

AC WAVEFORMS



Standard Square Wave: Travel faster



Soft Square Wave: Max puddle control



Sine Wave: Traditional arc



Triangle Wave: Reduced heat input

Standard Square Wave

The Standard Square Wave offers fast transitions between EN and EP for a responsive, dynamic, and focused arc with better directional control. It forms a fast-freezing puddle with deep penetration and fast travel speeds.

Soft Square Wave

The Soft Square Wave provides a smooth, soft, "buttery" arc with a fluid puddle and good wetting action. The puddle is more fluid than with standard square wave and more controllable than with sine wave.

Sine Wave

The Sine Wave a soft arc with the feel of a conventional power source. It provides good wetting action and actually sounds quieter than other waves. Its fast transition through the zero amperage point also eliminates the need for continuous high frequency.

Triangle Wave

The Triangular Wave peak amperage while reducing overall heat input into the weld. This leads to quick puddle formation, low weld distortion, and fast travel speeds. It is especially good for welding thin aluminum.