

Synergia			
NR PROGRAMU	MATERIAŁ	DRUT Φ (mm)	GAZ
P1	Solid Fe	0.8	CO ₂
P2	Solid Fe	0.8	80%Ar+20%CO ₂
P3	Solid Fe	0.9	CO ₂
P4	Solid Fe	0.9	80%Ar+20%CO ₂
P5	Solid Fe	1.0	80%Ar+20%CO ₂
P6	Solid Fe	1.0	CO ₂
P7	Solid Fe	1.2	CO ₂
P8	Solid Fe	1.2	80%Ar+20%CO ₂
P9	Solid Fe	1.6	80%Ar+20%CO ₂
P10	Solid Fe	1.6	CO ₂
P11	Flux.c.w Fe	1.0	CO ₂
P12	Flux.c.w Fe	1.2	CO ₂
P13	Flux.c.w Fe	1.6	CO ₂
P14	SS ER316	1.0	98%Ar+2%CO ₂
P15	SS ER316	1.2	98%Ar+2%CO ₂
P16	SS ER316	1.6	98%Ar+2%CO ₂
P17	Flux.c.w SS	1.2	CO ₂
P18	Cu Si	1.0	Ar100%
P19	Cu Si	1.2	Ar100%
P20	Cu Si	1.6	Ar100%
Podwójny Puls			
NR PROGRAMU	MATERIAŁ	DRUT Φ (mm)	GAZ
P1	AlMg5	1.0	Ar
P2	AlMg5	1.2	Ar
P3	AlMg5	1.6	Ar
P4	AlSi5	1.0	Ar
P5	AlSi5	1.2	Ar
P6	AlSi5	1.6	Ar
P7	Al99.5	1.2	Ar
P8	Al99.5	1.6	Ar
P9	Fe	0.8	80%Ar+20%CO ₂
P10	Fe	0.9	80%Ar+20%CO ₂
P11	Fe	1.0	80%Ar+20%CO ₂
P12	Fe	1.2	80%Ar+20%CO ₂
P13	Fe	1.6	80%Ar+20%CO ₂
P14	SS ER316	1.0	98%Ar+2%CO ₂
P15	SS ER316	1.2	98%Ar+2%CO ₂
P16	SS ER316	1.6	98%Ar+2%CO ₂
P17	Flux.c.w Fe	1.2	80%Ar+20%CO ₂
P18	Flux.c.w Fe	1.6	80%Ar+20%CO ₂
P19	Flux.c.w SS	1.2	80%Ar+20%CO ₂
P20	CuSi3	1.0	Ar
P21	CuSi3	1.2	Ar
P22	CuAl8	1.2	Ar
P23	CuAl8	1.6	Ar

Indeks „c.w.” oznacza „core wired” (drut rdzeniowy proszkowy)