

PROGRAM TABLE: PROGRAM PACKAGE 10645900 (C0)

Prog. No	Diameter	Program description	Gas specification		Function Polarity	Standard	StandardPlus	Special	IAC mild steel	IAC stainless steel
						10660000	10660001	10660002	10660003	10660004
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	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 ER7056 Seam track	ArCO ₂	82/18	DC/P +			x		
713	Ø 1.2 mm	Fe SG2 ER7056 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		

SIGMA GALAXY PROGRAM TABLE

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Prog. No	Diameter	Program description	Gas specification		Function Polarity	Standard	StandardPlus	Special	IAC mild steel	IAC stainless steel
						10660000	10660001	10660002	10660003	10660004
001		MMA			DC +	x	x	x		
002		Manuel MIG/MAG	CO ₂	100	DC +	x	x	x		
003		Manuel MIG/MAG	ArCO ₂	82/18	DC +	x	x	x		
004		ArcGouging			DC +		x	x		
101	Ø 0.8 mm	Fe SG2 ER7056	CO ₂	100	DC +	x	x	x		
102	Ø 1.0 mm	Fe SG2 ER7056	CO ₂	100	DC +	x	x	x		
103	Ø 1.2 mm	Fe SG2 ER7056	CO ₂	100	DC +	x	x	x		
104	Ø 1.6 mm	Fe SG2 ER7056	CO ₂	100	DC +	x	x	x		
106	Ø 0.6 mm	Fe SG2 ER7056	CO ₂	100	DC +	x	x	x		
109	Ø 0.9 mm	Fe SG2 ER7056	CO ₂	100	DC +	x	x	x		
111	Ø 0.8 mm	Fe SG2 ER7056	ArCO ₂	82/18	DC/P +	x	x	x		
112	Ø 1.0 mm	Fe SG2 ER7056	ArCO ₂	82/18	DC/P +	x	x	x		
113	Ø 1.2 mm	Fe SG2 ER7056	ArCO ₂	82/18	DC/P +	x	x	x		
114	Ø 1.6 mm	Fe SG2 ER7056	ArCO ₂	82/18	DC/P +	x	x	x		
115	Ø 1.0 mm	Fe SG2 ER7056	ArCO ₂	92/8	DC/P +	x	x	x		
116	Ø 0.6 mm	Fe SG2 ER7056	ArCO ₂	82/18	DC/P +	x	x	x		
117	Ø 1.6 mm	Fe SG2 ER7056	ArCO ₂	92/8	DC/P +	x	x	x		
118	Ø 1.2 mm	Fe SG2 ER7056	ArCO ₂	92/8	DC/P +	x	x	x		
119	Ø 0.9 mm	Fe SG2 ER7056	ArCO ₂	82/18	DC/P +	x	x	x		
120	Ø 0.9 mm	Fe SG2 ER7056	ArCO ₂	92/8	DC/P +	x	x	x		
121	Ø 0.8 mm	Fe SG2 ER7056	ArCO ₂ O ₂	90/5/5	DC/P +		x	x		
122	Ø 1.0 mm	Fe SG2 ER7056	ArCO ₂ O ₂	90/5/5	DC/P +		x	x		
123	Ø 1.2 mm	Fe SG2 ER7056	ArCO ₂ O ₂	90/5/5	DC/P +		x	x		
124	Ø 1.4 mm	Fe SG2 ER7056	ArCO ₂	82/18	DC +	x	x	x		
125	Ø 0.8 mm	Fe SG2 ER7056	ArHeCO ₂ O ₂	91/4/2/3	DC/P +		x	x		
126	Ø 1.0 mm	Fe SG2 ER7056	ArHeCO ₂ O ₂	91/4/2/3	DC/P +		x	x		
127	Ø 1.2 mm	Fe SG2 ER7056	ArHeCO ₂ O ₂	91/4/2/3	DC/P +		x	x		
128	Ø 0.6 mm	Fe SG2 ER7056	ArCO ₂ O ₂	90/5/5	DC +		x	x		
129	Ø 1.4 mm	Fe SG2 ER7056	ArCO ₂	92/8	DC +	x	x	x		
130	Ø 0.8 mm	Fe SG2 ER7056	ArCO ₂	92/8	DC/P +	x	x	x		
131	Ø 1.0 mm	Fe SG2 ER7056	ArCO ₂	98/2	DC/P +		x	x		
132	Ø 1.0 mm	Fe SG2 ER7056	ArO ₂	97/3	DC/P +		x	x		
133	Ø 1.2 mm	Fe SG2 ER7056	ArO ₂	97/3	DC/P +		x	x		
134	Ø 1.0 mm	Fe SG2 ER7056	ArCO ₂ O ₂	90.5/7/2.5	DC/P +	x	x	x		
135	Ø 1.2 mm	Fe SG2 ER7056	ArCO ₂ O ₂	90.5/7/2.5	DC/P +	x	x	x		
136	Ø 1.0 mm	Fe SG2 ER7056	ArCO ₂ O ₂	82.5/15/2.5	DC/P +	x	x	x		
137	Ø 1.2 mm	Fe SG2 ER7056	ArCO ₂ O ₂	82.5/15/2.5	DC/P +	x	x	x		
138	Ø 1.0 mm	Fe SG2 ER7056	ArHeCO ₂	68/20/12	DC/P +	x	x	x		
139	Ø 1.2 mm	Fe SG2 ER7056	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		
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		



PROGRAM TABLE: PROGRAM PACKAGE 10645900 (C0)

Prog. No	Diameter	Program description	Gas specification		Function Polarity	Standard 10660000	StandardPlus 10660001	Special 10660002	IAC mild steel 10660003	IAC stainless steel 10660004
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		
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	
193	Ø 1.2 mm	Innershield	-	-	DC -	x	x	x		
194	Ø 1.6 mm	Innershield	-	-	DC -	x	x	x		
199	Ø 0.9 mm	Innershield	-	-	DC -	x	x	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			
243	Ø 1.2 mm	ER 347 Si	ArHeCO ₂	68/30/2	DC/P +		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		
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		

PROGRAM TABLE: PROGRAM PACKAGE 10645900 (C0)

Prog. No	Diameter	Program description	Gas specification		Function Polarity	Standard 10660000	StandardPlus 10660001	Special 10660002	IAC mild steel 10660003	IAC stainless steel 10660004
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
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	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-RS	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 FeRutil 15.14	CO ₂	100	DC +			x		
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		

