# WELD MODE SPEED







# Experience the Benefits of SPEED

The SPEED mode creates a more focused and stable arc overlaying a modified pulsed current waveform onto a conventional spray transfer arc, resulting in improved material transfer.

Benefits of the SPEED WeldMode, with its enhanced arc stability include improved control at higher welding speeds which boosts productivity. Furthermore SPEED provides deeper more focused penetration in fillet welds and the ability to weld in narrower grooves.

This mode also minimizes spatter, leading to less post-weld clean-up. The consistent material transfer of SPEED compared to spray arc reduces fume generation.

SPEED is effective for material thicknesses of 5 mm and above, offering these advantages over standard Spray Arc transfer:

- Faster welding speeds and improved productivity
- Deeper penetration and ability to weld in more narrow grooves
- Reduced spatter levels
- Reduced fumes

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

TROIL

MORE

### **FEATURES**

# IMPROVED INCREASED WELDING SPEED SPFFD SPRAY ARC PENETRATION SPEED SPRAY ARC 티망 F()(CIUSIFD PENETRATION MARROW JOINTS SPEED SPRAY ARC

#### Benefits of the SPEED mode include improved control at higher welding speeds, reduced spatter and fumes, deeper more focused penetration in fillet welds and the ability to weld in narrower grooves.

# SPEED VS. SPRAY ARC

#### **APPLICATION**



WELD MODE: JOINT: **T JOINT** SPEED

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Position	Plate Thickness	Wire Type	Wire Diameter	Gas Type	Gas Flow	CTWD	WFS	Voltage	Current	Arc Length	Arc Dynamics	Travel Speed	Torch Angle	Travel Angle	Distance to Corner	Heat Input
PB	10.0 mm	Fe ER70S	1.0 mm	Ar + 15-25% CO <sub>2</sub>	18 L/min	18 mm	16.5 m/min	32.3 V	323 A	-1,5 V	+3	45 cm/min	45°	15° push	0.5 mm	1.391 kJ/mm



WELD MODE: JOINT: SPEED INCLINED **T JOINT** 

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Position	Plate Thickness	Wire Type	Wire Diameter	Gas Type	Gas Flow	CTWD	WFS	Voltage	Current	Arc Length	Arc Dynamics	Travel Speed	Torch Angle	Travel Angle	Distance to Corner	Heat Input
РВ	10.0 mm	Fe ER70S	1.0 mm	Ar + 15-25% CO <sub>2</sub>	18 L/min	21 mm	19.0 m/min	29.0 V	325 A	-3,2 V	+5	28 cm/min	22.5°	20° drag	0.0 mm	2.020 kJ/mm









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Position	Plate Thickness	Bevel Angle	Land	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	15.0 mm	45°	0 - 0,5 mm	Fe ER70S	1.0 mm	Ar + 15-25% CO <sub>2</sub>	18 L/min	21 mm	17.5 m/min	28.2 V	298 A	-2,8 V	+5	33 cm/min	26°	25°> 15° drag	0.0 mm	1.528 kJ/mm

### **RECOMMENDED EQUIPMENT**

POWER SOURCE Warrior Edge 500

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



CX II / DX





