



CMT CYCLE STEP

REGULATES
SINGLE WELDING
DROPLETS



HIGHEST LEVEL OF REPEATABILITY
/ The set number of welding droplets per welding spot allow for unique repeatability.



DEFINED SPOT SIZE
/ Exact welding spot size repeatability
/ No welding reinforcement



MINIMAL HEAT INPUT
/ Even the thinnest of sheets can be welded through easily controllable heat input.



PERFECT WELD SEAM APPEARANCE
/ Defined welding cycles allow high-quality visible welding seams – spatter-free



Hold point
1 mm elo coated
Vd: 11,5 m/min

Filler wire: CuSi3 1 mm
Number of CMT-cycles: 8



Lap joint
3 mm aluminum
Vd: 7,7 m/min
Vs: 50 cm/min

Filler wire: AlSi5 1,2 mm
Number of CMT-cycles: 18
Break time: 0,16 s

	Applications Cycle Step
Visible welding seams with defined jointing	✓
Welding thin sheets with tolerances	✓
Fine overlay welding	✓
Additive welding applications	✓
Support by bonding techniques through defined distances (distance points)	✓
Hold points for bonded joints	✓
Welding in position	✓