

SPARTUS® MASTER MIG 250 DUAL PULSE SYNERGY

SYN Parameter			
Program Number	Material	Wire ϕ (mm)	Gas
P1	Fe	0.8	CO ₂
P2	Fe	0.8	80%Ar+20%CO ₂
P3	Fe	0.9	CO ₂
P4	Fe	0.9	80%Ar+20%CO ₂
P5	Fe	1.0	80%Ar+20%CO ₂
P6	Fe	1.0	CO ₂
P7	Fe	1.2	CO ₂
P8	Fe	1.2	80%Ar+20%CO ₂
P9	Flux.c.w Fe	1.0	CO ₂
P10	Flux.c.w Fe	1.2	CO ₂
P11	SS ER316	1.0	98%Ar+2%CO ₂
P12	SS ER316	1.2	98%Ar+2%CO ₂
P13	CuSi3	1.0	Ar100%
P14	CuSi3	1.2	Ar100%
Dual Pulse Parameter			
Program Number	Material	Wire ϕ (mm)	Gas
P1	AlMg5	0.9	Ar100%
P2	AlMg5	1.0	Ar100%
P3	AlMg5	1.2	Ar100%
P4	AlSi5	1.0	Ar100%
P5	AlSi5	1.2	Ar100%
P6	Al99.5	1.2	Ar100%
P7	Fe	0.8	80%Ar+20%CO ₂
P8	Fe	0.9	80%Ar+20%CO ₂
P9	Fe	1.0	80%Ar+20%CO ₂
P10	Fe	1.2	80%Ar+20%CO ₂
P11	SS ER316	1.0	98%Ar+2%CO ₂
P12	SS ER316	1.2	98%Ar+2%CO ₂
P13	Flux.c.w Fe	1.2	80%Ar+20%CO ₂
P14	Flux.c.w SS	1.2	80%Ar+20%CO ₂
P15	Flux.c.w SS	1.0	Ar100%
P16	CuSi3	1.2	Ar100%
P17	CuAl8	1.2	Ar100%

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Display	Function
PrG	PRE GAS
PoG	POST GAS
SFt	SLOW FEED TIME
bub	BURN BACK
SPt	SPOT WELD TIME
dPC	DELTA PULSE CURRENT
FdP	DUAL PULSE FREQUENCY
dut	DUAL PULSE DUTY
bAL	DUAL PULSE BASE CURRENT ARC LENGTH
SCP	START CURRENT PERCENT
SAL	START CURRENT ARC LENGTH
ECP	END CURRENT PERCENT
EAL	END CURRENT ARC LENGTH
HdC	HYDROCOOLING
SPG	SPOOL GUN
HSt	HOT START
ACF	ARC FORCE
dSL	DOWN SLOPE