**Weld Process:**   Pulse

**Wire Feed Speed Range:**   100 – 500 inches per minute

**Wire Diameter:**   0.035" - 0.045"

**Recommended Shielding Gas:**   Mixed Gas - Argon Helium Gas 75/25 (Ar/He)

Single Gas – Argon

**Recommended Wire Alloys:**   ERNiCrCoMo-1

ERNiCrMo-3

ERNiCrMo-10

**Optional Program Card**

1. Insert optional program card and leave inserted while using custom program

2. Select weld process
   a) Press the MIG TYPE button on the inside panel of the feeder or front panel until the desired process is illuminated
   b) CARD will illuminate on the inside panel as well as on the feeder front panel to indicate that the optional program is being used from the memory card

3. Select the wire diameter, if applicable
   a) Press the WIRE DIA button on the inside 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

4. Remove memory card to revert to standard operation