

# WELD MODE THIN



## Experience the Benefits of THIN

The THIN WeldMode uses an enhanced short circuit transfer processes with a novel type of adaptive control that delivers consistent and smooth metal transfer for a more stable weld process compared to regular short-circuit welding.

Improved stability gives the operator better control even when welding at faster welding speeds, plus it suppresses the conditions that lead to the formation of spatter and gives lower heat input for reduced distortion.

In addition, there is no need for a voltage sense cable which simplifies set-up and reduces the risk for mistakes.

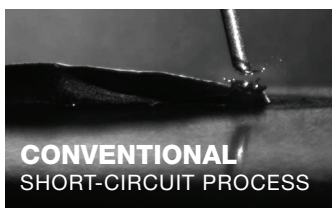
The THIN WeldMode is optimized for welding thin plates (0.7 to 3 mm) with the aim to:

- Reduce spatter for less post-weld clean-up
- Reduce heat input leading to decreased distortion
- Enhance arc stability, offering more control at faster welding speeds

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



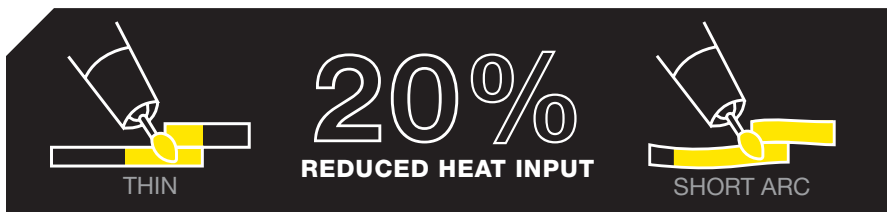
**THIN**  
PROCESS



**CONVENTIONAL**  
SHORT-CIRCUIT PROCESS

## FEATURES

### THIN VS SHORT ARC

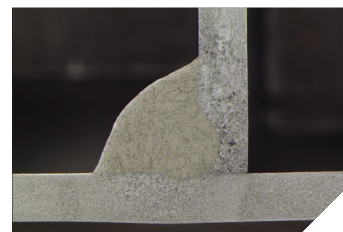
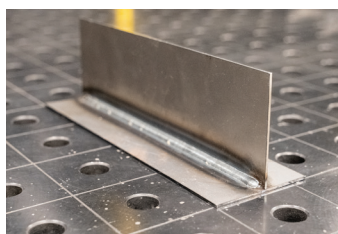


**IMPROVED  
METAL  
TRANSFER  
&  
REDUCED  
FUMES**

## APPLICATION

WELD MODE:  
**THIN**

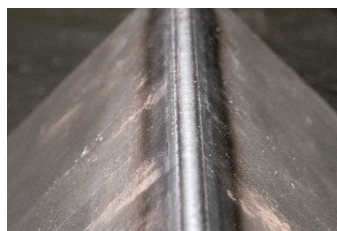
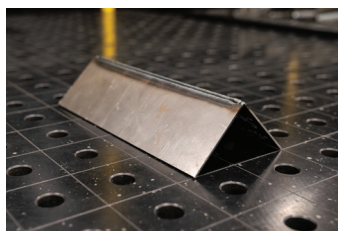
JOINT:  
**T JOINT**



Position	Plate Thickness	Wire Type	Wire Diameter	Gas Type	Gas Flow	CTWD	WFS	Voltage	Current	Arc Length	Travel Speed	Torch Angle	Travel Angle	Distance to Corner	Heat Input
PB	1.5 mm	Fe ER70S	1.0 mm	Ar + 15-25% CO <sub>2</sub>	15 L/min	10 mm	3.4 m/min	14.4 V	97 A	+0,5 V	35 cm/min	45°	0°	0 mm	0.239 kJ/mm

WELD MODE:  
**THIN**

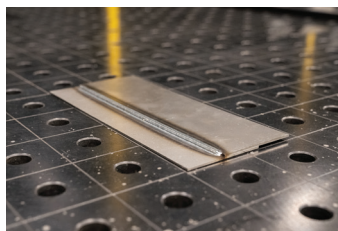
JOINT:  
**CORNER JOINT**



Position	Plate Thickness	Wire Type	Wire Diameter	Gas Type	Gas Flow	CTWD	WFS	Voltage	Current	Arc Length	Travel Speed	Torch Angle	Travel Angle	Distance to Corner	Heat Input
PA	1.5 mm	Fe ER70S	1.0 mm	Ar + 15-25% CO <sub>2</sub>	15 L/min	10 mm	2.5 m/min	14.3 V	74 A	+0,5 V	50 cm/min	0°	0°	0 mm	0.127 kJ/mm

WELD MODE:  
**THIN**

JOINT:  
**LAP JOINT**



Position	Plate Thickness	Wire Type	Wire Diameter	Gas Type	Gas Flow	CTWD	WFS	Voltage	Current	Arc Length	Travel Speed	Torch Angle	Travel Angle	Distance to Corner	Heat Input
PA	1.5 mm	Fe ER70S	1.0 mm	Ar + 15-25% CO <sub>2</sub>	15 L/min	10 mm	2.6 m/min	14.5 V	77 A	+1,0 V	35c m/min	35°	5° drag	1 mm	0.191 kJ/mm

## RECOMMENDED EQUIPMENT

### POWER SOURCE

Warrior Edge 500 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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TECHNIKA SPAWALNICZA

