

PROGRAM TABLE: PROGRAM PACKAGE 10645800 (B3)

Prog.No	Diameter	Program description	Gas specification		Function Polarity	Standard 10660000	StandardPlus 10660001	Special 10660002	IAC mild steel 10660003	IAC stainless steel 10660004
001		MMA			DC +	x	x	x		
004		ArcGouging			DC +		x	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 +	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 +	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		
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		
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		
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		
157	Ø 1.2 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		
181	Ø 0.8 mm	Fe SG2 ER70S6 IAC	ArCO ₂	82/18	DC +			x		
182	Ø 1.0 mm	Fe SG2 ER70S6 IAC	ArCO ₂	82/18	DC +			x		
183	Ø 1.2 mm	Fe SG2 ER70S6 IAC	ArCO ₂	82/18	DC +			x		
185	Ø 0.8 mm	Fe SG2 ER70S6 IAC	ArO ₂	92/8	DC +			x		
186	Ø 1.0 mm	Fe SG2 ER70S6 IAC	ArO ₂	92/8	DC +			x		
189	Ø 0.9 mm	Fe SG2 ER70S6 IAC	ArCO ₂	82/18	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 +	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		
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 2209	ArHeCO ₂	83/15/2	P +		x	x		
253	Ø 1.2 mm	Duplex G22 9 3NL	ArHeCO ₂	83/15/2	P +		x	x		
262	Ø 1.0 mm	Duplex 2509	ArCO ₂	98/2	P +		x	x		
263	Ø 1.2 mm	Duplex 2509	ArCO ₂	98/2	P +		x	x		
267	Ø 1.0 mm	Duplex 2509	ArHeO ₂	69/30/1	P +		x	x		
273	Ø 1.2 mm	CrNi Zecor	ArCO ₂	98/2	DC/P +			x		
281	Ø 0.8 mm	ER 316 LSI IAC	ArCO ₂	98/2	DC +				x	
282	Ø 1.0 mm	ER 316 LSI IAC	ArCO ₂	98/2	DC +				x	
283	Ø 1.2 mm	ER 316 LSI IAC	ArCO ₂	98/2	DC +				x	

PROGRAM TABLE: PROGRAM PACKAGE 10645800 (B3)

Prog.No	Diameter	Program description	Gas specification		Function Polarity	Standard 10660000	StandardPlus 10660001	Special 10660002	IAC mild steel 10660003	IAC stainless steel 10660004
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		
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		
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		
372	Ø 1.0 mm	AlSi12 ER4047	Ar	100	DC/P +			x		
373	Ø 1.2 mm	AlSi12 ER4047	Ar	100	DC/P +			x		
383	Ø 1.2 mm	AlSi10 MG ER4046	ArHe	50/50	DC/P +			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		
408	Ø 1.2 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		
417	Ø 1.0 mm	FCW FeBasic 6125	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		
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 FeRutil 15.14	CO ₂	100	DC +			x		
447	Ø 1.2 mm	FCW FeRutil PZ61145	CO ₂	100	DC +			x		
448	Ø 1.2 mm	FCW FeR Nittetsu SF-1E	CO ₂	100	DC +			x		
453	Ø 1.2 mm	FCW217 FeRutil	ArCO ₂	82/18	DC +	x	x	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		
493	Ø 1.2 mm	FCW CrNi 309/316L	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		
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 1.2 mm	CuSi3 Brazing	ArCO ₂	98/2	DC/P +		x	x		
569	Ø 0.9 mm	CuSi3 Brazing	Ar	100	DC/P +	x	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		
595	Ø 1.6 mm	Inconel 625	ArHe							

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Prog.No	Diameter	Program description	Gas specification		Function Polarity	Standard 10660000	StandardPlus 10660001	Special 10660002	IAC mild steel 10660003	IAC stainless steel 10660004
001		MMA			DC +	x	x	x		
004		ArcGouging			DC +		x	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 +	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 +	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		
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		
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		
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		
157	Ø 1.2 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		
181	Ø 0.8 mm	Fe SG2 ER70S6 IAC	ArCO ₂	82/18	DC +			x		
182	Ø 1.0 mm	Fe SG2 ER70S6 IAC	ArCO ₂	82/18	DC +			x		
183	Ø 1.2 mm	Fe SG2 ER70S6 IAC	ArCO ₂	82/18	DC +			x		
185	Ø 0.8 mm	Fe SG2 ER70S6 IAC	ArO ₂	92/8	DC +			x		
186	Ø 1.0 mm	Fe SG2 ER70S6 IAC	ArO ₂	92/8	DC +			x		
189	Ø 0.9 mm	Fe SG2 ER70S6 IAC	ArCO ₂	82/18	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 +	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		
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 2209	ArHeCO ₂	83/15/2	P +		x	x		
253	Ø 1.2 mm	Duplex G22 9 3NL	ArHeCO ₂	83/15/2	P +		x	x		
262	Ø 1.0 mm	Duplex 2509	ArCO ₂	98/2	P +		x	x		
263	Ø 1.2 mm	Duplex 2509	ArCO ₂	98/2	P +		x	x		
267	Ø 1.0 mm	Duplex 2509	ArHeO ₂	69/30/1	P +		x	x		
273	Ø 1.2 mm	CrNi Zecor	ArCO ₂	98/2	DC/P +			x		
281	Ø 0.8 mm	ER 316 LSI IAC	ArCO ₂	98/2	DC +				x	
282	Ø 1.0 mm	ER 316 LSI IAC	ArCO ₂	98/2	DC +				x	
283	Ø 1.2 mm	ER 316 LSI IAC	ArCO ₂	98/2	DC +				x	

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Prog.No	Diameter	Program description	Gas specification		Function Polarity	Standard 10660000	StandardPlus 10660001	Special 10660002	IAC mild steel 10660003	IAC stainless steel 10660004
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		
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		
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		
372	Ø 1.0 mm	AlSi12 ER4047	Ar	100	DC/P +			x		
373	Ø 1.2 mm	AlSi12 ER4047	Ar	100	DC/P +			x		
383	Ø 1.2 mm	AlSi10 MG ER4046	ArHe	50/50	DC/P +			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		
408	Ø 1.2 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		
417	Ø 1.0 mm	FCW FeBasic 6125	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		
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 FeRutil 15.14	CO ₂	100	DC +			x		
447	Ø 1.2 mm	FCW FeRutil PZ61145	CO ₂	100	DC +			x		
448	Ø 1.2 mm	FCW FeR Nittetsu SF-1E	CO ₂	100	DC +			x		
453	Ø 1.2 mm	FCW217 FeRutil	ArCO ₂	82/18	DC +	x	x	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		
493	Ø 1.2 mm	FCW CrNi 309/316L	CO ₂	100	DC +			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		
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 1.2 mm	CuSi3 Brazing	ArCO ₂	98/2	DC/P +		x	x		
569	Ø 0.9 mm	CuSi3 Brazing	Ar	100	DC/P +	x	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		
595	Ø 1.6 mm	Inconel 625	ArHe	85/15	DC/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	
Number of programs (incl. pulse)						40 (63)	77 (131)	113 (181)	6	3