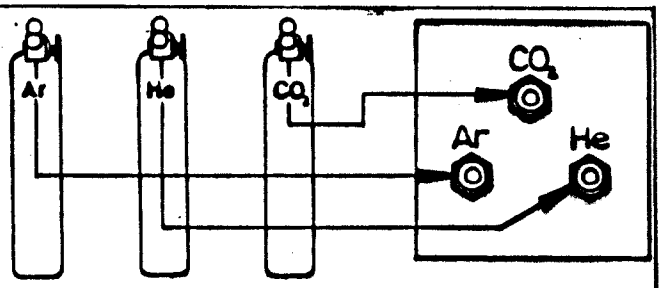
Gas Mix # 1 : 69% Ar - 30% He - 1% CO_2 — GMAW

Pulse Spray - Stainless Steels
Low Alloy Steels
Nickel Base Alloys

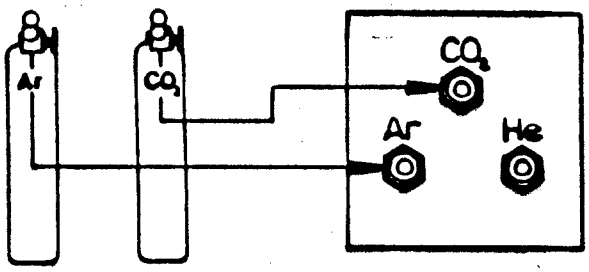
Note : Hoses connected as shown on mixer.



Gas Mix # 2 : 98 1/2% Ar - 1 1/2% CO_2 — GMAW

Pulse Spray - Carbon Steel
Spray Arc - Carbon Steel
Stainless Steels

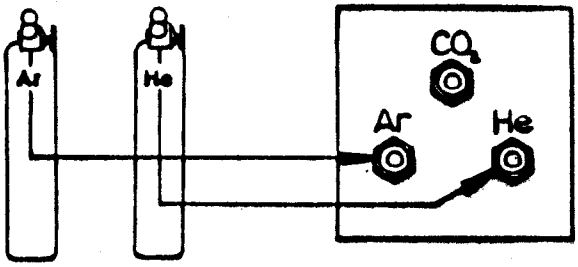
Note : Helium off.



Gas Mix # 3 : 70% Ar - 30% He — GMAW, GTAW

Pulse Spray &
Spray Arc - Aluminum Alloys
TIG - All Weldable Alloys

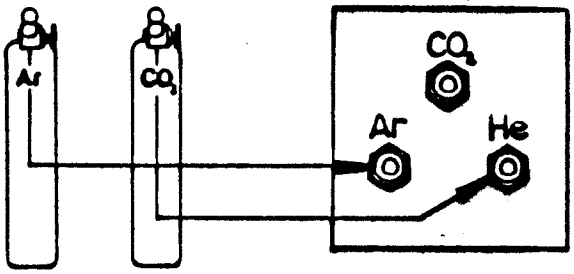
Note : Carbon Dioxide off.



Gas Mix # 4 : 88% Ar - 12% CO_2 — GMAW, FCAW

Pulse Spray, Spray Arc &
Short Arc - Carbon Steel
Flux Cored - All Alloys formulated for 75/25.

Note : Carbon Dioxide hose in Helium inlet port.



Gas Mix # 5 : 92% He - 7 1/2% Ar - 1/2% CO_2

Short Arc - Stainless Steels — GMAW

Note : Argon and Helium Hose Reversed.

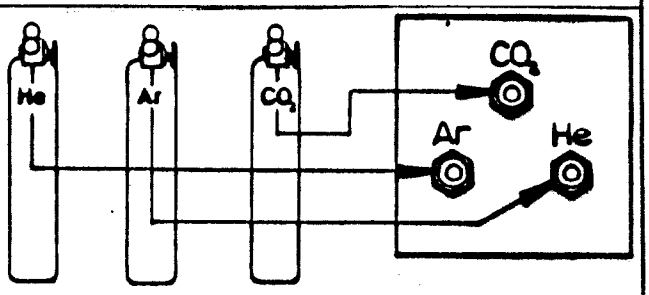


FIG-2
Hose Interchange Diagram