

Welding programs

Program No.	Pre Flow (s)	Start Amp (A)	Up Slope (S)	Welding Amp (A)	Pulse With (%)	Pulse Amp (%)	Pulse Frequence (Hz)	AC Balance (%)	AC Frequence (Hz)	Down Slope (s)	End Amp (A)	Post Flow (s)	Indications
1	1	5	0	16	-	-	-	-	-	0	5	7	INOX 1 mm pulse off
2	1	5	0	24	40	20	2,7	-	-	0	5	7	INOX > 1 mm pulse on
3	1	7	1	50	-	-	-	-	-	1	5	7	INOX 2 mm pulse off
4	1	7	1	60	40	20	4	-	-	1	10	7	INOX 2,5/3 mm pulse on
5	1	10	1	85	-	-	-	-	-	2	10	7	INOX 4 mm pulse off
6	1	5	0	24	-	-	-	45	85	1	5	7	Aluminium 1 mm pulse off
7	1	7	1	69	-	-	-	45	85	1	10	7	Aluminium 2 mm pulse off
8	1	10	1	80	-	-	-	45	85	1	10	7	Aluminium 2,5/3 mm pulse off
9	1	10	2	140	-	-	-	45	50	2	10	7	Aluminium 4 mm pulse off