



<b><u>Weld Process:</u></b>	Pulse
<b><u>Wire Feed Speed Range:</u></b>	100 – 780 inches per minute
<b><u>Wire Diameter:</u></b>	0.035 - 0.045"
<b><u>Recommended Shielding Gas:</u></b>	Mixed Gas - Argon Helium Gas 75/25 (Ar/He) Single Gas – Argon
<b><u>Recommended Wire Alloys:</u></b>	ERNiCrCoMo-1 ERNiCrMo-3 ERNiCrMo-10

### **Optional Program Card**

1. Insert optional program card and leave inserted while using custom program
2. Select wire feeder
  - a) Press either the LEFT or RIGHT (dual feeder only) button on the feeder OR
  - b) Press the SIDE SELECT button on the power source until the desired wire feeder side is illuminated
3. Select weld process
  - a) Press the MIG TYPE button on the power source front panel until the desired process is illuminated
  - b) CARD will illuminate on the power source front panel as well as on the feeder front panel to indicate that the optional program is being used from the memory card
4. Select the wire diameter, if applicable
  - a) Press the WIRE DIA button on the power source front panel until the desired wire diameter is illuminated
  - b) NOTE: some optional program cards only support a single wire diameter, in which case only that diameter will illuminate
5. Remove memory card to revert to standard operation