



SIGMA SELECT PROGRAM TABLE

Material	Diameter	Gas specification		Polarity	Program number	Item number	PROGRAM PACKAGE					PROCESS				
							Standard	Mild steel	Stainless steel	Aluminium	All included	DC	Pulse	Power Arc	IAC	
																10681000
MMA		-		+	001	Included	x				x	x				
Manual MIG/MAG		CO ₂	100	+	002	Included	x				x	x				
Manual MIG/MAG		ArCO ₂	82/18	+	003	Included	x				x	x				
ArcGouging		-		+	004	10680004		x			x	x				
Fe 5G2 ER7056	ø 0.6 mm	CO ₂	100	+	106	10680106	x				x	x				
		ArCO ₂	82/18	+	116	10680116	x				x	x	x			
		ArCO ₂ O ₂	90/5/5	+	128	10680128		x				x	x			
	ø 0.8 mm	CO ₂	100	+	101	10680101	x					x	x			
		ArCO ₂	82/18	+	111	10680111	x					x	x	x		
			92/8	+	130	10680130		x				x	x		x	
		ArHeCO ₂ O ₂	91/4/2/3	+	125	10680125		x				x	x	x		
		ArO ₂	92/8	+	185	10680185		x				x	x		x	
		ArCO ₂ O ₂	90/5/5	+	121	10680121		x				x	x	x		
	ø 0.9 mm	CO ₂	100	+	109	10680109	x					x	x			
		ArCO ₂	82/18	+	119	10680119	x					x	x	x		
		ArCO ₂	92/8	+	120	10680120		x				x	x		x	
	ø 1.0 mm	CO ₂	100	+	102	10680102	x					x	x			
		ArCO ₂	82/18	+	112	10680112	x					x	x	x	x	
			98/2	+	131	10680131		x				x	x	x		
			92/8	+	115	10680115		x				x	x	x		
			90/5/5	+	122	10680122		x				x	x	x		
		ArCO ₂ O ₂	90.5/7/2.5	+	134	10680134		x				x	x	x	x	
			82.5/15/2.5	+	136	10680136		x				x	x	x	x	
		ArHeCO ₂	68/20/12	+	138	10680138		x				x	x	x	x	
		ArHeCO ₂ O ₂	91/4/2/3	+	126	10680126		x				x	x	x	x	
		ArO ₂	97/3	+	132	10680132		x				x	x	x	x	
			92/8	+	176	10680176		x				x	x	x	x	
		ø 1.2 mm	CO ₂	100	+	103	10680103	x					x	x		
	ArCO ₂		82/18	+	113	10680113	x					x	x	x	x	
			92/8	+	118	10680118		x				x	x	x	x	
			90/5/5	+	123	10680123		x				x	x	x	x	
	ArCO ₂ O ₂		90.5/7/2.5	+	135	10680135		x				x	x	x	x	
			82.5/15/2.5	+	137	10680137		x				x	x	x	x	
	ArHeCO ₂		68/20/12	+	139	10680139		x				x	x	x	x	
	ArHeCO ₂ O ₂		91/4/2/3	+	127	10680127		x				x	x	x	x	
	ArO ₂		97/3	+	133	10680133		x				x	x	x	x	
			92/8	+	180	10680180		x				x	x	x	x	
	ø 1.4 mm		ArCO ₂	82/18	+	124	10680124	x					x	x		x
				92/8	+	129	10680129		x				x	x		x
		CO ₂	100	+	104	10680104	x					x	x			
	ø 1.6 mm	ArCO ₂	82/18	+	114	10680114	x					x	x	x	x	
		ArCO ₂	92/8	+	117	10680117		x				x	x	x		
	Innershield	ø 0.9 mm	-	-	-	199	10680199	x				x	x			
		ø 1.2 mm	-	-	-	193	10680193	x				x	x			
		ø 1.6 mm	-	-	-	194	10680194	x				x	x			
	ER 308 LSi	ø 0.8 mm	ArCO ₂	98/2	+	221	10680221	x				x	x	x		
			ArCO ₂ H ₂	96/3/1	+	226	10680226		x				x	x	x	
			ArCO ₂	98/2	+	222	10680222	x					x	x	x	
		ø 1.0 mm	ArO ₂	98/2	+	220	10680220	x					x	x	x	
			ArCO ₂ H ₂	96/3/1	+	227	10680227		x				x	x	x	
			ArCO ₂	98/2	+	223	10680223	x					x	x	x	
	ER 309 LSi	ø 0.8 mm	ArCO ₂ H ₂	96/3/1	+	228	10680228		x				x	x	x	
			ArCO ₂	98/2	+	224	10680224	x					x	x	x	
			ArCO ₂ H ₂	96/3/1	+	230	10680230		x				x	x	x	
ø 0.9 mm		ArCO ₂	98/2	+	231	10680231	x					x	x	x		
		ArCO ₂	98/2	+	225	10680225	x					x	x	x		
		ArO ₂	98/2	+	232	10680232	x					x	x	x		
ER 316 LSi	ø 0.8 mm	ArCO ₂ H ₂	96/3/1	+	229	10680229		x				x	x	x		
		ArCO ₂	98/2	+	201	10680201	x					x	x	x		
		ArCO ₂	98/2	+	209	10680209	x					x	x	x		
	ø 1.0 mm	ArCO ₂	98/2	+	202	10680202	x					x	x	x		
		ArO ₂	97/3	+	212	10680212		x				x	x	x		
		ArCO ₂	98/2	+	203	10680203	x					x	x	x		
ø 1.2 mm	ArO ₂	97/3	+	213	10680213		x				x	x	x			
	ArCO ₂	98/2	+	204	10680204	x					x	x	x			
	ArHeCO ₂	68/30/2	+	242	10680242		x				x	x	x			
ER 347 Si	ø 1.0 mm	ArHeCO ₂	68/30/2	+	243	10680243		x				x	x			
	ø 1.2 mm	ArHeCO ₂	68/30/2	+	243	10680243		x				x	x			
Duplex 2209	ø 1.0 mm	ArHeCO ₂	83/15/2	+	252	10680252		x				x	x			
		ArO ₂	98/2	+	254	10680254		x				x	x			
		ArHeCO ₂	83/15/2	+	253	10680253		x				x	x			
	ø 1.2 mm	ArO ₂	98/2	+	255	10680255		x				x	x			
CrNi Zecor	ø 1.2 mm	ArCO ₂	98/2	+	273	10680273		x				x	x			



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						Standard	Mild steel	Stainless steel	Aluminium	All included	DC	Pulse	Power Arc	IAC
						10681000	10681001	10681002	10681003	10681099	10682001	10682999	10682002	10682003
Super Duplex 2509	ø 1.0 mm	ArCO ₂	98/2	+	262	10680262			x		x		x	
		ArHeCO ₂	83/15/2	+	256	10680256			x		x		x	
		ArHeCO ₂	68/30/2			274	10680274			x		x		
		ArHeO ₂	69/30/1	+	267	10680267			x		x		x	
	ø 1.2 mm	ArO ₂	98/2	+	264	10680264			x		x	x	x	
		ArCO ₂	98/2	+	263	10680263			x		x		x	
		ArHeCO ₂	83/15/2	+	257	10680257			x		x		x	
AlMg5 ER5356	ø 0.8 mm	Ar	100	+	311	10680311	x				x	x		
		Ar	100	+	319	10680319	x				x	x	x	
	ø 0.9 mm	Ar	100	+	312	10680312	x				x	x	x	
		ArHe	70/30	+	316	10680316				x	x	x	x	
	ø 1.0 mm	ArHe	50/50	+	332	10680332				x	x	x	x	
		Ar	100	+	313	10680313	x				x	x	x	
		ArHe	70/30	+	317	10680317				x	x	x	x	
ø 1.2 mm	ArHe	50/50	+	333	10680333				x	x	x	x		
	Ar	100	+	314	10680314	x				x	x	x		
ø 1.6 mm	ArHe	70/30	+	318	10680318				x	x	x	x		
AlMg4.5MnZr ER5087	ø 1.2 mm	Ar	100	+	321	10680321				x	x	x	x	
AlMg4.5 ER5183	ø 1.2 mm	ArHe	20/80	+	323	10680323				x	x	x	x	
	ø 1.6 mm	ArHe	70/30	+	328	10680328				x	x	x	x	
AlMg3Mn ER5554	ø 0.9 mm	Ar	100	+	369	10680369				x	x	x		
	ø 0.9 mm	Ar	100	+	359	10680359	x				x	x		
AlSi5 ER4043	ø 1.0 mm	Ar	100	+	352	10680352	x				x	x	x	
		ArHe	70/30	+	356	10680356				x	x	x	x	
	ø 1.2 mm	Ar	100	+	353	10680353	x				x	x	x	
		ArHe	70/30	+	357	10680357				x	x	x	x	
	ø 1.6 mm	Ar	100	+	354	10680354	x				x	x	x	
		ArHe	70/30	+	358	10680358				x	x	x	x	
		Ar	100	+	363	10680363				x	x	x	x	
Al99.5 ER1100	ø 1.6 mm	Ar	100	+	364	10680364				x	x	x	x	
AlSi12 ER4047	ø 1.0 mm	Ar	100	+	372	10680372	x				x	x	x	
	ø 1.2 mm	Ar	100	+	373	10680373	x				x	x	x	
AlSi10 MG ER4046	ø 1.2 mm	ArHe	50/50	+	383	10680383				x	x	x	x	
AlSi10Cu4 ER4145	ø 1.2 mm	Ar	100	+	393	10680393				x	x	x		
FCW FeRutil 215	ø 1.0 mm	ArCO ₂	82/18	+	402	10680402	x				x	x		
	ø 1.2 mm	ArCO ₂	82/18	+	403	10680403	x				x	x		
		ArCO ₂	82/18	+	404	10680404	x				x	x		
	ø 1.6 mm	CO ₂	100	+	444	10680444	x				x	x		
FCW FeRutil 217	ø 1.2 mm	ArCO ₂	82/18	+	453	10680453	x				x	x		
FCW FeRutil 713R	ø 1.2 mm	ArCO ₂	82/18	+	454	10680454			x		x	x		
FCW FeRutil 15.14	ø 1.2 mm	CO ₂	100	+	443	10680443			x		x	x		
FCW FeRutil Nittetsu SF-1A	ø 1.2 mm	ArCO ₂	82/18	+	407	10680407			x		x	x		
FCW FeRutil Nittetsu SF-1E	ø 1.2 mm	CO ₂	100	+	448	10680448			x		x	x		
FCW FeRutil Nittetsu SF-3AM	ø 1.2 mm	ArCO ₂	82/18	+	408	10680408			x		x	x		
	ø 1.4 mm	ArCO ₂	82/18	+	409	10680409			x		x	x		
FCW FeRutil PZ6111	ø 1.6 mm	ArCO ₂	82/18	+	405	10680405			x		x	x		
FCW FeRutil PZ6111-HS	ø 1.6 mm	CO ₂	100	+	446	10680446			x		x	x		
FCW FeRutil 6114	ø 1.2 mm	ArCO ₂	82/18	+	458	10680458			x		x	x		
FCW FeRutil PZ61145	ø 1.2 mm	CO ₂	100	+	447	10680447			x		x	x		
FCW FeRutil PZ6138	ø 1.2 mm	ArCO ₂	82/18	+	457	10680457			x		x	x		
FCW FeRutil DWA 55E	ø 1.2 mm	ArCO ₂	82/18	+	451	10680451			x		x	x		
FCW FeRutil Tubrod 15.14	ø 1.2 mm	ArCO ₂	82/18	+	452	10680452			x		x	x		
FCW FeMetal 6104	ø 1.2 mm	CO ₂	100	+	495	10680495			x		x	x		
FCW FeMetal 6104	ø 1.2 mm	ArCO ₂	82/18	+	456	10680456			x		x	x		
FCW FeMetal MX 100T	ø 1.2 mm	ArCO ₂	82/18	+	429	10680429			x		x	x		
FCW FeMetal 115	ø 1.2 mm	ArCO ₂	82/18	+	423	10680423	x				x	x	x	
		ArCO ₂	82/18	+	425	10680425	x				x	x		
	ø 1.6 mm	ArCO ₂	82/18	+	424	10680424	x				x	x		
		CO ₂	100	+	445	10680445	x				x	x		
FCW FeMetal 235M	ø 1.2 mm	ArCO ₂	82/18	+	420	10680420			x		x	x		
FCW FeMetal 710M/742M	ø 1.0 mm	ArCO ₂	82/18	+	426	10680426			x		x	x		
FCW FeMetal 710M	ø 1.2 mm	ArCO ₂	82/18	+	427	10680427			x		x	x		
FCW FeMetal 742M	ø 1.2 mm	ArCO ₂	82/18	+	428	10680428			x		x	x		
FCW FeMetal MC-RS	ø 1.2 mm	ArCO ₂	82/18	+	418	10680418			x		x	x		
FCW FeMetal 700 T-MC	ø 1.2 mm	ArCO ₂	92/8	+	461	10680461			x		x	x	x	
FCW FeMetal HL 51-MC	ø 1.0 mm	ArCO ₂	92/8	+	462	10680462			x		x	x	x	
FCW FeMetal HL 51-MC	ø 1.2 mm	ArCO ₂	92/8	+	463	10680463			x		x	x	x	
FCW FeMetal 700MC	ø 1.0 mm	ArCO ₂	92/8	+	464	10680464			x		x	x	x	
FCW FeMetal 700MC	ø 1.2 mm	ArCO ₂	92/8	+	465	10680465			x		x	x	x	
FCW FeBasic 515	ø 1.2 mm	ArCO ₂	82/18	-	413	10680413			x		x	x		
FCW FeBasic 6130	ø 1.4 mm	CO ₂	100	+/-	435	10680435			x		x	x		
		ArCO ₂	82/18	+/-	415	10680415			x		x	x		
FCW FeBasic 6125	ø 1.0 mm	ArCO ₂	82/18	-	417	10680417			x		x	x		
FCW FeBasic 15.00	ø 1.4 mm	CO ₂	100	+/-	433	10680433			x		x	x		



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							Standard	Mild steel	Stainless steel	Aluminium	All included	DC	Pulse	Power Arc	IAC
												10681000	10681001		
FCW FeCr	ø 1.6 mm	ArCO ₂	82/18	+	474	10680474		x			x	x			
FCW CrNi E316LT-1	ø 1.2 mm	ArCO ₂	82/18	+	483	10680483			x		x	x			
FCW 2205	ø 1.2 mm	ArCO ₂	82/18	+	484	10680484		x			x	x			
FCW 2507	ø 1.2 mm	ArCO ₂	82/18	+	485	10680485		x			x	x			
FCW CrNi 15.31	ø 1.2 mm	ArO ₂	98/2	+	486	10680486			x		x	x			
FCW CrNi 309	ø 1.2 mm	CO ₂	100	+	493	10680493	x				x	x			
FCW CrNi 316L	ø 1.2 mm	CO ₂	100	+	494	10680494	x				x	x			
CuAl8 Brazing	ø 0.8 mm	Ar	100	+	501	10680501		x			x	x	x		
	ø 0.9 mm	Ar	100	+	509	10680509		x			x	x			
	ø 1.0 mm	Ar	100	+	502	10680502		x			x	x			
CuAl8 Welding	ø 0.8 mm	Ar	100	+	571	10680571		x			x		x		
	ø 1.0 mm	Ar	100	+	572	10680572		x			x		x		
	ø 1.2 mm	Ar	100	+	573	10680573		x			x		x		
CuSn Brazing	ø 1.2 mm	Ar	100	+	523	10680523		x			x		x		
AlBz9Fe Welding	ø 1.6 mm	Ar	100	+	554	10680554		x			x	x			
CuSi3 Brazing	ø 0.8 mm	Ar	100	+	561	10680561		x			x	x	x		
	ø 0.9 mm	Ar	100	+	569	10680569		x			x	x	x		
	ø 1.0 mm	Ar	100	+	562	10680562		x			x	x	x		
		ArCO ₂	92/8	+	567	10680567		x			x	x	x		
Inconel 625	ø 1.2 mm	Ar	100	+	588	10680588			x		x	x	x		
		ArHe	85/15	+	583	10680583			x		x	x	x		
	ø 1.6 mm	ArHe	85/15	+	584	10680584			x		x	x	x		
Inconel 718	ø 1.2 mm	ArHeCO ₂	95.8/4/0.2	+	591	10680591			x		x	x	x		
Inconel 825	ø 1.2 mm	ArHeCO ₂	81/18/1	+	590	10680590			x		x	x	x		
Inconel 82 / Monel 400	ø 1.2 mm	Ar	100	+	589	10680589			x		x	x	x		
FCW Inconel 625-PW	ø 1.2 mm	ArCO ₂	82/18	+	593	10680593			x		x	x			
UTP A 8051Ti	ø 1.2 mm	ArCO ₂	98/2	+	595	10680595			x		x		x		
SMO	ø 1.0 mm	ArHeCO ₂	68/30/2	+	596	10680596			x		x	x	x		
	ø 1.2 mm	ArHeCO ₂	68/30/2	+	597	10680597			x		x	x	x		
Titanium Gr.2	ø 1.6 mm	ArHe	70/30	+	704	10680704			x		x		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.