

Synergic programs list for Art. 321 – Rev.05

Number of curves: 40

Material	Alloy	Diameter	Gas	Pulse	Short
Fe	SG2 (G3Si1)	0.6mm	Ar 18%CO2	•	•
Fe	SG2 (G3Si1)	0.8mm	Ar 18%CO2	•	•
Fe	SG2 (G3Si1)	0.9mm	Ar 18%CO2	•	•
Fe	SG2 (G3Si1)	1.0mm	Ar 18%CO2	•	•
Fe	SG2 (G3Si1)	0.6mm	Ar 25%CO2	•	•
Fe	SG2 (G3Si1)	0.8mm	Ar 25%CO2	•	•
Fe	SG2 (G3Si1)	0.9mm	Ar 25%CO2	•	•
Fe	SG2 (G3Si1)	1.0mm	Ar 25%CO2	•	•
Fe	SG2 (G3Si1)	0.8mm	Ar 8%CO2	•	•
Fe	SG2 (G3Si1)	1.0mm	Ar 8%CO2	•	•
Fe	SG2 (G3Si1)	1.2mm	Ar 8%CO2	•	•
Fe	SG2 (G3Si1)	0.6mm	CO2		•
Fe	SG2 (G3Si1)	0.8mm	CO2		•
Fe	SG2 (G3Si1)	0.9mm	CO2		•
Fe	SG2 (G3Si1)	1.0mm	CO2		•
Fe	X96 (ER120S-G)	0.8mm	Ar 18%CO2	•	•
Fe	X96 (ER120S-G)	0.8mm	Ar 25%CO2	•	•
Al	AlMg2.7Mn (5554)	1.0mm	Ar	•	•
Al	AlMg2.7Mn (5554)	1.2mm	Ar	•	•
Al	AlMg5 (5356)	0.8mm	Ar	•	•
Al	AlMg5 (5356)	0.9mm	Ar	•	•
Al	AlMg5 (5356)	1.0mm	Ar	•	•
Al	AlSi12 (4047)	0.6mm	Ar	•	•
Al	AlSi12 (4047)	0.8mm	Ar	•	•
Al	AlSi12 (4047)	0.9mm	Ar	•	•
Al	AlSi12 (4047)	1.0mm	Ar	•	•
Al	AlSi5 (4043)	0.8mm	Ar	•	•
Al	AlSi5 (4043)	0.9mm	Ar	•	•
Al	AlSi5 (4043)	1.0mm	Ar	•	•
Al	AlSi5 (4043)	1.2mm	Ar	•	•
Al	AlSiCu (4145)	1.2mm	Ar	•	•
SS	308L	0.8mm	Ar 2%CO2	•	•
SS	308L	0.9mm	Ar 2%CO2	•	•
SS	308L	1.0mm	Ar 2%CO2	•	•
SS	308L	1.2mm	Ar 2%CO2	•	•
SS	316L	0.8mm	Ar 2%CO2	•	•
SS	316L	1.0mm	Ar 2%CO2	•	•
Speciale	CuSi3	0.8mm	Ar	•	•
Speciale	CuSi3	0.9mm	Ar	•	•
Speciale	CuSi3	1.0mm	Ar	•	•

Last Approved: 10/10/2019