

## AUTOMIG PULSE PROGRAM TABLE

Material	Diameter						PROGRAM PACKAGE	PROCESS		ISC
		Gas specification		Polarity	Program number	Item number	Standard 10681030	DC	Pulse	10682006
Manual MIG/MAG		CO <sub>2</sub>	100	+	002	10680002	x	x		
Manual MIG/MAG		ArCO <sub>2</sub>	82/18	+	003	10680003	x	x		
Fe SG2 ER70S6	ø 0.6 mm	CO <sub>2</sub>	100	+	106	10680106	x	x		
		ArCO <sub>2</sub>	82/18	+	116	10680116	x	x	x	
		CO <sub>2</sub>	100	+	101	10680101	x	x		
	ø 0.8 mm	ArCO <sub>2</sub>	82/18	+	111	10680111	x	x	x	x
		ArCO <sub>2</sub>	92/8	+	130	10680130	x	x	x	x
		CO <sub>2</sub>	100	+	109	10680109	x	x		
	ø 0.9 mm	ArCO <sub>2</sub>	82/18	+	119	10680119	x	x	x	x
		ArCO <sub>2</sub>	92/8	+	120	10680120	x	x	x	x
		CO <sub>2</sub>	100	+	102	10680102	x	x		
	ø 1.0 mm	ArCO <sub>2</sub>	82/18	+	112	10680112	x	x	x	x
		ArCO <sub>2</sub>	92/8	+	115	10680115	x	x	x	x
		ArCO <sub>2</sub>	98/2	+	201	10680201	x	x	x	x
ER 316 LSi	ø 0.9 mm	ArCO <sub>2</sub>	98/2	+	209	10680209	x	x	x	x
	ø 1.0 mm	ArCO <sub>2</sub>	98/2	+	202	10680202	x	x	x	x
AlMg5 ER5356	ø 0.8 mm	Ar	100	+	311	10680311	x	x	x	
	ø 0.9 mm	Ar	100	+	319	10680319	x	x	x	
		Ar	100	+	312	10680312	x	x	x	
	ø 1.0 mm	ArHe	70/30	+	316	10680316	x	x	x	
			50/50	+	332	10680332	x	x	x	
		Ar	100	+	313	10680313	x	x	x	
	ø 1.2 mm	ArHe	70/30	+	317	10680317	x	x	x	
			50/50	+	333	10680333	x	x	x	
		Ar	100	+	369	10680369	x	x	x	
AlMg2.7Mn ER5554	ø 1.0 mm	Ar	100	+	367	10680367	x	x	x	
	ø 1.2 mm	Ar	100	+	368	10680368	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	
		ArHe	70/30	+	356	10680356	x	x	x	
		Ar	100	+	353	10680353	x	x	x	
	ø 1.2 mm	ArHe	70/30	+	357	10680357	x	x	x	
		Ar	100	+	372	10680372	x	x	x	
AlSi12 ER4047	ø 1.2 mm	Ar	100	+	373	10680373	x	x	x	
AlSi10Cu4 ER4145	ø 1.2 mm	Ar	100	+	393	10680393	x	x	x	
CuAl8 Brazing	ø 0.8 mm	Ar	100	+	501	10680501	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	
	ø 1.0 mm	Ar	100	+	572	10680572	x		x	
CuSi3 Brazing	ø 0.8 mm	Ar	100	+	561	10680561	x	x	x	
	ø 0.9 mm	Ar	100	+	569	10680569	x	x	x	
	ø 1.0 mm	Ar	100	+	562	10680562	x	x	x	

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

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		ArCO <sub>2</sub>	82/18	+	116	10680116	x	x	x	
		CO <sub>2</sub>	100	+	101	10680101	x	x		
	ø 0.8 mm	ArCO <sub>2</sub>	82/18	+	111	10680111	x	x	x	x
		ArCO <sub>2</sub>	92/8	+	130	10680130	x	x	x	x
		CO <sub>2</sub>	100	+	109	10680109	x	x		
	ø 0.9 mm	ArCO <sub>2</sub>	82/18	+	119	10680119	x	x	x	x
		ArCO <sub>2</sub>	92/8	+	120	10680120	x	x	x	x
		CO <sub>2</sub>	100	+	102	10680102	x	x		
	ø 1.0 mm	ArCO <sub>2</sub>	82/18	+	112	10680112	x	x	x	x
		ArCO <sub>2</sub>	92/8	+	115	10680115	x	x	x	x
		ArCO <sub>2</sub>	98/2	+	201	10680201	x	x	x	x
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