ar | 100 | DC + | x | x | x |
| 363 | Ø 1.2 mm | Al99.5 ER1100 | Ar | 100 | DC/P + | | x | x |
| 364 | Ø 1.6 mm | Al99.5 ER1100 | Ar | 100 | DC/P + | | x | x |
| 369 | Ø 0.9 mm | AlMg3Mn ER5554 | Ar | 100 | DC + | | x | x |
| 372 | Ø 1.0 mm | AlSi12 ER4047 | Ar | 100 | DC/P + | | x | x |
| 373 | Ø 1.2 mm | AlSi12 ER4047 | Ar | 100 | DC/P + | | x | x |
| 383 | Ø 1.2 mm | AlSi10 MG ER4046 | ArHe | 50/50 | DC/P + | | | x |
| 402 | Ø 1.0 mm | FCW FeRutil 215 | ArCO ₂ | 82/18 | DC + | x | x | x |
| 403 | Ø 1.2 mm | FCW FeRutil 215 | ArCO ₂ | 82/18 | DC + | x | x | x |
| 404 | Ø 1.6 mm | FCW FeRutil 215 | ArCO ₂ | 82/18 | DC + | x | x | x |
| 405 | Ø 1.6 mm | FCW FeRutil PZ6111 | ArCO ₂ | 82/18 | DC + | | | x |
| 407 | Ø 1.2 mm | FCW FeR Nittetsu SF-1A | ArCO ₂ | 82/18 | DC + | | | x |
| 408 | Ø 1.2 mm | FCW FeR Nittetsu SF-3AM | ArCO ₂ | 82/18 | DC + | | | x |
| 409 | Ø 1.4 mm | FCW FeR Nittetsu SF-3AM | ArCO ₂ | 82/18 | DC + | | | x |
| 413 | Ø 1.2 mm | FCW FeBasic 515 | ArCO ₂ | 82/18 | DC - | x | x | x |
| 415 | Ø 1.4 mm | FCW FeBasic 6130 | ArCO ₂ | 82/18 | DC +/- | x | x | x |
| 417 | Ø 1.0 mm | FCW FeBasic 6125 | ArCO ₂ | 82/18 | DC - | x | x | x |
| 418 | Ø 1.2 mm | FCW MC-R5 | ArCO ₂ | 82/18 | DC + | | | x |
| 420 | Ø 1.2 mm | FCW FeM 235M | ArCO ₂ | 82/18 | DC/P + | | | x |
| 422 | Ø 1.2 mm | FCW115 FeM PowerArc | ArCO ₂ | 82/18 | DC + | | | x |
| 423 | Ø 1.2 mm | FCW115 Fe Metal | ArCO ₂ | 82/18 | DC/P + | x | x | x |
| 424 | Ø 1.6 mm | FCW115 Fe Metal | ArCO ₂ | 82/18 | DC + | x | x | x |
| 425 | Ø 1.4 mm | FCW115 Fe Metal | ArCO ₂ | 82/18 | DC + | | x | x |
| 426 | Ø 1.0 mm | FCW FeM 710M/742M | ArCO ₂ | 82/18 | DC + | x | x | x |
| 427 | Ø 1.2 mm | FCW FeM 710M | ArCO ₂ | 82/18 | DC + | x | x | x |
| 428 | Ø 1.2 mm | FCW FeM 742M | ArCO ₂ | 82/18 | DC + | x | x | x |
| 429 | Ø 1.2 mm | FCW FeM MX 100T | ArCO ₂ | 82/18 | DC + | x | x | x |
| 433 | Ø 1.2 mm | FCW FeBasic 15.00 | CO ₂ | 100 | DC +/- | | | x |
| 435 | Ø 1.4 mm | FCW FeBasic 6130 | CO ₂ | 100 | DC +/- | | | x |
| 443 | Ø 1.2 mm | FCW FeRutile 15.14 | CO ₂ | 100 | DC + | | | x |

