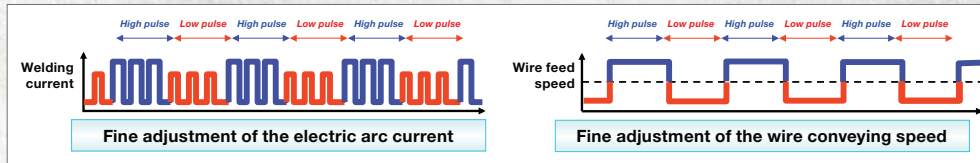




Extended working range due to the AC/DC Wave Pulse function (0.5–32 Hz)

AC/MIG welding process



The new wave pulse function regularly regulates the Welding current control and the wire feed speed control, and it also controls the weld pool.

Advantages of the Wave-Pulse function

1. Reduction of gas bubbles
2. Optimized gap bridgeability
3. A seam scaling similar to TIG welding can be produced

Reduction of pores

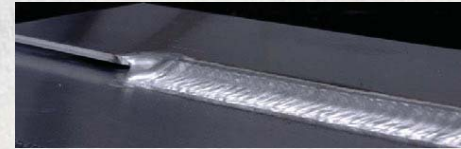


With galvanized steel, which has a tendency to build blow holes, with the Wave-Pulse-function, it is possible to decrease number and size of blow holes.

| | |
|------------------------|-----------|
| Welding current: | 200 A |
| Welding voltage: | 25 V |
| Electroplating Sheet: | 9 mm |
| Welding wire diameter: | Ø 1.2 mm |
| Welding speed: | 30 cm/min |
| Oscillation frequency: | 3 Hz |

Air gap bridging and excellent seam appearance

In addition, a seam appearance similar to TIG welding can be produced using the OTC Wave Pulse function.



| | |
|------------------------|-----------|
| Welding current: | 120 A |
| Welding voltage: | 16 V |
| Sheet thickness: | 3,00 mm |
| Welding wire diameter: | Ø 1.2 mm |
| Welding speed: | 50 cm/min |
| Oscillation frequency: | 2.5 Hz |

Advantages

- Low pore formation
- Excellent air gap bridging
- Controlled heat input
- TIG-like seam appearance
- Reduction of gas bubbles

| | |
|------------------------|-----------|
| Welding current: | 85 A |
| Welding voltage: | 17 V |
| Sheet thickness: | 2.0 mm |
| Welding wire diameter: | 1.2 mm |
| Welding speed: | 50 cm/min |
| Oscillation frequency: | 3 Hz |

An excellent air gap bridging is to be achieved through the controlled heat input.

| Gap pace | Normal Pulse | | Wave Pulse | |
|----------|----------------------|---------------|----------------------|---------------|
| | Weld seam appearance | Cross-section | Weld seam appearance | Cross-section |
| 0.5 mm | | | | |
| 1.5 mm | | | | |
| 2.0 mm | | | | |