

PROGRAM TABLE: PROGRAM PACKAGE 10645900 (A0)

Prog.No ➤	Diameter	Program description	Gas specification		Function Polarity	Standard 10660100	TECHNOLIT 10660103	GM 10660102
			CO ₂	100				
101	Ø 0.8 mm	Fe SG2 ER70S6	CO ₂	100	DC +	x	x	
102	Ø 1.0 mm	Fe SG2 ER70S6	CO ₂	100	DC +	x	x	
103	Ø 1.2 mm	Fe SG2 ER70S6	CO ₂	100	DC +	x		
106	Ø 0.6 mm	Fe SG2 ER70S6	CO ₂	100	DC +	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		
116	Ø 0.6 mm	Fe SG2 ER70S6	ArCO ₂	82/18	DC/P +	x	x	x
201	Ø 0.8 mm	ER 316 LSI	ArCO ₂	98/2	DC/P +	x	x	
202	Ø 1.0 mm	ER 316 LSI	ArCO ₂	98/2	DC/P +	x	x	
203	Ø 1.2 mm	ER 316 LSI	ArCO ₂	98/2	DC/P +	x		
311	Ø 0.8 mm	AlMg5 ER5356	Ar	100	DC/P +	x	x	
312	Ø 1.0 mm	AlMg5 ER5356	Ar	100	DC/P +	x	x	
313	Ø 1.2 mm	AlMg5 ER5356	Ar	100	DC/P +	x	x	
316	Ø 1.0 mm	AlMg5 ER5356	ArHe	70/30	DC/P +	x		
317	Ø 1.2 mm	AlMg5 ER5356	ArHe	70/30	DC/P +	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
356	Ø 1.0 mm	AlSi5 ER4043	ArHe	70/30	DC/P +	x		
357	Ø 1.2 mm	AlSi5 ER4043	ArHe	70/30	DC/P +	x		
372	Ø 1.0 mm	AlSi12 ER4047	Ar	100	DC/P +	x	x	x
373	Ø 1.2 mm	AlSi12 ER4047	Ar	100	DC/P +	x	x	x
501	Ø 0.8 mm	CuAl8 Brazing	Ar	100	DC/P +	x		x
502	Ø 1.0 mm	CuAl8 Brazing	Ar	100	DC/P +	x		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
571	Ø 0.8 mm	CuAl8 Welding	Ar	100	P +	x	x	
572	Ø 1.0 mm	CuAl8 Welding	Ar	100	P +	x	x	

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103	Ø 1.2 mm	Fe SG2 ER70S6	CO ₂	100	DC +	x		
106	Ø 0.6 mm	Fe SG2 ER70S6	CO ₂	100	DC +	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		
116	Ø 0.6 mm	Fe SG2 ER70S6	ArCO ₂	82/18	DC/P +	x	x	x
201	Ø 0.8 mm	ER 316 LSI	ArCO ₂	98/2	DC/P +	x	x	
202	Ø 1.0 mm	ER 316 LSI	ArCO ₂	98/2	DC/P +	x	x	
203	Ø 1.2 mm	ER 316 LSI	ArCO ₂	98/2	DC/P +	x		
311	Ø 0.8 mm	AlMg5 ER5356	Ar	100	DC/P +	x	x	
312	Ø 1.0 mm	AlMg5 ER5356	Ar	100	DC/P +	x	x	
313	Ø 1.2 mm	AlMg5 ER5356	Ar	100	DC/P +	x	x	
316	Ø 1.0 mm	AlMg5 ER5356	ArHe	70/30	DC/P +	x		
317	Ø 1.2 mm	AlMg5 ER5356	ArHe	70/30	DC/P +	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
356	Ø 1.0 mm	AlSi5 ER4043	ArHe	70/30	DC/P +	x		
357	Ø 1.2 mm	AlSi5 ER4043	ArHe	70/30	DC/P +	x		
372	Ø 1.0 mm	AlSi12 ER4047	Ar	100	DC/P +	x	x	x
373	Ø 1.2 mm	AlSi12 ER4047	Ar	100	DC/P +	x	x	x
501	Ø 0.8 mm	CuAl8 Brazing	Ar	100	DC/P +	x		x
502	Ø 1.0 mm	CuAl8 Brazing	Ar	100	DC/P +	x		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
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