

# MASTER SOFTWARE ALLWELD

79 .11.00044

**MIG/MAG and pulsed MIG/MAG welding**



## HIGHLIGHTS

- » Böhler Arc welding programs.
- » Universal Arc welding programs.
- » For carbon steel, stainless steel, aluminium, nickel & copper alloy.



MIG/MAG WELDING PROGRAMS	
Filler Material	Process
BOHLER EMK 8 Ultra Ø0,8mm C1 (CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ultra Ø0,8mm C1 (CO <sub>2</sub> )	ArcDrive
BOHLER Q G4 Ø0,8mm C1 (CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ø0,8mm C1 (CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ø0,8mm C1 (CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ultra Ø1,0mm C1 (CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ultra Ø1,0mm C1 (CO <sub>2</sub> )	ArcDrive
BOHLER Q G4 Ø1,0mm C1 (CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ø1,0mm C1 (CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ø1,0mm C1 (CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ultra Ø1,2mm C1 (CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ultra Ø1,2mm C1 (CO <sub>2</sub> )	ArcDrive
BOHLER Q G4 Ø1,2mm C1 (CO <sub>2</sub> )	ArcDrive

# MASTER SOFTWARE ALLWELD

<b>MIG/MAG WELDING PROGRAMS</b> <i>(continued)</i>	
<b>Filler Material</b>	<b>Process</b>
BOHLER EMK 8 Ø1,2mm C1 (CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ø1,2mm C1 (CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ultra Ø1,6mm C1 (CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ultra Ø1,6mm C1 (CO <sub>2</sub> )	ArcDrive
BOHLER Q G4 Ø1,6mm C1 (CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ø1,6mm C1 (CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ø1,6mm C1 (CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ultra Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BOHLER Q G4 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ultra Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BOHLER Q G4 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ultra Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BOHLER Q G4 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ultra Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BOHLER Q G4 Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ultra Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
BOHLER Q G4 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ultra Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
BOHLER Q G4 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ultra Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
BOHLER Q G4 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ultra Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
BOHLER Q G4 Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 6 Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
diamondspark 52 MC Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
diamondspark 52 MC Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
Thermanit JE 308L Si Ø0,8mm M12 (Ar 0,5+5% CO <sub>2</sub> )	ArcDrive
Thermanit JE 308L Si Ø1,0mm M12 (Ar 0,5+5% CO <sub>2</sub> )	ArcDrive
Thermanit JE 308L Si Ø1,2mm M12 (Ar 0,5+5% CO <sub>2</sub> )	ArcDrive

# MASTER SOFTWARE ALLWELD

<b>MIG/MAG WELDING PROGRAMS</b> <i>(continued)</i>	
<b>Filler Material</b>	<b>Process</b>
Thermanit JE 308L Si Ø1,6mm M12 (Ar 0,5+5% CO <sub>2</sub> )	ArcDrive
Thermanit GE 316L Si Ø0,8mm M12 (Ar 0,5+5% CO <sub>2</sub> )	ArcDrive
Thermanit GE 316L Si Ø1,0mm M12 (Ar 0,5+5% CO <sub>2</sub> )	ArcDrive
Thermanit GE 316L Si Ø1,2mm M12 (Ar 0,5+5% CO <sub>2</sub> )	ArcDrive
Thermanit GE 316L Si Ø1,6mm M12 (Ar 0,5+5% CO <sub>2</sub> )	ArcDrive
Thermanit 22/09 Ø1,0mm M12 (Ar 2%CO <sub>2</sub> )	ArcDrive
Thermanit 22/09 Ø1,2mm M12 (Ar 2%CO <sub>2</sub> )	ArcDrive
Xcore GUARD 308L-T1 Ø1,2mm M21 (Ar 15+25% CO <sub>2</sub> )	ArcDrive
FOXcore 316 T0 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
Union AIMg5 Ø1,2mm I1 (Ar)	ArcDrive
FOXcore 307 MC Ø1,2mm M12 (Ar 0,5+5%CO <sub>2</sub> )	ArcDrive
FOXcore 13 4 MC Ø1,2mm M12 (Ar 0,5+5%CO <sub>2</sub> )	ArcDrive
diamondspark 700 MC Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
diamondspark 700 MC Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
diamondspark 700 MC Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
diamondspark 700 MC Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
diamondspark 900 MC Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
diamondspark 900 MC Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
diamondspark 900 MC Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
diamondspark 900 MC Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
diamondspark 52 MC Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
diamondspark 52 MC Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ultra Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ultra Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ultra Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ultra Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ultra Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ultra Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ultra Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive

# MASTER SOFTWARE ALLWELD

<b>MIG/MAG WELDING PROGRAMS</b> <i>(continued)</i>	
<b>Filler Material</b>	<b>Process</b>
BOHLER EMK 8 Ultra Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
BOHLER EMK 8 Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
ECOSpark 420 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
ECOSpark 420 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
ECOSpark 420 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
ECOSpark 420 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
ECOSpark 420 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
ECOSpark 420 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
diamondspark GUARD 420 MC Ø1,2mm M21 (Ar 15+ 25%CO <sub>2</sub> )	ArcDrive
diamondspark GUARD 420 RC Ø1,2mm M21 (Ar 15+ 25%CO <sub>2</sub> )	ArcDrive
FOXcore GUARD 316L-T1 Ø1,2mm M21 (Ar 15+25% CO <sub>2</sub> )	ArcDrive
UTP RB CHROMELESS 600 Ø1,2mm M21 (Ar 15+25% CO <sub>2</sub> )	ArcDrive
UTP RB CHROMELESS 600 Ø1,6mm M21 (Ar 15+25% CO <sub>2</sub> )	ArcDrive
G3/4 Si1 (ER70S-6) Ø0,8mm C1 (CO <sub>2</sub> )	ArcDrive
G3/4 Si1 (ER70S-6) Ø1,0mm C1 (CO <sub>2</sub> )	ArcDrive
G3/4 Si1 (ER70S-6) Ø1,2mm C1 (CO <sub>2</sub> )	ArcDrive
G3/4 Si1 (ER70S-6) Ø1,6mm C1 (CO <sub>2</sub> )	ArcDrive
G3/4 Si1 (ER70S-6) Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
G3/4 Si1 (ER70S-6) Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
G3/4 Si1 (ER70S-6) Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
G3/4 Si1 (ER70S-6) Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
G3/4 Si1 (ER70S-6) Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
G3/4 Si1 (ER70S-6) Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
G3/4 Si1 (ER70S-6) Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
G3/4 Si1 (ER70S-6) Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
Hardfacing Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
Hardfacing Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BFCW Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
BFCW Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
RFCW Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
RFCW Ø1,2mm C1 (CO <sub>2</sub> )	ArcDrive
MFCW Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
MFCW Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
MFCW Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
MFCW Ø1,2mm C1 (CO <sub>2</sub> )	ArcDrive
CrNi 13 4 (ER410) Ø1,2mm M12 (Ar 0,5+5%CO <sub>2</sub> )	ArcDrive

# MASTER SOFTWARE ALLWELD

<b>MIG/MAG WELDING PROGRAMS</b> <i>(continued)</i>	
<b>Filler Material</b>	<b>Process</b>
CrNi 18 8 (ER307) Ø0,8mm M12 (Ar 0,5+5%CO <sub>2</sub> )	ArcDrive
CrNi 18 8 (ER307) Ø1,0mm M12 (Ar 0,5+5%CO <sub>2</sub> )	ArcDrive
CrNi 18 8 (ER307) Ø1,2mm M12 (Ar 0,5+5%CO <sub>2</sub> )	ArcDrive
CrNi 19 9 (ER308) Ø0,8mm M12 (Ar 0,5+5%CO <sub>2</sub> )	ArcDrive
CrNi 19 9 (ER308) Ø1,0mm M12 (Ar 0,5+5%CO <sub>2</sub> )	ArcDrive
CrNi 19 9 (ER308) Ø1,2mm M12 (Ar 0,5+5%CO <sub>2</sub> )	ArcDrive
CrNi 19 9 (ER308) Ø1,6mm M12 (Ar 0,5+5%CO <sub>2</sub> )	ArcDrive
CrNi 19 12 3 (ER316) Ø0,8mm M12 (Ar 0,5+5% CO <sub>2</sub> )	ArcDrive
CrNi 19 12 3 (ER316) Ø1,0mm M12 (Ar 0,5+5% CO <sub>2</sub> )	ArcDrive
CrNi 19 12 3 (ER316) Ø1,2mm M12 (Ar 0,5+5% CO <sub>2</sub> )	ArcDrive
CrNi 19 12 3 (ER316) Ø1,6mm M12 (Ar 0,5+5% CO <sub>2</sub> )	ArcDrive
CrNi 22 09 (ER2209) Ø1,0mm M12 (Ar 0,5+5%CO <sub>2</sub> )	ArcDrive
CrNi 22 09 (ER2209) Ø1,2mm M12 (Ar 0,5+5%CO <sub>2</sub> )	ArcDrive
CrNi 23 12 (ER309) Ø1,0mm M12 (Ar 0,5+5%CO <sub>2</sub> )	ArcDrive
CrNi 23 12 (ER309) Ø1,2mm M12 (Ar 0,5+5%CO <sub>2</sub> )	ArcDrive
CrNi 25 09 (ER2509) Ø1,2mm Z (Ar 30%He 2%CO <sub>2</sub> )	ArcDrive
CrNi 25 20 (ER310) Ø0,8mm M12 (Ar 0,5+5%CO <sub>2</sub> )	ArcDrive
CrNi 25 20 (ER310) Ø1,0mm M12 (Ar 0,5+5%CO <sub>2</sub> )	ArcDrive
CrNi 25 20 (ER310) Ø1,2mm M12 (Ar 0,5+5%CO <sub>2</sub> )	ArcDrive
CrNb 16 (ER430) Ø1,0mm M12 (Ar 0,5+5%CO <sub>2</sub> )	ArcDrive
CrNi 13 4 FCW (E410) Ø1,2mm M21 (Ar 15+25% CO <sub>2</sub> )	ArcDrive
CrNi 19 12 3 FCW (E316) Ø1,2mm M21 (Ar 15+25% CO <sub>2</sub> )	ArcDrive
CuAl8 (ERCuAl) Ø0,8mm I1 (Ar)	ArcDrive
CuAl8 (ERCuAl) Ø1,0mm I1 (Ar)	ArcDrive
CuAl8 (ERCuAl) Ø1,2mm I1 (Ar)	ArcDrive
CuAl8 (ERCuAl) Ø1,6mm I1 (Ar)	ArcDrive
CuSi3 (ERCuSi) Ø0,8mm I1 (Ar)	ArcDrive
CuSi3 (ERCuSi) Ø1,0mm I1 (Ar)	ArcDrive
CuSi3 (ERCuSi) Ø1,2mm I1 (Ar)	ArcDrive
AlMg5 (ER5356) Ø0,8mm I1 (Ar)	ArcDrive
AlMg5 (ER5356) Ø1,0mm I1 (Ar)	ArcDrive
AlMg5 (ER5356) Ø1,2mm I1 (Ar)	ArcDrive
AlMg5 (ER5356) Ø1,6mm I1 (Ar)	ArcDrive
AISI5 (ER4043) Ø0,8mm I1 (Ar)	ArcDrive
AISI5 (ER4043) Ø1,0mm I1 (Ar)	ArcDrive
AISI5 (ER4043) Ø1,2mm I1 (Ar)	ArcDrive

# MASTER SOFTWARE ALLWELD

<b>MIG/MAG WELDING PROGRAMS</b> <i>(continued)</i>	
<b>Filler Material</b>	<b>Process</b>
AlSi5 (ER4043) Ø1,6mm I1 (Ar)	ArcDrive
Al99,5 (ER1050) Ø0,8mm I1 (Ar)	ArcDrive
Al99,5 (ER1050) Ø1,0mm I1 (Ar)	ArcDrive
Al99,5 (ER1050) Ø1,2mm I1 (Ar)	ArcDrive
Al99,5 (ER1050) Ø1,6mm I1 (Ar)	ArcDrive
G 69 4 M (ER110S-G) Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
G 69 4 M (ER110S-G) Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
G 69 4 M (ER110S-G) Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
G 69 4 M (ER110S-G) Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	ArcDrive
G 69 4 M (ER110S-G) Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
G 69 4 M (ER110S-G) Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	ArcDrive
MCW Ø1,2mm Self shielded	ArcDrive
BOHLER EMK 6 Ultra Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
BOHLER Q G4 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 6 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 6 Ultra Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
BOHLER Q G4 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 6 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 6 Ultra Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
BOHLER Q G4 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 6 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 6 Ultra Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
BOHLER Q G4 Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 6 Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 6 Ultra Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
BOHLER Q G4 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 6 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 6 Ultra Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
BOHLER Q G4 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 6 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 6 Ultra Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
BOHLER Q G4 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 6 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 6 Ultra Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
BOHLER Q G4 Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 6 Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep

# MASTER SOFTWARE ALLWELD

<b>MIG/MAG WELDING PROGRAMS</b> <i>(continued)</i>	
<b>Filler Material</b>	<b>Process</b>
diamondspark 52 MC Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
diamondspark 52 MC Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
Thermanit JE 308L Si Ø0,8mm M12 (Ar 0,5+5% CO <sub>2</sub> )	RapiDeep
Thermanit JE 308L Si Ø1,0mm M12 (Ar 0,5+5% CO <sub>2</sub> )	RapiDeep
Thermanit JE 308L Si Ø1,2mm M12 (Ar 0,5+5% CO <sub>2</sub> )	RapiDeep
Thermanit JE 308L Si Ø1,6mm M12 (Ar 0,5+5% CO <sub>2</sub> )	RapiDeep
Thermanit GE 316L Si Ø0,8mm M12 (Ar 0,5+5% CO <sub>2</sub> )	RapiDeep
Thermanit GE 316L Si Ø1,0mm M12 (Ar 0,5+5% CO <sub>2</sub> )	RapiDeep
Thermanit GE 316L Si Ø1,2mm M12 (Ar 0,5+5% CO <sub>2</sub> )	RapiDeep
Thermanit GE 316L Si Ø1,6mm M12 (Ar 0,5+5% CO <sub>2</sub> )	RapiDeep
diamondspark 700 MC Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
diamondspark 700 MC Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
diamondspark 700 MC Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
diamondspark 700 MC Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
diamondspark 900 MC Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
diamondspark 900 MC Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
diamondspark 900 MC Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
diamondspark 900 MC Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
diamondspark 52 MC Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
diamondspark 52 MC Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 8 Ultra Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 8 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 8 Ultra Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 8 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 8 Ultra Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 8 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 8 Ultra Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 8 Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 8 Ultra Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 8 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 8 Ultra Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 8 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 8 Ultra Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 8 Ø1,2mm M20 (Ar 5-15%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 8 Ultra Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
BOHLER EMK 8 Ø1,6mm M20 (Ar 5-15%CO <sub>2</sub> )	RapiDeep

# MASTER SOFTWARE ALLWELD

<b>MIG/MAG WELDING PROGRAMS</b> <i>(continued)</i>	
<b>Filler Material</b>	<b>Process</b>
ECOspark 420 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
ECOspark 420 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
ECOspark 420 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
ECOspark 420 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
ECOspark 420 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
ECOspark 420 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
diamondspark GUARD 420 MC Ø1,2mm M21 (Ar 15+ 25%CO <sub>2</sub> )	RapiDeep
G3/4 Si1 (ER70S-6) Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
G3/4 Si1 (ER70S-6) Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
G3/4 Si1 (ER70S-6) Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
G3/4 Si1 (ER70S-6) Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	RapiDeep
G3/4 Si1 (ER70S-6) Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
G3/4 Si1 (ER70S-6) Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
G3/4 Si1 (ER70S-6) Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
G3/4 Si1 (ER70S-6) Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	RapiDeep
CrNi 19 9 (ER308) Ø0,8mm M12 (Ar 0,5+5%CO <sub>2</sub> )	RapiDeep
CrNi 19 9 (ER308) Ø1,0mm M12 (Ar 0,5+5%CO <sub>2</sub> )	RapiDeep
CrNi 19 9 (ER308) Ø1,2mm M12 (Ar 0,5+5%CO <sub>2</sub> )	RapiDeep
CrNi 19 9 (ER308) Ø1,6mm M12 (Ar 0,5+5%CO <sub>2</sub> )	RapiDeep
AlMg5 (ER5356) Ø1,2mm I1 (Ar)	RapiDeep
AlMg5 (ER5356) Ø1,6mm I1 (Ar)	RapiDeep
AlSi5 (ER4043) Ø1,2mm I1 (Ar)	RapiDeep
AlSi5 (ER4043) Ø1,6mm I1 (Ar)	RapiDeep
Al99,5 (ER1050) Ø1,2mm I1 (Ar)	RapiDeep
Al99,5 (ER1050) Ø1,6mm I1 (Ar)	RapiDeep
<b>PULSED MIG/MAG WELDING PROGRAMS</b>	
<b>Filler Material</b>	<b>Process</b>
BOHLER EMK 6 Ultra Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
BOHLER Q G4 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 6 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 6 Ultra Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
BOHLER Q G4 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 6 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 6 Ultra Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
BOHLER Q G4 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 6 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive

# MASTER SOFTWARE ALLWELD

<b>PULSED MIG/MAG WELDING PROGRAMS</b> <i>(continued)</i>	
<b>Filler Material</b>	<b>Process</b>
BOHLER EMK 6 Ultra Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
BOHLER Q G4 Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 6 Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 6 Ultra Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
BOHLER Q G4 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 6 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 6 Ultra Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
BOHLER Q G4 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 6 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 6 Ultra Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
BOHLER Q G4 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 6 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 6 Ultra Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
BOHLER Q G4 Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 6 Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
diamondspark 54 MC Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
diamondspark 46 MC Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
diamondspark 52 MC Ø1,0mm M21 (Ar 15+25% CO <sub>2</sub> )	PulsDrive
diamondspark 54 MC Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
diamondspark 46 MC Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
diamondspark 52 MC Ø1,2mm M21 (Ar 15+25% CO <sub>2</sub> )	PulsDrive
Thermanit JE 308L Si Ø0,8mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
Thermanit JE 308L Si Ø1,0mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
Thermanit JE 308L Si Ø1,2mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
Thermanit JE 308L Si Ø1,6mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
Thermanit GE 316L Si Ø0,8mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
Thermanit GE 316L Si Ø1,0mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
Thermanit GE 316L Si Ø1,2mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
Thermanit GE 316L Si Ø1,6mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
Thermanit 22/09 Ø1,0mm M12 (Ar 2%CO <sub>2</sub> )	PulsDrive
Thermanit 22/09 Ø1,2mm M12 (Ar 2%CO <sub>2</sub> )	PulsDrive
FOXcore 316 T0 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
Union AlMg5 Ø1,0mm I1 (Ar)	PulsDrive
Union AlMg5 Ø1,2mm I1 (Ar)	PulsDrive
FOXcore 307 MC Ø1,2mm M12 (Ar 0,5+5%CO <sub>2</sub> )	PulsDrive
FOXcore 625 T1 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive

# MASTER SOFTWARE ALLWELD

<b>PULSED MIG/MAG WELDING PROGRAMS</b> <i>(continued)</i>	
<b>Filler Material</b>	<b>Process</b>
FOXcore 13 4 MC Ø1,2mm M12 (Ar 0,5+5%CO <sub>2</sub> )	PulsDrive
UNION AIMg4,5 Mn Ø1,2mm I3 (Ar 0,5+95%He)	PulsDrive
Thermanit 20 16 SM Ø1,2mm Z (Ar 15%He 2% CO <sub>2</sub> )	PulsDrive
diamondspark 700 MC Ø1,0mm M21 (Ar 15+25% CO <sub>2</sub> )	PulsDrive
diamondspark 700 MC Ø1,2mm M21 (Ar 15+25% CO <sub>2</sub> )	PulsDrive
diamondspark 700 MC Ø1,0mm M20 (Ar 5+15% CO <sub>2</sub> )	PulsDrive
diamondspark 700 MC Ø1,2mm M20 (Ar 5+15% CO <sub>2</sub> )	PulsDrive
diamondspark 900 MC Ø1,0mm M21 (Ar 15+25% CO <sub>2</sub> )	PulsDrive
diamondspark 900 MC Ø1,2mm M21 (Ar 15+25% CO <sub>2</sub> )	PulsDrive
diamondspark 900 MC Ø1,0mm M20 (Ar 5+15% CO <sub>2</sub> )	PulsDrive
diamondspark 900 MC Ø1,2mm M20 (Ar 5+15% CO <sub>2</sub> )	PulsDrive
diamondspark 54 MC Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
diamondspark 52 MC Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
diamondspark 54 MC Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
diamondspark 52 MC Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
Union NiMoCr Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
Union NiMoCr Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
Union NiMoCr Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
Union NiMoCr Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
Union NiMoCr Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
Union NiMoCr Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
BOHLER X 70 IG Ø1,2mm M21 (Ar 15+25% CO <sub>2</sub> )	PulsDrive
Union X 85 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
Union X 85 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
Union X 85 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
Union X 85 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
Union X 85 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
Union X 85 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 8 Ultra Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 8 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 8 Ultra Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 8 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 8 Ultra Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 8 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 8 Ultra Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 8 Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive

# MASTER SOFTWARE ALLWELD

<b>PULSED MIG/MAG WELDING PROGRAMS</b> <i>(continued)</i>	
<b>Filler Material</b>	<b>Process</b>
BOHLER EMK 8 Ultra Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 8 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 8 Ultra Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 8 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 8 Ultra Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 8 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 8 Ultra Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 8 Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
Union X 90 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
Union X 90 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
Union X 90 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
Union X 90 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
Union X 90 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
Union X 90 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
Union X 96 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
Union X 96 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
Union X 96 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
Union X 96 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
Union X 96 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
Union X 96 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
Thermanit ATS 4 Ø1,2mm M12 (Ar 0,5+5%CO <sub>2</sub> )	PulsDrive
Thermanit 22/09 Ø1,2mm Z (Ar 15%He 2%CO <sub>2</sub> )	PulsDrive
Thermanit Nicro 82 Ø1,2mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
Thermanit Nicro 82 Ø1,2mm Z (Ar 30%He 2%H <sub>2</sub> 0,05%CO <sub>2</sub> )	PulsDrive
ECOspark 420 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
ECOspark 460 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
ECOspark 420 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
ECOspark 460 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
ECOspark 420 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
ECOspark 420 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
ECOspark 420 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
ECOspark 460 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
ECOspark 420 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
UTP RB CHROMELESS 600 Ø1,2mm M21 (Ar 15+25% CO <sub>2</sub> )	PulsDrive
G3/4 Si1 (ER70S-6) Ø0,8mm M21 (Ar 15+25% CO <sub>2</sub> )	PulsDrive
G3/4 Si1 (ER70S-6) Ø1,0mm M21 (Ar 15+25% CO <sub>2</sub> )	PulsDrive

# MASTER SOFTWARE ALLWELD

<b>PULSED MIG/MAG WELDING PROGRAMS</b> <i>(continued)</i>	
<b>Filler Material</b>	<b>Process</b>
G3/4 Si1 (ER70S-6) Ø1,2mm M21 (Ar 15+25% CO <sub>2</sub> )	PulsDrive
G3/4 Si1 (ER70S-6) Ø1,6mm M21 (Ar 15+25% CO <sub>2</sub> )	PulsDrive
G3/4 Si1 (ER70S-6) Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
G3/4 Si1 (ER70S-6) Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
G3/4 Si1 (ER70S-6) Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
G3/4 Si1 (ER70S-6) Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	PulsDrive
Hardfacing Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
Hardfacing Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
Hardfacing Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
MFCW Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
MFCW Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
CrNi 13 4 (ER410) Ø1,2mm M12 (Ar 0,5+5%CO <sub>2</sub> )	PulsDrive
CrNi 18 8 (ER307) Ø0,8mm M12 (Ar 0,5+5%CO <sub>2</sub> )	PulsDrive
CrNi 18 8 (ER307) Ø1,0mm M12 (Ar 0,5+5%CO <sub>2</sub> )	PulsDrive
CrNi 18 8 (ER307) Ø1,2mm M12 (Ar 0,5+5%CO <sub>2</sub> )	PulsDrive
CrNi 19 9 (ER308) Ø0,8mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
CrNi 19 9 (ER308) Ø1,0mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
CrNi 19 9 (ER308) Ø1,2mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
CrNi 19 9 (ER308) Ø1,6mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
CrNi 19 12 3 (ER316) Ø0,8mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
CrNi 19 12 3 (ER316) Ø1,0mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
CrNi 19 12 3 (ER316) Ø1,2mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
CrNi 19 12 3 (ER316) Ø1,6mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
CrNi 22 09 (ER2209) Ø1,0mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
CrNi 22 09 (ER2209) Ø1,2mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
CrNi 23 12 (ER309) Ø1,0mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
CrNi 23 12 (ER309) Ø1,2mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
CrNi 25 09 (ER2509) Ø1,2mm Z (Ar 30%He 2% CO <sub>2</sub> )	PulsDrive
CrNi 25 20 (ER310) Ø0,8mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
CrNi 25 20 (ER310) Ø1,0mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
CrNi 25 20 (ER310) Ø1,2mm M12 (Ar 0,5+5% CO <sub>2</sub> )	PulsDrive
CrNb 16 (ER430) Ø1,0mm M12 (Ar 0,5+5%CO <sub>2</sub> )	PulsDrive
CrNi 13 4 FCW (E410) Ø1,2mm M21 (Ar 15+25% CO <sub>2</sub> )	PulsDrive
CrNi 19 9 FCW (E308) Ø1,2mm M21 (Ar 15+25% CO <sub>2</sub> )	PulsDrive
CrNi 19 9 FCW (E308) Ø1,6mm M21 (Ar 15+25% CO <sub>2</sub> )	PulsDrive
CuAl8 (ERCuAl) Ø0,8mm I1 (Ar)	PulsDrive

# MASTER SOFTWARE ALLWELD

<b>PULSED MIG/MAG WELDING PROGRAMS</b> <i>(continued)</i>	
<b>Filler Material</b>	<b>Process</b>
CuAl8 (ERCuAl) Ø1,0mm I1 (Ar)	PulsDrive
CuAl8 (ERCuAl) Ø1,2mm I1 (Ar)	PulsDrive
CuAl8 (ERCuAl) Ø1,6mm I1 (Ar)	PulsDrive
CuSi3 (ERCuSi) Ø0,8mm I1 (Ar)	PulsDrive
CuSi3 (ERCuSi) Ø1,0mm I1 (Ar)	PulsDrive
CuSi3 (ERCuSi) Ø1,2mm I1 (Ar)	PulsDrive
AlMg5 (ER5356) Ø0,8mm I1 (Ar)	PulsDrive
AlMg5 (ER5356) Ø1,0mm I1 (Ar)	PulsDrive
AlMg5 (ER5356) Ø1,2mm I1 (Ar)	PulsDrive
AlMg5 (ER5356) Ø1,6mm I1 (Ar)	PulsDrive
AlSi5 (ER4043) Ø0,8mm I1 (Ar)	PulsDrive
AlSi5 (ER4043) Ø1,0mm I1 (Ar)	PulsDrive
AlSi5 (ER4043) Ø1,2mm I1 (Ar)	PulsDrive
AlSi5 (ER4043) Ø1,6mm I1 (Ar)	PulsDrive
Al99,5 (ER1050) Ø0,8mm I1 (Ar)	PulsDrive
Al99,5 (ER1050) Ø1,0mm I1 (Ar)	PulsDrive
Al99,5 (ER1050) Ø1,2mm I1 (Ar)	PulsDrive
Al99,5 (ER1050) Ø1,6mm I1 (Ar)	PulsDrive
G 69 4 M (ER110S-G) Ø1,0mm M21 (Ar 15+25% CO <sub>2</sub> )	PulsDrive
G 69 4 M (ER110S-G) Ø1,2mm M21 (Ar 15+25% CO <sub>2</sub> )	PulsDrive
G 69 4 M (ER110S-G) Ø0,8mm M20 (Ar 5+15% CO <sub>2</sub> )	PulsDrive
G 69 4 M (ER110S-G) Ø0,8mm M21 (Ar 15+25% CO <sub>2</sub> )	PulsDrive
G 69 4 M (ER110S-G) Ø1,0mm M20 (Ar 5+15% CO <sub>2</sub> )	PulsDrive
G 69 4 M (ER110S-G) Ø1,2mm M20 (Ar 5+15% CO <sub>2</sub> )	PulsDrive
CrNi 18 8 (ER307) Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	PulsDrive
BOHLER EMK 6 Ultra Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
BOHLER Q G4 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 6 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 6 Ultra Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
BOHLER Q G4 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 6 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 6 Ultra Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
BOHLER Q G4 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 6 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 6 Ultra Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
BOHLER Q G4 Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse

# MASTER SOFTWARE ALLWELD

<b>PULSED MIG/MAG WELDING PROGRAMS</b> <i>(continued)</i>	
<b>Filler Material</b>	<b>Process</b>
BOHLER EMK 6 Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 6 Ultra Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
BOHLER Q G4 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 6 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 6 Ultra Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
BOHLER Q G4 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 6 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 6 Ultra Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
BOHLER Q G4 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 6 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 6 Ultra Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
BOHLER Q G4 Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 6 Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
diamondspark 54 MC Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
diamondspark 46 MC Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
diamondspark 52 MC Ø1,0mm M21 (Ar 15+25% CO <sub>2</sub> )	QuickPulse
diamondspark 54 MC Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
diamondspark 46 MC Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
diamondspark 52 MC Ø1,2mm M21 (Ar 15+25% CO <sub>2</sub> )	QuickPulse
Thermanit JE 308L Si Ø0,8mm M12 (Ar 0,5+5% CO <sub>2</sub> )	QuickPulse
Thermanit JE 308L Si Ø1,0mm M12 (Ar 0,5+5% CO <sub>2</sub> )	QuickPulse
Thermanit JE 308L Si Ø1,2mm M12 (Ar 0,5+5% CO <sub>2</sub> )	QuickPulse
Thermanit JE 308L Si Ø1,6mm M12 (Ar 0,5+5% CO <sub>2</sub> )	QuickPulse
Thermanit GE 316L Si Ø0,8mm M12 (Ar 0,5+5% CO <sub>2</sub> )	QuickPulse
Thermanit GE 316L Si Ø1,0mm M12 (Ar 0,5+5% CO <sub>2</sub> )	QuickPulse
Thermanit GE 316L Si Ø1,2mm M12 (Ar 0,5+5% CO <sub>2</sub> )	QuickPulse
Thermanit GE 316L Si Ø1,6mm M12 (Ar 0,5+5% CO <sub>2</sub> )	QuickPulse
Thermanit 309L Si Ø1,0mm M12 (Ar 0,5+5% CO <sub>2</sub> )	QuickPulse
Thermanit 309L Si Ø1,2mm M12 (Ar 0,5+5% CO <sub>2</sub> )	QuickPulse
diamondspark 700 MC Ø1,0mm M21 (Ar 15+25% CO <sub>2</sub> )	QuickPulse
diamondspark 700 MC Ø1,2mm M21 (Ar 15+25% CO <sub>2</sub> )	QuickPulse
diamondspark 700 MC Ø1,0mm M20 (Ar 5+15% CO <sub>2</sub> )	QuickPulse
diamondspark 700 MC Ø1,2mm M20 (Ar 5+15% CO <sub>2</sub> )	QuickPulse
diamondspark 900 MC Ø1,0mm M21 (Ar 15+25% CO <sub>2</sub> )	QuickPulse
diamondspark 900 MC Ø1,2mm M21 (Ar 15+25% CO <sub>2</sub> )	QuickPulse
diamondspark 900 MC Ø1,0mm M20 (Ar 5+15% CO <sub>2</sub> )	QuickPulse

# MASTER SOFTWARE ALLWELD

<b>PULSED MIG/MAG WELDING PROGRAMS</b> <i>(continued)</i>	
<b>Filler Material</b>	<b>Process</b>
diamondspark 900 MC Ø1,2mm M20 (Ar 5+15% CO <sub>2</sub> )	QuickPulse
diamondspark 52 MC Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
diamondspark 52 MC Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
Union NiMoCr Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
Union NiMoCr Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
Union NiMoCr Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
Union NiMoCr Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
Union NiMoCr Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
Union NiMoCr Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
Union X 85 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
Union X 85 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
Union X 85 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
Union X 85 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
Union X 85 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
Union X 85 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 8 Ultra Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 8 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 8 Ultra Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 8 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 8 Ultra Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 8 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 8 Ultra Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 8 Ø1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 8 Ultra Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 8 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 8 Ultra Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 8 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 8 Ultra Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 8 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 8 Ultra Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
BOHLER EMK 8 Ø1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
Union X 90 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
Union X 90 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
Union X 90 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
Union X 90 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
Union X 90 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse

# MASTER SOFTWARE ALLWELD

<b>PULSED MIG/MAG WELDING PROGRAMS</b> <i>(continued)</i>	
<b>Filler Material</b>	<b>Process</b>
Union X 90 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
Union X 96 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
Union X 96 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
Union X 96 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
Union X 96 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
Union X 96 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
Union X 96 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
ECOSpark 460 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
ECOSpark 420 Ø0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
ECOSpark 460 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
ECOSpark 420 Ø1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
ECOSpark 460 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
ECOSpark 420 Ø1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
ECOSpark 420 Ø0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
ECOSpark 460 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
ECOSpark 420 Ø1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
ECOSpark 460 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
ECOSpark 420 Ø1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
G3/4 Si1 (ER70S-6) 0,8mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
G3/4 Si1 (ER70S-6) 1,0mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
G3/4 Si1 (ER70S-6) 1,2mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
G3/4 Si1 (ER70S-6) 1,6mm M21 (Ar 15+25%CO <sub>2</sub> )	QuickPulse
G3/4 Si1 (ER70S-6) 0,8mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
G3/4 Si1 (ER70S-6) 1,0mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
G3/4 Si1 (ER70S-6) 1,2mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
G3/4 Si1 (ER70S-6) 1,6mm M20 (Ar 5+15%CO <sub>2</sub> )	QuickPulse
CrNi 19 9 (ER308) 0,8mm M12 (Ar 0,5+5%CO <sub>2</sub> )	QuickPulse
CrNi 19 9 (ER308) Ø1,0mm M12 (Ar 0,5+5% CO <sub>2</sub> )	QuickPulse
CrNi 19 9 (ER308) Ø1,2mm M12 (Ar 0,5+5% CO <sub>2</sub> )	QuickPulse
CrNi 19 9 (ER308) Ø1,6mm M12 (Ar 0,5+5% CO <sub>2</sub> )	QuickPulse
AlMg5 (ER5356) Ø1,2mm I1 (Ar)	QuickPulse
AlMg5 (ER5356) Ø1,6mm I1 (Ar)	QuickPulse
AlSi5 (ER4043) Ø1,2mm I1 (Ar)	QuickPulse
AlSi5 (ER4043) Ø1,6mm I1 (Ar)	QuickPulse
Al99,5 (ER1050) Ø1,2mm I1 (Ar)	QuickPulse
Al99,5 (ER1050) Ø1,6mm I1 (Ar)	QuickPulse