

PROGRAM TABLE: PROGRAM PACKAGE 10645900 (C0)

Prog. No	Diameter	Program description	Gas specification		Function Polarity	Standard 10660000	StandardPlus 10660001	Special 10660002
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 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

Note: the number of available programs may vary from your machine, as it depends on date of purchase. Please contact your MigatroniC dealer for purchase of new licenses

SIGMA NEXT RC PROGRAM TABLE

PROGRAM TABLE: PROGRAM PACKAGE 10645900 (C0)

Prog. No	Diameter	Program description	Gas specification		Function Polarity	Standard 10660000	StandardPlus 10660001	Special 10660002
002		Manuel MIG/MAG	CO ₂	100	DC +	x	x	x
003		Manuel MIG/MAG	ArCO ₂	82/18	DC +	x	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/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
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
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
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	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
255	Ø 1.2 mm	Duplex 2205	ArO ₂	98/2	DC/P +			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
265	Ø 1.2 mm	Super duplex 2507	ArO ₂	98/2	DC/P +			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
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
314	Ø 1.6 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
318	Ø 1.6 mm	AlMg5 ER5356	ArHe	70/30	DC/P +			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
323	Ø 1.2 mm	AlMg4.5 ER5183	ArHe	20/80	DC/P +			x
328	Ø 1.6 mm	AlMg4.5 ER5183	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
353	Ø 1.2 mm	AlSi5 ER4043	Ar	100	DC/P +	x		x
354	Ø 1.6 mm	AlSi5 ER4043	Ar	100	DC/P +	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
358	Ø 1.6 mm	AlSi5 ER4043	ArHe	70/30	DC/P +			x
359	Ø 0.9 mm	AlSi5 ER4043	Ar	100	DC +	x		x
363	Ø 1.2 mm	Al99.5 ER1100	Ar	100	DC/P +			x
364	Ø 1.6 mm	Al99.5 ER1100	Ar	100	DC/P +			x
369	Ø 0.9 mm	AlMg3Mn ER5554	Ar	100	DC +			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
402	Ø 1.0 mm	FCW FeRutil 215	ArCO ₂	82/18	DC +	x		x
403	Ø 1.2 mm	FCW FeRutil 215	ArCO ₂	82/18	DC +	x		x
404	Ø 1.6 mm	FCW FeRutil 215	ArCO ₂	82/18	DC +	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
415	Ø 1.4 mm	FCW FeBasic 6130	ArCO ₂	82/18	DC +/-	x		x
417	Ø 1.0 mm	FCW FeBasic 6125	ArCO ₂	82/18	DC -	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
424	Ø 1.6 mm	FCW115 Fe Metal	ArCO ₂	82/18	DC +	x		x
425	Ø 1.4 mm	FCW115 Fe Metal	ArCO ₂	82/18	DC +			x
426	Ø 1.0 mm	FCW FeM 710M/742M	ArCO ₂	82/18	DC +	x		x
427	Ø 1.2 mm	FCW FeM 710M	ArCO ₂	82/18	DC +	x		x
428	Ø 1.2 mm	FCW FeM 742M	ArCO ₂	82/18	DC +	x		x
429	Ø 1.2 mm	FCW FeM MX 100T	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
444	Ø 1.6 mm	FCW FeRutil 215	CO ₂	100	DC +	x		x
445	Ø 1.6 mm	FCW 115 Fe Metal	CO ₂	100	DC +	x		x
446	Ø 1.6 mm	FCW PZ6111-H5	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

