

# WELD MODE PULSE

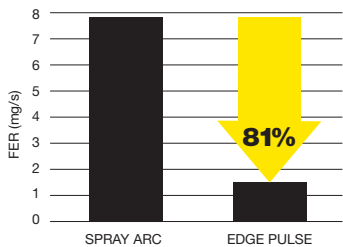


## Experience the Benefits of PULSE

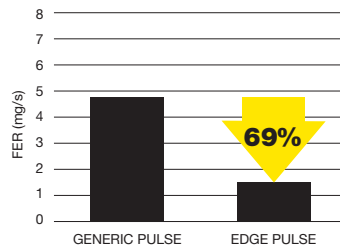
The Warrior Edge Pulse mode provides an outstanding out-of-the-box performance, with great weld pool control, useful for a wide range of applications. The Warrior Edge features a reactive arc length control compensating for operator behaviour, giving improved welding quality with consistent penetration and bead appearance even when stick out is changed.

Compared to conventional pulse welding systems Warrior Edge provides a higher process stability, with a balanced material transfer with clearly separated droplets, resulting in heavily reduced spatter and fume levels.

### FUME REDUCTION



EDGE PULSE COMPARED TO SPRAY ARC



EDGE PULSE COMPARED TO GENERIC PULSE

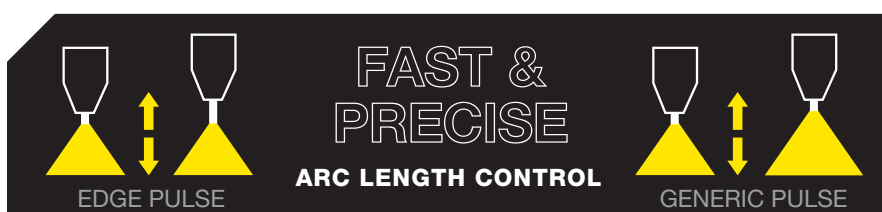
The Warrior Edge Pulse WeldMode is optimized for material thicknesses from 2 mm and above with the aim to:

- Eliminating spatter to reduce post weld clean-up, thus improving productivity.
- Strongly reduced fume levels compared to generic pulse and even more compared to spray arc.
- Provide out of the box performance without need for adjustments.
- Reactive arc length control maintaining good welding results with consistent penetration and bead appearance even when stick out is changed.

With easy to use, advanced WeldModes like PULSE on Warrior Edge, manufacturers and fabricators benefit from optimized productivity, improved quality, and simplified training.

## FEATURES

### EDGE PULSE VS. GENERIC PULSE



REDUCED  
SPATTER AND  
FUMES TO  
ELIMINATE  
NEED FOR  
POST WELD  
CLEAN-UP

Benefits of the PULSE mode include exceptional weld pool control, minimized spatter and fume levels, consistent penetration and bead appearance even with varying stick-out, and the ability to deliver optimal performance without adjustments

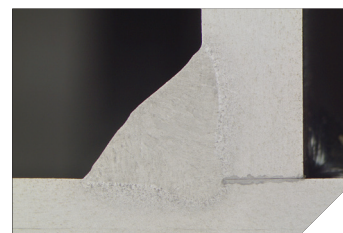
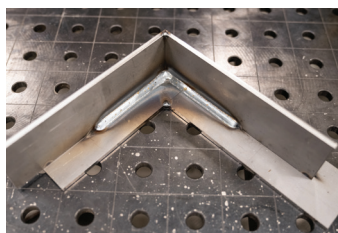
## APPLICATION

WELD MODE: **PULSE** JOINT: **T JOINT**



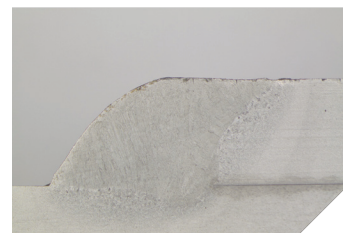
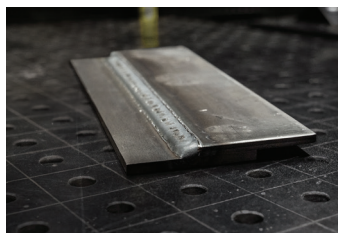
Position	Plate Thickness	Wire Type	Wire Diameter	Gas Type	Gas Flow	CTWD	WFS	Voltage	Current	Arc Length Trim	Arc Dynamics	Travel Speed	Torch Angle	Travel Angle	Distance to Corner	Heat Input
PB	5.0 mm	Fe ER70S	1.0 mm	Ar + 15-25% CO <sub>2</sub>	15 L/min	15 mm	7.5 m/min	23.8 V	162 A	±0	±0	35 cm/min	45°	20° push	0 mm	0.661 kJ/mm

WELD MODE: **PULSE** JOINT: **T JOINT**



Position	Plate Thickness	Wire Type	Wire Diameter	Gas Type	Gas Flow	CTWD	WFS	Voltage	Current	Arc Length Trim	Arc Dynamics	Travel Speed	Torch Angle	Travel Angle	Distance to Corner	Heat Input
PB	5.0 mm	Fe ER70S	1.0 mm	Ar + 15-25% CO <sub>2</sub>	15 L/min	15 mm	9.0 m/min	23.8 V	179 A	-1,5	±0	35 cm/min	45°	15°- 20° push	0 mm	0.730 kJ/mm

WELD MODE: **PULSE** JOINT: **LAP JOINT**



Position	Plate Thickness	Wire Type	Wire Diameter	Gas Type	Gas Flow	CTWD	WFS	Voltage	Current	Arc Length Trim	Arc Dynamics	Travel Speed	Torch Angle	Travel Angle	Distance to Corner	Heat Input
PA	5.0 mm	Fe ER70S	1.0 mm	Ar + 15-25% CO <sub>2</sub>	15 L/min	12 mm	7.3 m/min	23.8 V	163 A	±0	+3	26 cm/min	30°	15° push	0.5 mm	0.895 kJ/mm

## RECOMMENDED EQUIPMENT

### POWER SOURCE

Warrior Edge 500  
CX I / CX II / DX

### WIRE FEEDER

RobustFeed Edge BX / CX

### TORCH

Exeor Mig Water / Air  
cooled torches

### FILLER METAL

OK Aristorod 12.50, 1.0 mm  
Purus 42 CF, 1.0 mm



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