

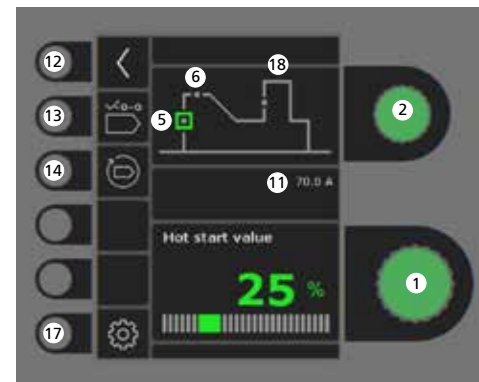
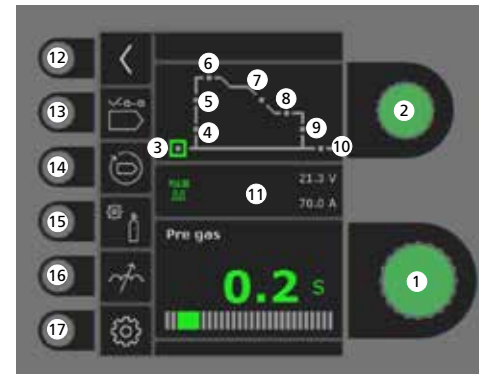
Betriebsanzeige MIG/MMA



1. **Einstellung des Schweißstroms**
2. **Anzeige des Schweißstroms**
3. **Anzeige der Drahtfördergeschwindigkeit (m/min)**
4. **Anzeige des Strom-/Transfer-Modus:**
 - Kurzbogen
 - Mischbogen (Risiko für Schweißspritzer)
 - Spraybogen
5. **Anzeige der Materialstärke**

6. **Anzeige der Lichtbogenlänge/ Form der Schweißnaht**
7. **Einstellung der Schweißspannung**
Die gewünschte Schweißspannung mittels des Drehknopfs einstellen.
8. **Anzeige der Schweißspannung**
9. **Anzeige +/- Spannungstrimm**
10. **Anzeige des gewählten Programms**
11. **Heftschweißen**
Wenn die Funktion aktiv ist, sind Hotstart, Stromabsenkung und DUO PLUS™ ausgeschaltet.
12. **Puls**
MIG-Pulsschweißen ein/aus. (nicht alle Ausführungen)
13. **Wahl der Funktion Ein/Aus**
 - Aus
 - DUO Plus™
Pulsierender Draht in Verbindung mit synergischem MIG.
 - Punktschweißen
Schweißen in der definierten Punktschweißzeit
14. **Trigger-Modus**
Wechseln Sie zwischen 2-Takt (Indikator aus) und 4-Takt (Indikator ein).
2-Takt: Der Schweißvorgang beginnt, wenn der Trigger gedrückt wird und endet, wenn er losgelassen wird.
4-Takt: Der Schweißvorgang beginnt, wenn der Trigger gedrückt und losgelassen wird. Der Schweißvorgang endet, wenn der Trigger wiederum gedrückt wird.
15. **Speicherfunktion**
5 bevorzugte Einstellungen
16. **Menü**

Einstellung des MIG/MMA Schweißvorgangs -Prozessaufbau



1. **Einstellung der Parameter**
Den gewählten Wert mittels des Drehknopfs einstellen.
2. **Wahl der Sekundärparameter**
Die Parameter mittels des Drehknopfs wählen.
3. **Vorgas (Sek.)**
4. **Softstart (m/min)**

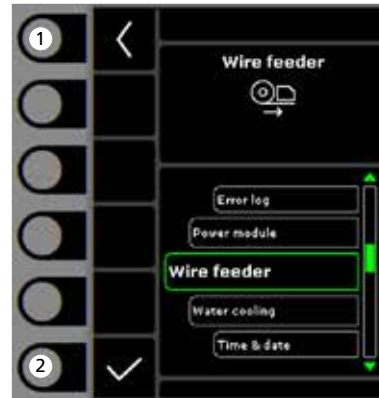
5. **Hotstart (%)**
6. **Hotstartzeit (Sek.)**
7. **Stromabsenkung (Sek.)**
8. **Stopstromzeit (Sek.)**
9. **Stopstrom (%)**
10. **Nachgas (Sek.)**
11. **Eingestellter Strom / Prozess / eingestellte Spannung**
12. **Zurück**
Zurück zum Menü.
13. **Programmwahl**
Material - Drahtdurchmesser - Gas.
14. **Zurücksetzung auf werkseitige Einstellung**
Das gewählte Programm auf werkseitige Einstellung zurücksetzen.
15. **Gas**
 - Gas-/IGC-Einstellung (nicht alle Ausführungen)
 - Gastest
 - Kalibrierung von IGC (nicht alle Ausführungen)
16. **Drossel**
17. **Maschinen-Setup**
 - Brenner
 - Service
 - Sprache
 - Über
18. **Arc Power (%)**

Menü - Brenner



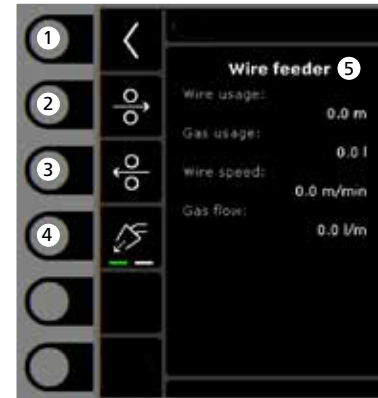
- 1. Home/zurück**
Zurück zur Betriebsanzeige.
- 2. Trigger-Modus**
2-Takt/4-Takt Trigger Modus.
- 3. Wahl des Brennertyps**
Brennertyp.

Menü - Service



- 1. Home/zurück**
Zurück zur Betriebsanzeige.
- 2. Wahl des Menüs**
 - Fehlerliste
 - Powermodul
 - DV-Einheit
 - Wasserkühlung
 - Uhrzeit & Datum
 - Zurücksetzen auf Werkseinstellungen

Menü - DV-Einheit



- 1. Home/zurück**
Zurück zur Betriebsanzeige.
- 2. Drahtförderung vorwärts**
- 3. Drahtförderung zurück**
- 4. Gastest**
- 5. Anzeige der DV-Einheit-Information**



SIGMA ONE PROGRAM TABLE

| Material | Diameter | Gas specification | | Polarity | Program no. | Item number | PROGRAM PACKAGE | | | | | PROCESS | | |
|----------------|------------------------------------|------------------------------------|-------------------|----------|-------------|-------------|-------------------|---------------------|--------------------------|--------------------|-----------------------|---------|-------|---|
| | | | | | | | Standard 10681000 | Mild steel 10681001 | Stainless steel 10681002 | Aluminium 10681003 | All included 10681099 | DC | Pulse | |
| MMA | | - | - | + | 001 | Included | x | | | | x | x | | |
| Manual MIG/MAG | | CO ₂ | 100 | + | 002 | Included | x | | | | x | x | | |
| Manual MIG/MAG | | ArCO ₂ | 82/18 | + | 003 | Included | x | | | | x | x | | |
| ArcGouging | | - | - | + | 004 | 10680004 | | x | x | | x | x | | |
| Fe SG2 ER70S6 | ø 0.6 mm | CO ₂ | 100 | + | 106 | 10680106 | x | | | | x | x | | |
| | | ArCO ₂ | 82/18 | + | 116 | 10680116 | x | | | | x | x | x | |
| | | ArCO ₂ O ₂ | 90/5/5 | + | 128 | 10680128 | | x | | | | x | x | |
| | ø 0.8 mm | CO ₂ | 100 | + | 101 | 10680101 | x | | | | x | x | | |
| | | ArCO ₂ | 82/18 | + | 111 | 10680111 | x | | | | x | x | x | |
| | | ArCO ₂ | 92/8 | + | 130 | 10680130 | x | | | | x | x | x | |
| | | ArCO ₂ | 95/5 | + | 141 | 10680141 | x | | | | x | x | x | |
| | | ArHeCO ₂ O ₂ | 91/4/2/3 | + | 125 | 10680125 | | x | | | | x | x | x |
| | | ArO ₂ | 92/8 | + | 185 | 10680185 | | x | | | | x | x | |
| | ø 0.9 mm | ArCO ₂ O ₂ | 90/5/5 | + | 121 | 10680121 | | x | | | | x | x | x |
| | | CO ₂ | 100 | + | 109 | 10680109 | x | | | | | x | x | |
| | | ArCO ₂ | 82/18 | + | 119 | 10680119 | x | | | | | x | x | x |
| | ø 1.0 mm | ArCO ₂ | 92/8 | + | 120 | 10680120 | x | | | | | x | x | x |
| | | CO ₂ | 100 | + | 102 | 10680102 | x | | | | | x | x | |
| | | ArCO ₂ | 82/18 | + | 112 | 10680112 | x | | | | | x | x | x |
| | | ArCO ₂ | 98/2 | + | 131 | 10680131 | | x | | | | x | x | x |
| | | ArCO ₂ | 92/8 | + | 115 | 10680115 | x | | | | | x | x | x |
| | | ArCO ₂ | 95/5 | + | 142 | 10680142 | x | | | | | x | x | x |
| | | ArCO ₂ O ₂ | 90/5/5 | + | 122 | 10680122 | | | x | | | x | x | x |
| | | ArCO ₂ O ₂ | 90.5/7/2.5 | + | 134 | 10680134 | | | x | | | x | x | x |
| | | ArCO ₂ O ₂ | 82.5/15/2.5 | + | 136 | 10680136 | | | x | | | x | x | x |
| | | ArHeCO ₂ | 68/20/12 | + | 138 | 10680138 | | | x | | | x | x | x |
| | | ArHeCO ₂ O ₂ | 91/4/2/3 | + | 126 | 10680126 | | | x | | | x | x | x |
| | | ø 1.2 mm | ArO ₂ | 97/3 | + | 132 | 10680132 | | | x | | | x | x |
| | ArO ₂ | | 92/8 | + | 176 | 10680176 | | | x | | | x | x | |
| | CO ₂ | | 100 | + | 103 | 10680103 | x | | | | | x | x | |
| | ArCO ₂ | | 82/18 | + | 113 | 10680113 | x | | | | | x | x | x |
| | ArCO ₂ | | 92/8 | + | 118 | 10680118 | x | | | | | x | x | x |
| | ArCO ₂ | | 95/5 | + | 143 | 10680143 | x | | | | | x | x | x |
| | ArCO ₂ O ₂ | | 90/5/5 | + | 123 | 10680123 | | | x | | | x | x | x |
| | ArCO ₂ O ₂ | | 90.5/7/2.5 | + | 135 | 10680135 | | | x | | | x | x | x |
| | ArCO ₂ O ₂ | | 82.5/15/2.5 | + | 137 | 10680137 | | | x | | | x | x | x |
| | ArHeCO ₂ | | 68/20/12 | + | 139 | 10680139 | | | x | | | x | x | x |
| | ArHeCO ₂ O ₂ | | 91/4/2/3 | + | 127 | 10680127 | | | x | | | x | x | x |
| | ø 1.4 mm | | ArO ₂ | 97/3 | + | 133 | 10680133 | | | x | | | x | x |
| | | ArO ₂ | 92/8 | + | 180 | 10680180 | | | x | | | x | x | |
| | | CO ₂ | 100 | + | 104 | 10680104 | x | | | | | x | x | |
| | | ArCO ₂ | 82/18 | + | 124 | 10680124 | x | | | | | x | x | x |
| | | ArCO ₂ | 92/8 | + | 129 | 10680129 | x | | | | | x | x | |
| | | CO ₂ | 100 | + | 104 | 10680104 | x | | | | | x | x | |
| | | ArCO ₂ | 82/18 | + | 114 | 10680114 | x | | | | | x | x | x |
| | | ArCO ₂ | 92/8 | + | 117 | 10680117 | x | | | | | x | x | x |
| Innershield | | ø 0.9 mm | - | - | - | 199 | 10680199 | x | | | | x | x | |
| | | ø 1.2 mm | - | - | - | 193 | 10680193 | x | | | | x | x | |
| | | ø 1.6 mm | - | - | - | 194 | 10680194 | x | | | | x | x | |
| ER 308 LSi | | ø 0.8 mm | ArCO ₂ | 98/2 | + | 221 | 10680221 | x | | | | x | x | x |
| | ArCO ₂ H ₂ | | 96/3/1 | + | 226 | 10680226 | | | x | | | x | x | x |
| | ArCO ₂ | | 98/2 | + | 222 | 10680222 | x | | | | | x | x | x |
| | ø 1.0 mm | ArO ₂ | 98/2 | + | 220 | 10680220 | x | | | | | x | x | x |
| | | ArCO ₂ H ₂ | 96/3/1 | + | 227 | 10680227 | | | x | | | x | x | x |
| | | ArCO ₂ | 98/2 | + | 223 | 10680223 | x | | | | | x | x | x |
| ø 1.2 mm | ArCO ₂ H ₂ | 96/3/1 | + | 228 | 10680228 | | | x | | | x | x | x | |
| | ArCO ₂ | 98/2 | + | 224 | 10680224 | x | | | | | x | x | x | |
| | ArCO ₂ H ₂ | 96/3/1 | + | 230 | 10680230 | | | x | | | x | x | x | |
| ER 309 LSi | ø 0.9 mm | ArCO ₂ | 98/2 | + | 231 | 10680231 | x | | | | | x | x | x |
| | | ArCO ₂ | 98/2 | + | 225 | 10680225 | x | | | | | x | x | x |
| | | ArO ₂ | 98/2 | + | 232 | 10680232 | x | | | | | x | x | x |
| | ø 1.0 mm | ArCO ₂ H ₂ | 96/3/1 | + | 229 | 10680229 | | | x | | | x | x | x |
| | | ArCO ₂ | 98/2 | + | 201 | 10680201 | x | | | | | x | x | x |
| | | ArCO ₂ | 98/2 | + | 209 | 10680209 | x | | | | | x | x | x |
| ER 316 LSi | ø 1.0 mm | ArCO ₂ | 98/2 | + | 202 | 10680202 | x | | | | | x | x | x |
| | | ArO ₂ | 97/3 | + | 212 | 10680212 | | | x | | | x | x | x |
| | | ArHeCO ₂ | 68/30/2 | + | 237 | 10680237 | | | x | | | x | x | x |
| | ø 1.2 mm | ArCO ₂ | 98/2 | + | 203 | 10680203 | x | | | | | x | x | x |
| | | ArO ₂ | 97/3 | + | 213 | 10680213 | | | x | | | x | x | x |
| | | ArHeCO ₂ | 68/30/2 | + | 238 | 10680238 | | | x | | | x | x | x |
| ER 347 Si | ø 1.6 mm | ArCO ₂ | 98/2 | + | 204 | 10680204 | x | | | | | x | x | x |
| | | ArHeCO ₂ | 68/30/2 | + | 242 | 10680242 | | | x | | | x | x | x |
| | | ArHeCO ₂ | 68/30/2 | + | 243 | 10680243 | | | x | | | x | x | x |
| Duplex 2205 | ø 1.0 mm | ArHeCO ₂ | 83/15/2 | + | 252 | 10680252 | | | x | | | x | x | x |
| | | ArO ₂ | 98/2 | + | 254 | 10680254 | | | x | | | x | x | x |
| | ø 1.2 mm | ArHeCO ₂ | 83/15/2 | + | 253 | 10680253 | | | x | | | x | x | x |
| | | ArO ₂ | 98/2 | + | 255 | 10680255 | | | x | | | x | x | x |
| CrNi Zecor | ø 1.2 mm | ArCO ₂ | 98/2 | + | 273 | 10680273 | | | x | | | x | x | x |



| Material | Diameter | Gas specification | | Polarity | Program no. | Item number | PROGRAM PACKAGE | | | | | PROCESS | |
|-----------------------------|----------|---------------------|---------------------|----------|-------------|-------------|-------------------|---------------------|--------------------------|--------------------|-----------------------|---------|-------|
| | | | | | | | Standard 10681000 | Mild steel 10681001 | Stainless steel 10681002 | Aluminium 10681003 | All included 10681099 | DC | Pulse |
| Super Duplex 2507 | ø 0.8 mm | ArO ₂ | 98/2 | + | 266 | 10680266 | | | x | | x | x | x |
| | | ArCO ₂ | 98/2 | + | 262 | 10680262 | | | x | | x | x | x |
| | ø 1.0 mm | ArHeCO ₂ | 83/15/2 | + | 256 | 10680256 | | | x | | x | x | x |
| | | | 68/30/2 | + | 274 | 10680274 | | | x | | x | x | x |
| | | ArHeO ₂ | 69/30/1 | + | 267 | 10680267 | | | x | | x | x | x |
| | | | ArO ₂ | 98/2 | + | 264 | 10680264 | | | x | | x | x |
| | ø 1.2 mm | ArCO ₂ | 98/2 | + | 263 | 10680263 | | | x | | x | x | x |
| | | | ArHeCO ₂ | 83/15/2 | + | 257 | 10680257 | | | x | | x | x |
| | | ArO ₂ | 68/30/2 | + | 275 | 10680275 | | | x | | x | x | x |
| | | | 98/2 | + | 265 | 10680265 | | | x | | x | x | x |
| 253 MA | ø 1.0 mm | Ar | 100 | + | 290 | 10680290 | | | x | | x | x | x |
| | ø 1.2 mm | Ar | 100 | + | 291 | 10680291 | | | x | | x | x | x |
| AlMg5 ER5356 | ø 0.8 mm | Ar | 100 | + | 311 | 10680311 | x | | | | x | x | x |
| | ø 0.9 mm | Ar | 100 | + | 319 | 10680319 | x | | | | x | x | x |
| | | Ar | 100 | + | 312 | 10680312 | x | | | | x | x | x |
| | ø 1.0 mm | ArHe | 70/30 | + | 316 | 10680316 | | | | x | x | x | x |
| | | | 50/50 | + | 332 | 10680332 | | | | x | x | x | x |
| | ø 1.2 mm | ArHe | 100 | + | 313 | 10680313 | x | | | | x | x | x |
| | | | 70/30 | + | 317 | 10680317 | | | | x | x | x | x |
| | ø 1.6 mm | Ar | 50/50 | + | 333 | 10680333 | | | | x | x | x | x |
| | | | 100 | + | 314 | 10680314 | x | | | | x | x | x |
| | | ArHe | 70/30 | + | 318 | 10680318 | | | | x | x | x | x |
| 25/75 | | | + | 336 | 10680336 | | | | x | x | x | x | |
| ø 1.2 mm | ArHe | 25/75 | + | 337 | 10680337 | | | | x | x | x | x | |
| | | 100 | + | 321 | 10680321 | | | | x | x | x | x | |
| AlMg4.5MnZr ER5087 | ø 1.2 mm | Ar | 100 | + | 321 | 10680321 | | | | x | x | x | x |
| AlMg4.5Mn ER5183 | ø 1.2 mm | ArHe | 20/80 | + | 323 | 10680323 | | | | x | x | x | x |
| | | Ar | 100 | + | 325 | 10680325 | | | | x | x | x | x |
| AlMg2.7Mn ER5554 | ø 1.6 mm | ArHe | 70/30 | + | 328 | 10680328 | | | | x | x | x | x |
| | ø 0.9 mm | Ar | 100 | + | 369 | 10680369 | | | | x | x | x | x |
| | ø 1.0 mm | Ar | 100 | + | 367 | 10680367 | | | | x | x | x | x |
| AlSi5 ER4043 | ø 0.9 mm | Ar | 100 | + | 359 | 10680359 | x | | | | x | x | x |
| | | | 100 | + | 352 | 10680352 | x | | | | x | x | x |
| | ø 1.0 mm | ArHe | 70/30 | + | 356 | 10680356 | | | | x | x | x | x |
| | | | 100 | + | 353 | 10680353 | x | | | | x | x | x |
| | ø 1.2 mm | ArHe | 70/30 | + | 357 | 10680357 | | | | x | x | x | x |
| | | | 100 | + | 354 | 10680354 | x | | | | x | x | x |
| ø 1.6 mm | ArHe | 70/30 | + | 358 | 10680358 | | | | x | x | x | x | |
| | | 100 | + | 363 | 10680363 | | | | x | x | x | x | |
| AlI99.5 ER1100 | ø 1.2 mm | Ar | 100 | + | 363 | 10680363 | | | | x | x | x | x |
| AlSi12 ER4047 | ø 1.6 mm | Ar | 100 | + | 364 | 10680364 | | | | x | x | x | x |
| | ø 1.0 mm | Ar | 100 | + | 372 | 10680372 | x | | | | x | x | x |
| AlSi10 MG ER4046 | ø 1.2 mm | ArHe | 50/50 | + | 383 | 10680383 | | | | x | x | x | x |
| | | | 100 | + | 393 | 10680393 | | | | x | x | x | x |
| FCW FeRutil 215 | ø 1.0 mm | ArCO ₂ | 82/18 | + | 402 | 10680402 | x | | | | x | x | |
| | ø 1.2 mm | ArCO ₂ | 82/18 | + | 403 | 10680403 | x | | | | x | x | |
| | ø 1.6 mm | ArCO ₂ | 82/18 | + | 404 | 10680404 | x | | | | x | x | |
| CO ₂ | | 100 | + | 444 | 10680444 | x | | | | x | x | | |
| FCW FeRutil 217 | ø 1.2 mm | ArCO ₂ | 82/18 | + | 453 | 10680453 | x | | | | x | x | |
| FCW FeRutil 713R | ø 1.2 mm | ArCO ₂ | 82/18 | + | 454 | 10680454 | | x | | | x | x | |
| FCW FeRutil 15.14 | ø 1.2 mm | CO ₂ | 100 | + | 443 | 10680443 | | x | | | x | x | |
| FCW FeRutil Nittetsu SF-1A | ø 1.2 mm | ArCO ₂ | 82/18 | + | 407 | 10680407 | | x | | | x | x | |
| FCW FeRutil Nittetsu SF-1E | ø 1.2 mm | CO ₂ | 100 | + | 448 | 10680448 | | x | | | x | x | |
| FCW FeRutil Nittetsu SF-3AM | ø 1.2 mm | ArCO ₂ | 82/18 | + | 408 | 10680408 | | x | | | x | x | |
| FCW FeRutil PZ6111 | ø 1.4 mm | ArCO ₂ | 82/18 | + | 409 | 10680409 | | x | | | x | x | |
| FCW FeRutil PZ6111-HS | ø 1.6 mm | ArCO ₂ | 82/18 | + | 405 | 10680405 | | x | | | x | x | |
| FCW FeRutil 6114 | ø 1.6 mm | CO ₂ | 100 | + | 446 | 10680446 | | x | | | x | x | |
| FCW FeRutil 6114 | ø 1.2 mm | ArCO ₂ | 82/18 | + | 458 | 10680458 | | x | | | x | x | |
| FCW FeRutil PZ6114S | ø 1.2 mm | CO ₂ | 100 | + | 447 | 10680447 | | x | | | x | x | |
| FCW FeRutil PZ6138 | ø 1.2 mm | ArCO ₂ | 82/18 | + | 457 | 10680457 | | x | | | x | x | |
| FCW FeRutil DWA 55E | ø 1.2 mm | ArCO ₂ | 82/18 | + | 451 | 10680451 | | x | | | x | x | |
| FCW FeRutil Tubrod 15.14 | ø 1.2 mm | ArCO ₂ | 82/18 | + | 452 | 10680452 | | x | | | x | x | |
| FCW FeMetal PZ6104 | ø 1.2 mm | CO ₂ | 100 | + | 495 | 10680495 | | x | | | x | x | |
| FCW FeMetal MX 100T | ø 1.2 mm | ArCO ₂ | 82/18 | + | 456 | 10680456 | | x | | | x | x | |
| FCW FeMetal 115 | ø 1.2 mm | ArCO ₂ | 82/18 | + | 429 | 10680429 | | x | | | x | x | |
| | ø 1.2 mm | ArCO ₂ | 82/18 | + | 423 | 10680423 | x | | | | x | x | x |
| | ø 1.4 mm | ArCO ₂ | 82/18 | + | 425 | 10680425 | x | | | | x | x | |
| | ø 1.6 mm | ArCO ₂ | 82/18 | + | 424 | 10680424 | x | | | | x | x | |
| CO ₂ | | 100 | + | 445 | 10680445 | x | | | | x | x | | |
| FCW FeMetal 235M | ø 1.2 mm | ArCO ₂ | 82/18 | + | 420 | 10680420 | | x | | | x | x | x |
| FCW FeMetal 710M/742M | ø 1.0 mm | ArCO ₂ | 82/18 | + | 426 | 10680426 | | x | | | x | x | |
| FCW FeMetal 710M | ø 1.2 mm | ArCO ₂ | 82/18 | + | 427 | 10680427 | | x | | | x | x | |
| FCW FeMetal 742M | ø 1.2 mm | ArCO ₂ | 82/18 | + | 428 | 10680428 | | x | | | x | x | |
| FCW FeMetal MC-R5 | ø 1.2 mm | ArCO ₂ | 82/18 | + | 418 | 10680418 | | x | | | x | x | |
| FCW FeMetal 700 T-MC | ø 1.2 mm | ArCO ₂ | 92/8 | + | 461 | 10680461 | | x | | | x | x | x |
| FCW FeMetal HL 51-MC | ø 1.0 mm | ArCO ₂ | 92/8 | + | 462 | 10680462 | | x | | | x | x | x |
| | ø 1.2 mm | ArCO ₂ | 92/8 | + | 463 | 10680463 | | x | | | x | x | x |



| Material | Diameter | Gas specification | | Polarity | Program no. | Item number | PROGRAM PACKAGE | | | | | PROCESS | |
|------------------------|----------|---------------------|------------|----------|-------------|-------------|-------------------|---------------------|--------------------------|--------------------|-----------------------|---------|-------|
| | | | | | | | Standard 10681000 | Mild steel 10681001 | Stainless steel 10681002 | Aluminium 10681003 | All included 10681099 | DC | Pulse |
| FCW FeMetal 700MC | ø 1.0 mm | ArCO ₂ | 92/8 | + | 464 | 10680464 | | x | | | x | x | x |
| | ø 1.2 mm | ArCO ₂ | 92/8 | + | 465 | 10680465 | | x | | | x | x | x |
| FCW FeBasic 515 | ø 1.2 mm | ArCO ₂ | 82/18 | - | 413 | 10680413 | | x | | | x | x | |
| FCW FeBasic 6130 | ø 1.4 mm | CO ₂ | 100 | +/- | 435 | 10680435 | | x | | | x | x | |
| | | ArCO ₂ | 82/18 | +/- | 415 | 10680415 | | x | | | x | x | |
| FCW FeBasic 6125 | ø 1.0 mm | ArCO ₂ | 82/18 | - | 417 | 10680417 | | x | | | x | x | |
| FCW FeBasic 15.00 | ø 1.4 mm | CO ₂ | 100 | +/- | 433 | 10680433 | | x | | | x | x | |
| FCW FeCr | ø 1.6 mm | ArCO ₂ | 82/18 | + | 474 | 10680474 | | x | | | x | x | |
| FCW CrNi 309/316L | ø 1.2 mm | ArCO ₂ | 82/18 | + | 483 | 10680483 | | | x | | x | x | |
| FCW 2205 | ø 1.2 mm | ArCO ₂ | 82/18 | + | 484 | 10680484 | | | x | | x | x | |
| FCW 2507 | ø 1.2 mm | ArCO ₂ | 82/18 | + | 485 | 10680485 | | | x | | x | x | |
| FCW CrNi 15.31 | ø 1.2 mm | ArO ₂ | 98/2 | + | 486 | 10680486 | | | x | | x | x | x |
| FCW CrNi 309 | ø 1.2 mm | CO ₂ | 100 | + | 493 | 10680493 | x | | | | x | x | |
| FCW CrNi 316L | ø 1.2 mm | CO ₂ | 100 | + | 494 | 10680494 | x | | | | x | x | |
| CuAl8 Brazing | ø 0.8 mm | Ar | 100 | + | 501 | 10680501 | | x | | | x | x | x |
| | ø 0.9 mm | Ar | 100 | + | 509 | 10680509 | | x | | | x | x | x |
| | ø 1.0 mm | Ar | 100 | + | 502 | 10680502 | | x | | | x | x | x |
| CuAl8 Welding | ø 0.8 mm | Ar | 100 | + | 571 | 10680571 | | x | | | x | | x |
| | ø 1.0 mm | Ar | 100 | + | 572 | 10680572 | | x | | | x | | x |
| | ø 1.2 mm | Ar | 100 | + | 573 | 10680573 | | x | | | x | | x |
| CuSn Brazing | ø 1.2 mm | Ar | 100 | + | 523 | 10680523 | | x | | | x | | x |
| AlBz9Fe Welding | ø 1.6 mm | Ar | 100 | + | 554 | 10680554 | | x | | | x | x | |
| CuSi3 Brazing | ø 0.8 mm | Ar | 100 | + | 561 | 10680561 | | x | | | x | x | x |
| | ø 0.9 mm | Ar | 100 | + | 569 | 10680569 | | x | | | x | x | x |
| | ø 1.0 mm | Ar | 100 | + | 562 | 10680562 | | x | | | x | x | x |
| | | ArCO ₂ | 92/8 | + | 567 | 10680567 | | x | | | x | x | x |
| Inconel 625 | ø 1.0 mm | Ar | 100 | + | 587 | 10680587 | | | x | | x | x | x |
| | ø 1.2 mm | Ar | 100 | + | 588 | 10680588 | | | x | | x | x | x |
| | | ArHe | 85/15 | + | 583 | 10680583 | | | x | | x | x | x |
| ø 1.6 mm | ArHe | 85/15 | + | 584 | 10680584 | | | x | | x | x | x | |
| Inconel 718 | ø 1.2 mm | ArHeCO ₂ | 95.8/4/0.2 | + | 591 | 10680591 | | | x | | x | x | x |
| Inconel 825 | ø 1.2 mm | ArHeCO ₂ | 81/18/1 | + | 590 | 10680590 | | | x | | x | x | x |
| Inconel 82 / Monel 400 | ø 1.2 mm | Ar | 100 | + | 589 | 10680589 | | | x | | x | x | x |
| FCW Inconel 625-PW | ø 1.2 mm | ArCO ₂ | 82/18 | + | 593 | 10680593 | | | x | | x | x | |
| UTP A 8051Ti | ø 1.2 mm | ArCO ₂ | 98/2 | + | 595 | 10680595 | | | x | | x | | x |
| SMO | ø 1.0 mm | ArHeCO ₂ | 68/30/2 | + | 596 | 10680596 | | | x | | x | x | x |
| | ø 1.2 mm | ArHeCO ₂ | 68/30/2 | + | 597 | 10680597 | | | x | | x | x | x |
| Titanium Gr.2 | ø 1.6 mm | ArHe | 70/30 | + | 704 | 10680704 | | | x | | x | | x |

Note: the number of available programs may vary from your machine, as it depends on date of purchase.
Please contact your Migatronik dealer for purchase of new licenses.