




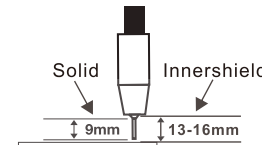
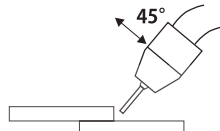
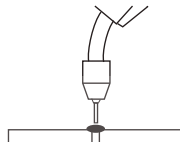
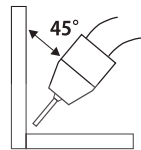
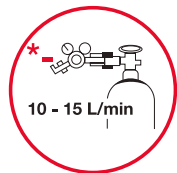
**Suggested settings for welding with POWERCRAFT® 200M**

Material Thickness	STEEL						STAINLESS				STEEL			4043 ALSI	5356 ALMG	
	 DC(+)											 DC(-)			DC(+)	
	<b>Solid</b>						<b>Cored</b>									
	80% Argon 20% CO <sub>2</sub>				100% Co <sub>2</sub>		98% Argon 2% CO <sub>2</sub>			No Gas For Innershield Wires			100% Argon			
	0.6mm	0.8mm	0.9mm	1.0mm	0.8mm	0.9mm	1.0mm	0.8mm	0.9mm	1.0mm	0.8mm	0.9mm	1.0mm	1.0mm	1.0mm	
	⊙										v					
0.8mm	14.0 5.5	14.5 3.0	N\A	N\A	N\A	N\A	N\A	N\A	N\A	N\A	N\A	N\A	N\A	N\A	N\A	
1.0mm	14.8 6.7	15.0 3.6	14.3 2.9	N\A	16.0 3.4	17.0 3.5	N\A	14.2 4.6	N\A	N\A	15.0 5.1	17.4 5.0	N\A	N\A	N\A	
1.2mm	15.3 8.1	15.6 4.4	14.8 3.7	14.0 2.4	16.5 3.8	17.7 4.1	16.5 3.0	15.7 6.3	15.1 4.8	15.1 4.1	15.3 6.0	17.9 5.8	17.3 4.8	N\A	16.4 7.0	
1.6mm	17.0 9.5	16.3 5.1	16.4 4.3	14.2 2.7	17.3 4.8	18.6 4.6	17.0 3.4	16.7 8.3	16.0 5.8	16.1 5.0	17.3 7.4	18.6 7.0	17.5 5.3	17.0 7.0	17.6 9.0	
2.0mm	18.5 11.0	16.8 5.5	16.8 4.9	14.5 3.3	18.1 6.0	19.0 5.1	17.2 3.7	17.4 9.4	17.2 7.0	16.7 5.9	19.5 8.7	19.2 8.1	18.0 6.1	17.4 8.3	18.4 11.0	
3.0mm	20.0 14.0	18.0 6.8	19.0 6.8	15.8 4.3	18.8 6.8	19.8 6.3	17.9 4.5	18.6 12.5	18.8 9.7	18.3 8.2	21.5 12.0	21.9 10.7	19.0 7.6	19.3 10.3	19.8 15.0	
5.0mm	N\A	19.5 10.0	21.8 9.5	18.4 6.3	20.4 9.3	22.2 9.2	20.8 6.7	N\A	N\A	22.2 12.6	N\A	24.4 14.2	22.4 11.2	23.0 13.0	21.0 16.0	
6.0mm	N\A	20.5 12.5	22.4 10.8	20.5 7.7	23.4 14.0	24.1 11.1	23.5 8.3	N\A	N\A	23.7 14.2	N\A	N\A	N\A	N\A	N\A	
8.0mm	N\A	23.8 15.3	26.8 12.8	24.5 11.0	24.5 15.8	N\A	26.5 10.4	N\A	N\A	N\A	N\A	N\A	N\A	N\A	N\A	

N\A=Not applicable

**CONSUMABLE PARTS**

LINC Gun LG150C	Part No	Wire Type	DRIVE ROLLS	Part No
Contact Tip M6 0.6mm	KP10440-06	Wire Type	Size	Part No
Contact Tip M6 0.8mm	KP10440-08	Solid	0.6/0.8mm	KP69024-0608
Contact Tip M6 0.9mm	KP10440-09	Solid	0.8/0.9mm	KP69024-0809
Contact Tip M6 1.2mm	KP10440-12	Solid	0.8/1.0mm	KP69024-0810
Liner 0.8-1.0mm 4M	KP10413-4M	Core	0.9/1.2mm	KP69024-0912R
Nozzle 12mm	KP10461-1	Aluminum	0.9/1.2mm	KP69024-0912A
Nozzle Support Spring	KP10400-1			



**WELDING TECHNOLOGY**  
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