

# Welding program tables

## TSt 2700c MP welding program table

Pos.		Inch	mm		Pos.
1	Steel				
2	Steel dynamic	.030	0.8		
3	Steel root	.035	0.9	CO <sub>2</sub> 100%	A
4	Rutil / E 71 T	.040	1.0	Ar + 8-12%CO <sub>2</sub>	B
5	Basic / E 70 T	.045	1.2	Ar + 15-25%CO <sub>2</sub>	C
6	Metal Cored	.052	1.4	Ar + 3-6%O <sub>2</sub>	D
7	Self-shielded	1/16	1.6	Ar 100%	E
8	SP	SP	SP	SP	F

## UID 3788 welding program database

Standard Programs										
Material		Gas		Diameter						
Pos.		Pos.		0,8 mm .030"	0,9 mm .035"	1,0 mm .040"	1,2 mm .045"	1,4 mm .052"	1,6 mm 1/16"	SP
1	Steel	A	100 % CO <sub>2</sub>	3813	3812	3811	2322			3814*
1	Steel	B	Ar + 8-12 % CO <sub>2</sub>	2288	2298	2308	2324			
1	Steel	C	Ar + 15-25 % CO <sub>2</sub>	3809	3808	3806	2488			3810*
1	Steel	D	Ar + 3-6 % O <sub>2</sub>	2285	2297	2307	2323			
2	Steel dynamic	B	Ar + 8-12 % CO <sub>2</sub>	2292	2302	2312	2326			
2	Steel dynamic	C	Ar + 15-25 % CO <sub>2</sub>	2293	2303	2313	2327			
2	Steel dynamic	D	Ar + 3-6 % O <sub>2</sub>	2291	2301	2311	2325			
3	Steel root	A	100 % CO <sub>2</sub>	2502	2501	2499	2500			
3	Steel root	B	Ar + 8-12 % CO <sub>2</sub>	2295	2305	2315	2329			
3	Steel root	C	Ar + 15-25 % CO <sub>2</sub>	2296	2306	2316	2330			
3	Steel root	D	Ar + 3-6 % O <sub>2</sub>	2294	2304	2314	2328			
4	Rutil FCW	A	100 % CO <sub>2</sub>		2410		2321			
4	Rutil FCW	C	Ar + 15-25 % CO <sub>2</sub>		2411		2320			
5	Basic FCW	A	100 % CO <sub>2</sub>				2317			
5	Basic FCW	C	Ar + 15-25 % CO <sub>2</sub>				2318			
6	Metal cored	B	Ar + 8-12 % CO <sub>2</sub>		2420		2385			
6	Metal cored	C	Ar + 15-25 % CO <sub>2</sub>		2421		2536			
7	Self-shielded				2350		2349			

\* Diameter = 0.6 mm (0.024 inch)

Special assignment										
Material		Gas		Diameter						
Pos.		Pos.		0,8 mm .030"	0,9 mm .035"	1,0 mm .040"	1,2 mm .045"	1,4 mm .052"	1,6 mm 1/16"	SP
1	Stainless Steel	F	Ar + 2,5 % CO <sub>2</sub>	2427	2402	2426	2405			
3	Stainless Steel root	F	Ar + 2,5 % CO <sub>2</sub>	2440	2441	2442	2443			
8	FCW Stainless Steel	C	Ar + 18 % CO <sub>2</sub>		2423		2424			
8	AlMg5	E	100 % Ar			3639	3643			
1	AlSi5	E	100 % Ar			3640	3092			
8	CuSi3	F	100 % Ar (Ar + 2,5 % CO <sub>2</sub> )	2496	2495	2493	2497			