



Available welding programs

Kemppi welding software meets a wide range of welding needs in a variety of materials and gas types. Divided into two groups, Wise and Match solutions can be purchased and integrated to your equipment delivery or added later if welding needs change.

The following tables list all currently available welding programs for FastMig KMS, FastMig M, FastMig Pulse, FastMig X, X8 MIG Welder, KempArc Automation and A7 Automation equipment.

Welding programs are available at DataStore
<https://datastore.kemppi.com>

+ Wise and Match

- Manage welding skill requirement
- Increase welding productivity
- Improve welding quality
- Reduce rework costs

Welding programs; compatible gases and materials

Welding program gases		Compatible gases			
Ar+18%CO ₂	▶	Ar+20%CO ₂	Ar+25%CO ₂	Ar+23%CO ₂	Ar+15%CO ₂
Ar+8%CO ₂	▶	Ar+5%CO ₂	Ar+10%CO ₂	Ar+5%CO ₂ + 5%O ₂	
Ar+2%CO ₂	▶	Ar+2,5%CO ₂	Ar+2%O ₂	Ar+1%CO ₂	
Ar+30%He+1%O ₂	▶	Ar+30%He + 2%CO ₂			

Welding program materials		Compatible materials				
Ss-316	▶	Ss-308	Ss-309	Ss-307	Ss-310	Ss-312
CrNiMo 19 12	▶	CrNi 19 9	CrNi 23 12	CrNiMn 18 8	CrNi 25 20	CrNi 30 9
1.4430	▶	1.4316	1.4332	1.4370	1.4842	1.4337
AlMg5	▶	AlMg4,5Mn	AlMg5Mn	AlMg3		
ER 5356	▶	ER 5183	ER 5556	ER 5154		
3.3556	▶	3.3548		3.3536		
AlSi5	▶	AlSi12	Al			
ER 4043	▶	ER 4047	ER 1100			
3.2245	▶	3.2585	3.0259			

Classification according to standards

DIN	AWS	W.-Nr	DIN	AWS	W.-Nr	
Al Al	▶	1100	Ss CrNiMo 19 12	▶	Ss-316	1.4430
AlMg5	▶	5356	CrNiMo 22 9 3	▶	Duplex 2209	1.4462
AlSi5	▶	4043	CrNiMo 25 9 4	▶	SuperDuplex 2509	1.4410
Cu CuAl8	▶	CuAl8	NiCr21Mo9Nb	▶	Inc-625	2.4831
CuSi3	▶	CuSi3	FC-CrNiMo 19 12	▶	FC-316	1.4430
CuSn	▶	CuSn	Cr21 Ni10 N RE	▶	253MA	1.4835
Fe Fe	▶	G3Si	CrNiMo 27 31 4 Cu L	▶	383	1.4563
Fe Metal (MC)	▶	Metal cored	CrNi 25 20	▶	Ss-310	1.4842
Fe Rutil (FC)	▶	Rutil cored	T CO₂ (stelloy)	▶	CCoCr-A	
Fe Basic (FC)	▶	Basic cored				

Wire diameters AWS, ISO and welding programs

AWS	ISO	Welding program wire ø
0.024"	0.6 mm	-
0.030"	0.8 mm	0.8
0.035"	0.9 mm	0.9
0.040"	1.0 mm	1.0
0.045"	1.1 mm	1.14 or 1.2
0.047"	1.2 mm	1.2
0.052"	1.3 mm	1.4
0.055"	1.4 mm	1.4
1/16"	1.6 mm	1.6
5/64"	2.0 mm	2.0
3/32"	2.4 mm	2.4

Kemppi DataStore offers new welding program packs, which facilitate customization of X8 MIG Welder system and make welding more efficient. The new welding program packs and their availability in Kemppi DataStore make it easier to purchase and sell welding programs for X8 MIG Welder machine. Welding program packs introduce a more inexpensive and comfortable way to purchase welding programs than buying them individually. The contents of the packs are so designed that they cover wide range of welding needs in various kind of workshops.

X8 Work Pack

1-MIG	Wire Ø	Gas	N:o	Pulse / DPulse	Wire Ø	Gas	N:o
AlMg5	1.2	Ar	A02	AlMg5	1.2	Ar	A02
AlSi5	1.2	Ar	A12	AlSi5	1.2	Ar	A12
Fe	0.9	Ar+18%CO ₂	F02	Fe	1.0	Ar+18%CO ₂	F03
Fe	1.0	Ar+18%CO ₂	F03	Fe	1.2	Ar+18%CO ₂	F04
Fe	1.2	Ar+18%CO ₂	F04	Ss	1.0	Ar+2%CO ₂	S03
Fe	0.9	CO ₂	F22	Ss	1.0	Ar+2%CO ₂	S06
Fe	1.0	CO ₂	F23	Ss	1.2	Ar+2%CO ₂	S04
Fe	1.2	CO ₂	F24				
Fe Metal	1.2	Ar+18%CO ₂	M04				
Fe Rutil	1.2	Ar+18%CO ₂	R04				
Fe Rutil	1.2	CO ₂	R14				
CrNiMo 19 12	1.0	Ar+2%CO ₂	S03				
CrNiMo 19 12	1.2	Ar+2%CO ₂	S04				
FC-CrNiMo 19 12	1.2	Ar+18%CO ₂	S84				

Kemppi DataStore offers new welding program packs, which facilitate customization of FastMig Pulse and FastMig X systems and make welding more efficient. The new welding program packs and their availability in Kemppi DataStore make it easier to purchase and sell welding programs for FastMig Pulse and FastMig X machines. Welding program packs introduce a more inexpensive and comfortable way to purchase welding programs than buying them individually. The contents of the packs are so designed that they cover wide range of welding needs in various kind of workshops.

Aluminium Pack

1-MIG	Wire Ø	Gas	N:o	Pulse / DPulse	Wire Ø	Gas	N:o
AlMg5	1.0	Ar	A01	AlMg5	1.0	Ar	A01
AlMg5	1.2	Ar	A02	AlMg5	1.2	Ar	A02
AlMg5	1.6	Ar	A03	AlMg5	1.6	Ar	A03
AlSi5	1.0	Ar	A11	AlSi5	1.0	Ar	A11
AlSi5	1.2	Ar	A12	AlSi5	1.2	Ar	A12
AlSi5	1.6	Ar	A13	AlSi5	1.6	Ar	A13

Note: For FastMig X with MXP 37 Pipe Steel wire feeder you will need WisePulseMig licence.

Stainless Steel Pack

1-MIG	Wire Ø	Gas	N:o	Pulse / DPulse	Wire Ø	Gas	N:o
CrNiMo 19 12	0.8	Ar+2%CO ₂	S01	CrNiMo 19 12	0.8	Ar+2%CO ₂	S01
CrNiMo 19 12	0.9	Ar+2%CO ₂	S02	CrNiMo 19 12	0.9	Ar+2%CO ₂	S02
CrNiMo 19 12	1.0	Ar+2%CO ₂	S03	CrNiMo 19 12	1.0	Ar+2%CO ₂	S06
CrNiMo 19 12	1.2	Ar+2%CO ₂	S04	CrNiMo 19 12	1.2	Ar+2%CO ₂	S04
FC-CrNiMo 19 12	1.2	Ar+18%CO ₂	S84	CrNiMo 19 12	1.0	Ar+He+CO ₂	S26
MC-CrNiMo 19 12	1.2	Ar+2%CO ₂	S87	CrNiMo 19 12	1.2	Ar+He+CO ₂	S24

Note: For FastMig X with MXP 37 Pipe Steel wire feeder you will need WisePulseMig licence.

Kemppi DataStore offers new welding program packs, which facilitate customization of FastMig Pulse and FastMig X systems and make welding more efficient. The new welding program packs and their availability in Kemppi DataStore make it easier to purchase and sell welding programs for FastMig Pulse and FastMig X machines. Welding program packs introduce a more inexpensive and comfortable way to purchase welding programs than buying them individually. The contents of the packs are so designed that they cover wide range of welding needs in various kind of workshops.

Steel Pack

1-MIG	Wire Ø	Gas	N:o	1-MIG	Wire Ø	Gas	N:o
Fe	0.8	Ar+18%CO ₂	F01	Fe	1.0	CO ₂	F23
Fe	0.9	Ar+18%CO ₂	F02	Fe	1.2	CO ₂	F24
Fe	1.0	Ar+18%CO ₂	F03	Fe Metal	1.2	Ar+18%CO ₂	M04
Fe	1.2	Ar+18%CO ₂	F04	Fe Metal	1.2	CO ₂	M24
Fe	0.8	CO ₂	F21	Fe Rutil	1.2	Ar+18%CO ₂	R04
Fe	0.9	CO ₂	F22	Fe Rutil	1.2	CO ₂	R14

Work Pack

1-MIG	Wire Ø	Gas	N:o	Pulse / DPulse	Wire Ø	Gas	N:o
AlMg5	1.2	Ar	A02	AlMg5	1.2	Ar	A02
AlSi5	1.2	Ar	A12	AlSi5	1.2	Ar	A12
Fe	0.9	Ar+18%CO ₂	F02	Fe	1.0	Ar+18%CO ₂	F03
Fe	1.0	Ar+18%CO ₂	F03	Fe	1.2	Ar+18%CO ₂	F04
Fe	1.2	Ar+18%CO ₂	F04	CrNiMo 19 12	1.0	Ar+2%CO ₂	S06
Fe	0.9	CO ₂	F22	CrNiMo 19 12	1.2	Ar+2%CO ₂	S04
Fe	1.0	CO ₂	F23				
Fe	1.2	CO ₂	F24				
Fe Metal	1.2	Ar+18%CO ₂	M04				
Fe Metal	1.2	CO ₂	M24				
Fe Rutil	1.2	Ar+18%CO ₂	R04				
Fe Rutil	1.2	CO ₂	R14				
CrNiMo 19 12	1.0	Ar+2%CO ₂	S03				
CrNiMo 19 12	1.2	Ar+2%CO ₂	S04				
FC-CrNiMo 19 12	1.2	Ar+18%CO ₂	S84				

Note: For FastMig X with MXP 37 Pipe Steel wire feeder you will need WisePulseMig licence.
This new revision does not consist AlMg5 1.0 mm welding programs. They can be found in Aluminium Pack.

Kemppi DataStore offers new welding program packs, which facilitate customization of FastMig X systems and make welding more efficient. The new welding program packs and their availability in Kemppi DataStore make it easier to purchase and sell welding programs for FastMig X machines. Welding program packs introduce a more inexpensive and comfortable way to purchase welding programs than buying them individually. The contents of the packs are so designed that they cover wide range of welding needs in various kind of workshops.

Pipe Steel pack

WiseRoot+	Wire Ø	Gas	N:o
Fe	0.8	Ar+18%CO ₂	F01
Fe	0.9	Ar+18%CO ₂	F02
Fe	1.0	Ar+18%CO ₂	F03
Fe	1.2	Ar+18%CO ₂	F04
Fe	0.8	CO ₂	F21
Fe	0.9	CO ₂	F22
Fe	1.0	CO ₂	F23
Fe	1.2	CO ₂	F24
Fe Metal	1.2	Ar+18%CO ₂	M04
Fe Metal	1.2	CO ₂	M24

Note: For other than MXP 37, WFX 200 P or WFX 300 P wire feeders you will need WiseRoot+ licence.

1-MIG	Wire Ø	Gas	N:o
Fe	0.8	Ar+18%CO ₂	F01
Fe	0.9	Ar+18%CO ₂	F02
Fe	1.0	Ar+18%CO ₂	F03
Fe	1.2	Ar+18%CO ₂	F04
Fe	0.8	CO ₂	F21
Fe	0.9	CO ₂	F22
Fe	1.0	CO ₂	F23
Fe	1.2	CO ₂	F24
Fe Metal	1.2	Ar+18%CO ₂	M04
Fe Metal	1.2	CO ₂	M24
Fe Rutil	1.2	Ar+18%CO ₂	R04
Fe Rutil	1.2	CO ₂	R14
Fe	1.6	Inner Shield	R56
Fe	2.0	Inner Shield	R57
Fe	2.4	Inner Shield	R58

Pipe Stainless Pack

WiseRoot+	Wire Ø	Gas	N:o
CrNiMo 19 12	0.8	Ar+2%CO ₂	S01
CrNiMo 19 12	0.9	Ar+2%CO ₂	S02
CrNiMo 19 12	1.0	Ar+2%CO ₂	S03
CrNiMo 19 12	1.2	Ar+2%CO ₂	S04

1-MIG	Wire Ø	Gas	N:o
CrNiMo 19 12	0.8	Ar+2%CO ₂	S01
CrNiMo 19 12	0.9	Ar+2%CO ₂	S02
CrNiMo 19 12	1.0	Ar+2%CO ₂	S03
CrNiMo 19 12	1.2	Ar+2%CO ₂	S04
FC-CrNiMo 19 12	1.0	Ar+18%CO ₂	S84
FC-CrNiMo 19 12	1.2	CO ₂	S85
MC-CrNiMo 19 12	1.2	Ar+2%CO ₂	S87

Pulse / DPulse	Wire Ø	Gas	N:o
CrNiMo	0.8	Ar+2%CO ₂	S01
CrNiMo	0.9	Ar+2%CO ₂	S02
CrNiMo	1.0	Ar+2%CO ₂	S06
CrNiMo	1.2	Ar+2%CO ₂	S04
CrNiMo	1.0	Ar+He+CO ₂	S26
CrNiMo	1.2	Ar+He+CO ₂	S24

Note: For other than MXP 37, WFX 200 P or WFX 300 P wire feeders you will need WiseRoot+ licence.

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Pipe Special Stainless pack

WiseRoot+	Wire Ø	Gas	N:o	1-MIG	Wire Ø	Gas	N:o
CrNiMo 22 9 3	1.0	Ar+He+CO ₂	S66	FC-CrNiMo 25 9 4	1.2	Ar+18%CO ₂	S70
CrNiMo 22 9 3	1.2	Ar+He+CO ₂	S67	FC-NiCr21Mo9Nb	1.2	Ar+18%CO ₂	S80
CrNiMo 25 9 4	1.0	Ar+He+CO ₂	S68	FC-CrNiMo 22 9 3	1.2	Ar+18%CO ₂	S86
CrNiMo 25 9 4	1.2	Ar+He+CO ₂	S69				
NiCr21Mo9Nb	1.0	Ar+He+CO ₂	S76				
NiCr21Mo9Nb	1.2	Ar+He+CO ₂	S77				

Pulse / DPulse	Wire Ø	Gas	N:o
CrNiMo 22 9 3	1.0	Ar+He+CO ₂	S66
CrNiMo 22 9 3	1.2	Ar+He+CO ₂	S67
CrNiMo 25 9 4	1.0	Ar+He+CO ₂	S68
CrNiMo 25 9 4	1.2	Ar+He+CO ₂	S69
NiCr21Mo9Nb	1.0	Ar+He+CO ₂	S76
NiCr21Mo9Nb	1.2	Ar+He+CO ₂	S77

Note: For other than MXP 37, WFX 200 P or WFX 300 P wire feeders you will need WiseRoot+ licence.

Steel pack for WiseThin+

WiseThin+	Wire Ø	Gas	N:o
Fe	0.8	Ar+18%CO ₂	F01
Fe	0.9	Ar+18%CO ₂	F02
Fe	1.0	Ar+18%CO ₂	F03
Fe	1.2	Ar+18%CO ₂	F04
Fe	0.8	CO ₂	F21
Fe	0.9	CO ₂	F22
Fe	1.0	CO ₂	F23
Fe	1.2	CO ₂	F24

Note: For other than MXP 38, WFX 200 AMC or WFX 300 AMC wire feeders you will need WiseThin+ licence.

Welding programs

Welding programs must be purchased separately for each welding process.

Welding programs are available at DataStore
<https://datastore.kemppi.com>

Pulse / DPulse

DataStore	Wire Ø	Gas	Description	N:o	Package
AlMg5	1.2	Ar		A02	Ⓜ
AlMg5	1.2	Ar	Soft	A06	
AlSi5	1.2	Ar		A12	Ⓜ
CuSi3	1.0	Ar		C03	
CuAl8	1.0	Ar		C13	
Fe	1.0	Ar+18%CO ₂		F03	Ⓜ
Fe	1.2	Ar+18%CO ₂		F04	Ⓜ
Fe	1.0	Ar+8%CO ₂		F13	
Fe	1.2	Ar+8%CO ₂		F14	
Fe Metal	1.2	Ar+18%CO ₂		M04	
CrNimo 22 9 3	1.0	Ar+30%He+2%CO ₂		H03	
CrNimo 22 9 3	1.2	Ar+30%He+2%CO ₂		H04	
CrNimo 25 9 4	1.0	Ar+30%He+N ₂		H28	
CrNimo 19 12	1.0	Ar+2%CO ₂		S03	Ⓜ
CrNimo 19 12	1.2	Ar+2%CO ₂		S04	Ⓜ
CrNimo 19 12	1.0	Ar+2%CO ₂	Soft	S06	Ⓜ
CrNimo 19 12	1.2	Ar+2%CO ₂	Soft	S07	
NiCr21Mo9Nb	1.0	Ar+30%He+2%CO ₂		H63	
NiCr21Mo9Nb	1.0	Ar+30%He		H83	
NiCr21Mo9Nb	1.2	Ar	Cladding	L94	

Welding programs

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1-MIG

DataStore	Wire Ø	Gas	Description	N:o	Package
AlMg5	1.2	Ar		A02	Ⓜ
AlSi5	1.2	Ar		A12	Ⓜ
CuSi3	1.0	Ar		C03	
Fe	0.9	Ar+18%CO ₂		F02	Ⓜ
Fe	1.0	Ar+18%CO ₂		F03	Ⓜ
Fe	1.2	Ar+18%CO ₂		F04	Ⓜ
Fe	1.4	Ar+18%CO ₂		F05	
Fe	1.6	Ar+18%CO ₂		F06	
Fe	1.0	Ar+8%CO ₂		F13	
Fe	1.2	Ar+8%CO ₂		F14	
Fe	1.4	Ar+8%CO ₂		F15	
Fe	0.9	CO ₂		F22	Ⓜ
Fe	1.0	CO ₂		F23	Ⓜ
Fe	1.2	CO ₂		F24	Ⓜ
Fe Metal	1.2	Ar+18%CO ₂		M04	Ⓜ
Fe Metal	1.2	CO ₂		M24	
Fe Metal	1.2	Ar+18%CO ₂		H86	
Fe Rutil	1.2	Ar+18%CO ₂		R04	Ⓜ
Fe Rutil	1.2	CO ₂		R14	Ⓜ
CrNimo 19 12	1.0	Ar+2%CO ₂		S03	Ⓜ
CrNimo 19 12	1.2	Ar+2%CO ₂		S04	Ⓜ
Fc-CrNiMo 19 12	1.2	Ar+18%CO ₂		S84	Ⓜ

Welding programs

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WiseRoot+

DataStore	Wire Ø	Gas	Description	N:o	Package
Fe	1.0	Ar+18%CO ₂		F03	
Fe	1.2	Ar+18%CO ₂		F04	
Fe	1.0	CO ₂		F23	
Fe	1.2	CO ₂		F24	
CrNiMo 19 12	1.0	Ar+2%CO ₂		S03	
CrNiMo 19 12	1.2	Ar+2%CO ₂		S04	

WiseThin+

DataStore	Wire Ø	Gas	Description	N:o	Package
CuSi3	1.0	Ar		C03	
Fe	1.0	Ar+18%CO ₂		F03	
Fe	1.0	CO ₂		F23	
CrNiMo 19 12	1.0	Ar+2%CO ₂		S03	
CrNiMo 19 12	1.2	Ar+2%CO ₂		S04	

MatchCurve programs

MatchCurve programs must be purchased separately for each welding process. For FastMig X with MXP 37 Pipe Fe wire feeder you will need WisePulseMig licence.

Welding programs are available at DataStore
<https://datastore.kemppi.com>

Pulse / DPulse

DataStore / Power source panel	Wire Ø	Gas	Description	N:o	Package
AlMg5	0.8	Ar		A00	
AlMg5	1.0	Ar		A01	AI
AlMg5	1.2	Ar		A02	AI W
AlMg5	1.6	Ar		A03	AI
AlMg5	1.2	Ar	Soft	A06	
AlSi5	1.0	Ar		A11	AI
AlSi5	1.2	Ar		A12	AI W
AlSi5	1.6	Ar		A13	AI
Al	1.2	Ar		A22	
Al	1.6	Ar		A23	
AlMg5	1.2	Ar+50%He		A32	
AlMg5	1.6	Ar+50%He		A33	
CuSi3	0.8	Ar		C01	
CuSi3	1.0	Ar		C03	
CuSi3	1.2	Ar		C04	
CuAl8	0.8	Ar		C11	
CuAl8	1.0	Ar		C13	
CuAl8	1.2	Ar		C14	
CuSn	1.2	Ar		C24	
CuSn	1.6	Ar		C26	
CuNi10Fe	1.2	Ar		C34	
Fe	0.8	Ar+18%CO ₂		F01	
Fe	0.9	Ar+18%CO ₂		F02	
Fe	1.0	Ar+18%CO ₂		F03	W Fe
Fe	1.2	Ar+18%CO ₂		F04	W Fe
Fe	1.4	Ar+18%CO ₂		F05	
Fe	1.6	Ar+18%CO ₂		F06	
Fe	0.8	Ar+8%CO ₂		F11	
Fe	1.0	Ar+8%CO ₂		F13	
Fe	1.2	Ar+8%CO ₂		F14	
Fe Metal	1.2	Ar+18%CO ₂		M04	
Fe Metal	1.4	Ar+18%CO ₂		M05	
Fe Metal	1.6	Ar+18%CO ₂		M06	
Fe Rutil	1.2	Ar+18%CO ₂		R04	
Fe Rutil	1.6	Ar+18%CO ₂		R06	
Fe Basic+	1.2	Ar+18%CO ₂		R64	
Fe Basic+	1.2	Ar+18%CO ₂	E 70 T-5	R74	

MatchCurve programs

MatchCurve programs must be purchased separately for each welding process. For FastMig X with MXP 37 Pipe Fe wire feeder you will need WisePulseMig licence.

Welding programs are available at DataStore
<https://datastore.kemppi.com>

Pulse / DPulse (continued)

DataStore / Power source panel	Wire Ø	Gas	Description	N:o	Package
CrNiMo 19 12	0.8	Ar+2%CO ₂		S01	SS
CrNiMo 19 12	0.9	Ar+2%CO ₂		S02	SS
CrNiMo 19 12	1.0	Ar+2%CO ₂		S03	
CrNiMo 19 12	1.2	Ar+2%CO ₂		S04	SS W
CrNiMo 19 12	1.6	Ar+2%CO ₂		S05	
CrNiMo 19 12	1.0	Ar+2%CO ₂	Soft	S06	SS W
CrNiMo 19 12	1.2	Ar+2%CO ₂	Soft	S07	
CrNiMo 19 12	1.0	Ar+He+CO ₂		S23	
CrNiMo 19 12	1.2	Ar+He+CO ₂		S24	SS
CrNiMo 19 12	1.0	Ar+He+CO ₂	Soft	S26	SS
CrNi 25 20	1.0	Ar + CO ₂	Soft	S43	
Cr21Ni10 N RE	1.0	Ar	Soft	S53	
CrNiMo 27 31 4 Cu L	1.2	Ar +30% He		S54	
CrNiMo 27 31 4 Cu L	1.0	Ar +30% He		S55	
CrNiMo 22 9 3	1.0	Ar+He+O ₂		S63	
CrNiMo 22 9 3	1.2	Ar+He+O ₂		S64	
CrNiMo 22 9 3	1.0	Ar+He+CO ₂		S66	
CrNiMo 22 9 3	1.2	Ar+He+CO ₂		S67	
CrNiMo 25 9 4	1.0	Ar+He+CO ₂		S68	
CrNiMo 25 9 4	1.2	Ar+He+CO ₂		S69	
NiCr21Mo9Nb	1.0	Ar+He+O ₂		S73	
NiCr21Mo9Nb	1.2	Ar+He+O ₂		S74	
NiCr21Mo9Nb	1.0	Ar+He+CO ₂		S76	
NiCr21Mo9Nb	1.2	Ar+He+CO ₂		S77	
NiCr21Mo9Nb	1.0	Ar	Cladding	S78	
NiCr21Mo9Nb	1.2	Ar		S79	
FC-CrNiMo 19 12	0.9	Ar + 18% CO ₂	Soft	S82	
FC-CrNiMo 19 12	1.2	Ar + 18% CO ₂	Soft	S84	
NiCr21Mo9Nb	1.2	Ar	Cladding	S93	
NiCr21Mo9Nb	1.6	Ar	Cladding	S95	
NiCr21Mo9Nb	1.6	Ar + 30% He	Cladding	S96	
CrNiMo 19 12	1.6	Ar+2% CO ₂	Cladding	S97	
Stelloy 6 BC-G	1.2	Ar	Cladding	L04	
Stelloy 6 BC-G	1.6	Ar	Cladding	L06	
CrNiMo 22 9 3	1.2	Ar	Cladding	L14	

MatchCurve programs

MatchCurve programs must be purchased separately for each welding process.

Welding programs are available at DataStore
<https://datastore.kemppi.com>

1-MIG

DataStore / Power source panel	Wire Ø	Gas	Description	N:o	Package
AlMg5	0.8	Ar		A00	
AlMg5	1.0	Ar		A01	Al
AlMg5	1.2	Ar		A02	Al W
AlMg5	1.6	Ar		A03	Al
AlSi5	1.0	Ar		A11	Al
AlSi5	1.2	Ar		A12	Al W
AlSi5	1.6	Ar		A13	Al
CuSi3	1.0	Ar		C03	
CuAl8	0.8	Ar		C11	
CuAl8	1.0	Ar		C13	
Fe	0.8	Ar+18%CO ₂		F01	Fe
Fe	0.9	Ar+18%CO ₂		F02	Fe W
Fe	1.0	Ar+18%CO ₂		F03	Fe W
Fe	1.2	Ar+18%CO ₂		F04	Fe W
Fe	1.4	Ar+18%CO ₂		F05	
Fe	1.6	Ar+18%CO ₂		F06	
Fe	1.0	Ar+18%CO ₂	Revision 2009 – 2016	F08	
Fe	1.2	Ar+18%CO ₂	Revision 2009 – 2016	F09	
Fe	0.8	Ar+8%CO ₂		F11	
Fe	0.9	Ar+8%CO ₂		F12	
Fe	1.0	Ar+8%CO ₂		F13	
Fe	1.2	Ar+8%CO ₂		F14	
Fe	1.4	Ar+8%CO ₂		F15	
Fe	0.8	CO ₂		F21	Fe
Fe	0.9	CO ₂		F22	Fe W
Fe	1.0	CO ₂		F23	Fe W
Fe	1.2	CO ₂		F24	Fe W
Fe	1.6	CO ₂		F26	
Fe Metal	1.2	Ar+18%CO ₂		M04	Fe W
Fe Metal	1.4	Ar+18%CO ₂		M05	
Fe Metal	1.6	Ar+18%CO ₂		M06	
Fe Metal	1.4	Ar+8%CO ₂		M15	
Fe Metal	1.2	CO ₂		M24	Fe W
Fe Metal	1.4	CO ₂		M25	

MatchCurve programs

MatchCurve programs must be purchased separately for each welding process.

Welding programs are available at DataStore
<https://datastore.kemppi.com>

1-MIG (continued)

DataStore / Power source panel	Wire Ø	Gas	Description	N:o	Package
Fe Rutil	1.2	Ar+18%CO ₂		R04	Fe W
Fe Rutil	1.4	Ar+18%CO ₂		R05	
Fe Rutil	1.6	Ar+18%CO ₂		R06	
Fe Rutil	1.2	CO ₂		R14	Fe W
Fe Rutil	1.6	CO ₂		R26	
Fe Rutil	1.2	Ar+18%CO ₂	E71T-9M-J	R44	
Fe	2.0	InnerShield		R47	
Fe Basic-	1.2	Ar+18%CO ₂		R54	
Fe	1.6	InnerShield	Only with FastMig X	R56	Fe
Fe	2.0	InnerShield	Only with FastMig X	R57	Fe
Fe	2.4	InnerShield	Only with FastMig X	R58	Fe
CrNiMo 19 12	0.8	Ar+2%CO ₂		S01	Ss
CrNiMo 19 12	0.9	Ar+2%CO ₂		S02	Ss
CrNiMo 19 12	1.0	Ar+2%CO ₂		S03	Ss W
CrNiMo 19 12	1.2	Ar+2%CO ₂		S04	Ss W
CrNiMo 19 12	1.6	Ar+2%CO ₂		S05	
CrNiMo 19 12	1.0	Ar+He+CO ₂		S23	
CrNiMo 19 12	1.2	Ar+He+CO ₂		S24	
FC-CrNiMo 25 9 4	1.2	Ar+18%CO ₂		S70	
FC-NiCr21Mo9Nb	1.2	Ar+18%CO ₂		S80	
FC-CrNiMo 19 12	0.9	Ar+18%CO ₂		S82	
FC-CrNiMo 19 12	1.2	Ar+18%CO ₂		S84	Ss W
FC-CrNiMo 19 12	1.2	CO ₂		S85	Ss
FC-CrNiMo 22 9 3	1.2	Ar+18%CO ₂		S86	
MC-CrNiMo 19 12	1.2	Ar+2%CO ₂		S87	Ss

MatchCurve programs

MatchCurve programs must be purchased separately for each welding process.

Welding programs are available at DataStore
<https://datastore.kemppi.com>

WiseRoot

DataStore / Power source panel	Wire Ø	Gas	Description	N:o	Package
Fe	0.8	Ar+18%CO ₂		F01	
Fe	0.9	Ar+18%CO ₂		F02	
Fe	1.0	Ar+18%CO ₂		F03	
Fe	1.2	Ar+18%CO ₂		F04	
Fe	1.0	Ar+8%CO ₂		F13	
Fe	1.2	Ar+8%CO ₂		F14	
Fe	0.9	CO ₂		F22	
Fe	1.0	CO ₂		F23	
Fe	1.2	CO ₂		F24	
Fe Metal	1.2	Ar+18%CO ₂		M04	
CrNiMo 19 12	0.8	Ar+2%CO ₂		S01	
CrNiMo 19 12	0.9	Ar+2%CO ₂		S02	
CrNiMo 19 12	1.0	Ar+2%CO ₂		S03	
CrNiMo 19 12	1.2	Ar+2%CO ₂		S04	
CrNiMo 19 12	0.9	Ar+He+O ₂		S12	
CrNiMo 19 12	1.0	Ar+He+O ₂		S13	
CrNiMo 19 12	1.2	Ar+He+O ₂		S14	
CrNiMo 19 12	1.0	Ar+He+CO ₂		S23	
CrNiMo 22 9 3	1.0	Ar+He+CO ₂		S66	
NiCr21Mo9Nb	1.0	Ar+He+CO ₂		S76	

WiseThin

DataStore / Power source panel	Wire Ø	Gas	Description	N:o	Package
CuSi3	1.0	Ar		C03	
CuAl8	1.0	Ar		C13	
Fe	0.8	Ar+18%CO ₂		F01	
Fe	0.9	Ar+18%CO ₂		F02	
Fe	1.0	Ar+18%CO ₂		F03	
Fe	1.2	Ar+18%CO ₂		F04	
Fe	0.8	CO ₂		F21	
Fe	0.9	CO ₂		F22	
Fe	1.0	CO ₂		F23	
Fe	1.2	CO ₂		F24	
CrNiMo 19 12	0.8	Ar+2%CO ₂		S01	
CrNiMo 19 12	0.9	Ar+2%CO ₂		S02	
CrNiMo 19 12	1.0	Ar+2%CO ₂		S03	
CrNiMo 19 12	1.2	Ar+2%CO ₂		S04	

MatchCurve programs

Welding programs are available at DataStore
<https://datastore.kemppi.com>

MatchCurve programs must be purchased separately for each welding process.

WiseRoot+

DataStore / Power source panel	Wire Ø	Gas	Description	N:o	Package
Fe	0.8	Ar+18%CO ₂		F01	Ⓢ
Fe	0.9	Ar+18%CO ₂		F02	Ⓢ
Fe	1.0	Ar+18%CO ₂		F03	Ⓢ
Fe	1.2	Ar+18%CO ₂		F04	Ⓢ
Fe	1.14	Ar+8%CO ₂		F07	
Fe	0.8	CO ₂		F21	Ⓢ
Fe	0.9	CO ₂		F22	Ⓢ
Fe	1.0	CO ₂		F23	Ⓢ
Fe	1.2	CO ₂		F24	Ⓢ
Fe	1.14	CO ₂		F27	
Fe Metal	1.2	Ar+18%CO ₂		M04	Ⓢ
Fe Metal	1.2	CO ₂		M24	Ⓢ
CrNiMo 19 12	0.8	Ar+2%CO ₂		S01	Ⓢ
CrNiMo 19 12	0.9	Ar+2%CO ₂		S02	Ⓢ
CrNiMo 19 12	1.0	Ar+2%CO ₂		S03	Ⓢ
CrNiMo 19 12	1.2	Ar+2%CO ₂		S04	Ⓢ
CrNi 23 12	1.0	Ar+2%CO ₂	Dissimilar	S33	
CrNi 23 12	1.2	Ar+2%CO ₂	Dissimilar	S34	
CrNiMo 22 9 3	1.0	Ar+He+ CO ₂		S66	
CrNiMo 22 9 3	1.2	Ar+He+ CO ₂		S67	
CrNiMo 25 9 4	1.0	Ar+He+ CO ₂		S68	
CrNiMo 25 9 4	1.2	Ar+He+ CO ₂		S69	
NiCr21Mo9Nb	1.0	Ar+He+ CO ₂		S76	
NiCr21Mo9Nb	1.2	Ar+He+ CO ₂		S77	

WiseThin+

DataStore / Power source panel	Wire Ø	Gas	Description	N:o	Package
CuSi3	1.0	Ar		C03	
Fe	0.8	Ar+18%CO ₂		F01	Ⓢ
Fe	0.9	Ar+18%CO ₂		F02	Ⓢ
Fe	1.0	Ar+18%CO ₂		F03	Ⓢ
Fe	1.2	Ar+18%CO ₂		F04	Ⓢ
Fe	0.8	CO ₂		F21	Ⓢ
Fe	0.9	CO ₂		F22	Ⓢ
Fe	1.0	CO ₂		F23	Ⓢ
Fe	1.2	CO ₂		F24	Ⓢ
CrNiMo 19 12	0.8	Ar+2%CO ₂		S01	
CrNiMo 19 12	0.9	Ar+2%CO ₂		S02	
CrNiMo 19 12	1.0	Ar+2%CO ₂		S03	
CrNiMo 19 12	1.2	Ar+2%CO ₂		S04	

MatchCurve programs

MatchCurve programs must be purchased separately for each welding process.

Welding programs are available at DataStore
<https://datastore.kemppi.com>

Pulse / DPulse

DataStore / Power source panel	Wire Ø	Gas	Description	N:o	Package
AlMg5	1.0	Ar	Automation	A101	
AlMg5	1.2	Ar	Automation	A102	
AlSi5	1.2	Ar	Automation	A112	
CuSi3	1.0	Ar	Automation	C103	
CuAl8	1.0	Ar	Automation	C113	
Fe	1.0	Ar+18%CO ₂	Automation	F103	
Fe	1.2	Ar+18%CO ₂	Automation	F104	
Fe Metal	1.2	Ar+18%CO ₂	Automation	M104	
Fe Rutil	1.2	Ar+18%CO ₂	Automation	R104	
CrNiMo 19 12	0.8	Ar+2% CO ₂	Automation	S101	
CrNiMo 19 12	0.9	Ar+2% CO ₂	Automation	S102	
CrNiMo 19 12	1.2	Ar+2% CO ₂	Automation	S104	
CrNiMo 19 12	1.0	Ar+2% CO ₂	Automation	S106	
CrNiMo 19 12	1.2	Ar+He+CO ₂	Automation	S124	
CrNiMo 19 12	1.0	Ar+He+CO ₂	Automation	S126	

1-MIG

DataStore / Power source panel	Wire Ø	Gas	Description	N:o	Package
CuSi3	1.0	Ar	Automation	C103	
CuAl8	1.0	Ar	Automation	C113	
Fe	1.0	Ar+18%CO ₂	Automation	F103	
Fe	1.2	Ar+18%CO ₂	Automation	F104	
Fe	1.0	CO ₂	Automation	F123	
Fe	1.2	CO ₂	Automation	F124	

Standard built-in welding programs

1-MIG

Welding program number shown in panel

Fe -group	Wire [mm]	Material	Shielding gas
101	0.8	Fe	Ar+18%CO ₂
102	0.9	Fe	Ar+18%CO ₂
103	1.0	Fe	Ar+18%CO ₂
104	1.2	Fe	Ar+18%CO ₂
106	1.6	Fe	Ar+18%CO ₂
111	0.8	Fe	CO ₂
112	0.9	Fe	CO ₂
113	1.0	Fe	CO ₂
114	1.2	Fe	CO ₂
116	1.6	Fe	CO ₂
121	0.8	Fe	Ar+8%CO ₂
122	0.9	Fe	Ar+8%CO ₂
123	1.0	Fe	Ar+8%CO ₂
124	1.2	Fe	Ar+8%CO ₂
126	1.6	Fe	Ar+8%CO ₂
152	0.9	Fe Metal	Ar+18%CO ₂
154	1.2	Fe Metal	Ar+18%CO ₂
164	1.2	Fe Metal	CO ₂
174	1.2	Fe Rutil	Ar+18%CO ₂
184	1.2	Fe Rutil	CO ₂
194	1.2	Fe Basic	Ar+18%CO ₂

Al -group	Wire [mm]	Material	Shielding gas
303	1.0	AlMg 5	Ar
304	1.2	AlMg 5	Ar
306	1.6	AlMg 5	Ar
313	1.0	AlSi 5	Ar
314	1.2	AlSi 5	Ar
316	1.6	AlSi 5	Ar

SPE -group	Wire [mm]	Material	Shielding gas
401	0.8	CuSi 3	Ar
402	0.9	CuSi 3	Ar
403	1.0	CuSi 3	Ar
404	1.2	CuSi 3	Ar
411	0.8	CuSi 3	Ar+2% CO ₂
412	0.9	CuSi 3	Ar+2% CO ₂
413	1.0	CuSi 3	Ar+2% CO ₂
421	0.8	CuAl 8	Ar
423	1.0	CuAl 8	Ar
424	1.2	CuAl 8	Ar

Ss -group	Wire [mm]	Material	Shielding gas
201	0.8	CrNiMo 19 12	Ar+2%CO ₂
202	0.9	CrNiMo 19 12	Ar+2%CO ₂
203	1.0	CrNiMo 19 12	Ar+2%CO ₂
204	1.2	CrNiMo 19 12	Ar+2%CO ₂
206	1.6	CrNiMo 19 12	Ar+2%CO ₂
211	0.8	CrNiMo 19 12	Ar+30%He+1%O ₂
212	0.9	CrNiMo 19 12	Ar+30%He+1%O ₂
213	1.0	CrNiMo 19 12	Ar+30%He+1%O ₂
214	1.2	CrNiMo 19 12	Ar+30%He+1%O ₂
216	1.6	CrNiMo 19 12	Ar+30%He+1%O ₂
221	0.8	CrNi 23 12	Ar+2%CO ₂
222	0.9	CrNi 23 12	Ar+2%CO ₂
223	1.0	CrNi 23 12	Ar+2%CO ₂
224	1.2	CrNi 23 12	Ar+2%CO ₂
231	0.8	CrNi 23 12	Ar+30%He+1%O ₂
232	0.9	CrNi 23 12	Ar+30%He+1%O ₂
233	1.0	CrNi 23 12	Ar+30%He+1%O ₂
234	1.2	CrNi 23 12	Ar+30%He+1%O ₂
242	0.9	FC-CrNiMo 19 12	Ar+18%-25%CO ₂
244	1.2	FC-CrNiMo 19 12	Ar+18%-25%CO ₂
252	0.9	FC-CrNiMo 19 12	CO ₂
254	1.2	FC-CrNi 2312	Ar+18%CO ₂

Standard built-in welding programs

Note! WiseThin and WiseRoot process must be purchased before programs are shown

WiseThin

Welding program number shown in panel

Fe -group	Wire [mm]	Material	Shielding gas	Ss -group	Wire [mm]	Material	Shielding gas
701	0.8	Fe	Ar+18%CO ₂	721	0.8	CrNiMo 19 12	Ar+2%CO ₂
702	0.9	Fe	Ar+18%CO ₂	722	0.9	CrNiMo 19 12	Ar+2%CO ₂
703	1.0	Fe	Ar+18%CO ₂	723	1.0	CrNiMo 19 12	Ar+2%CO ₂
704	1.2	Fe	Ar+18%CO ₂	724	1.2	CrNiMo 19 12	Ar+2%CO ₂
711	0.8	Fe	CO ₂				
712	0.9	Fe	CO ₂				
713	1.0	Fe	CO ₂				
714	1.2	Fe	CO ₂				
				Cu -group	Wire [mm]	Material	Shielding gas
				743	1.0	CuSi 3	Ar
				753	1.0	CuAl 8	Ar

WiseRoot for FastMig Synergic and KempArc

Fe -group	Wire [mm]	Material	Shielding gas	Ss -group	Wire [mm]	Material	Shielding gas
802	0.9	Fe	Ar+18%CO ₂	822	0.9	CrNiMo 19 12	Ar+2%CO ₂
803	1.0	Fe	Ar+18%CO ₂	823	1.0	CrNiMo 19 12	Ar+2%CO ₂
804	1.2	Fe	Ar+18%CO ₂	824	1.2	CrNiMo 19 12	Ar+2%CO ₂
812	0.9	Fe	CO ₂	832	0.9	CrNiMo 19 12	Ar+30%He+1%O ₂
813	1.0	Fe	CO ₂	833	1.0	CrNiMo 19 12	Ar+30%He+1%O ₂
814	1.2	Fe	CO ₂	834	1.2	CrNiMo 19 12	Ar+30%He+1%O ₂

WiseRoot for FastMig M

Fe -group	Wire [mm]	Material	Shielding gas	Ss -group	Wire [mm]	Material	Shielding gas
802	0.9	Fe	Ar+18%CO ₂	822	0.9	CrNiMo 19 12	Ar+2%CO ₂
803	1.0	Fe	Ar+18%CO ₂	823	1.0	CrNiMo 19 12	Ar+2%CO ₂
804	1.2	Fe	Ar+18%CO ₂	824	1.2	CrNiMo 19 12	Ar+2%CO ₂
				832	0.9	CrNiMo 19 12	Ar+30%He+1%O ₂
				833	1.0	CrNiMo 19 12	Ar+30%He+1%O ₂
				834	1.2	CrNiMo 19 12	Ar+30%He+1%O ₂

MatchCurve programs

Welding programs are available at DataStore
<https://datastore.kemppi.com>

1-MIG

Welding program number shown in panel

Fe	Wire [mm]	Material	Shielding gas	
20	2.0	Fe	Inner shield (*)	E71T8-Ni1
21	2.0	Fe	Inner shield (**)	E71T8-Ni1, E81T8
23	1.2	Fe Rutil	CO ₂	E 71T-1
24	1.2	Fe Rutil	Ar+18%CO ₂	E 71 T-1/-1M
25	1.4	Fe Metal	Ar+18%CO ₂	E 70C-6M
26	1.2	Fe Rutil	Ar+18%CO ₂	E 71 T-1
27	1.2	Fe Rutil	Ar+18%CO ₂	E 81T1-G
28	1.2	Fe Rutil	CO ₂	E 71T-1J
29	1.2	Fe Basic	CO ₂	E 71 T-5
30	1.4	Fe Basic	CO ₂	E 70 T-5J H4
31	1.2	Fe Basic	Ar+18%CO ₂	E 71 T-5
32	1.4	Fe Basic	Ar+18%CO ₂	E 70 T-5J H4
33	1.4	Fe	Ar+18%CO ₂	E71T8
35	1.6	Fe Basic	CO ₂	E71T-5
36	1.6	Fe	Inner shield	E71T8
37	1.2	Fe Metal	Ar+18%CO ₂	E70C-G
38	1.2	Fe Rutil	Ar+18%CO ₂	E71T-9M-J
41	1.6	Fe Metal	Ar+18%CO ₂	E 70 C-6M
43	1.0	Fe	Ar+18%CO ₂	E 70 S-6
53	1.0	Fe	CO ₂	E 70 S-6
54	1.2	Fe	CO ₂	E 70 S-6

* All positions except vertical down

** Vertical down

Stainless Steel	Wire [mm]	Material	Shielding gas	
44	1.2	Ss-2209	Ar+2%O ₂	CrNiMo23 9 3
45	1.2	FC-2209	Ar+18%CO ₂	CrNiMo23 9 3
46	1.2	FC-625	Ar+18%CO ₂	NiCr21Mo9Nb
48	1.2	FC-316	CO ₂	CrNiMo 19 12
52	1.2	FC-2209	CO ₂	CrNiMo23 9 3

Cu	Wire [mm]	Material	Shielding gas	
50	1.0	CuAl8	Ar	AIBZ8
51	1.0	CuAl9Fe	Ar	AIBZ9Fe

Welding programs are available at DataStore
<https://datastore.kemppi.com>

WiseThin

Welding program number shown in panel

WiseThin MatchCurve	Wire [mm]	Material	Shielding gas	
60	1.0	CuSi3	Ar	Soft
61	1.0	CuAl8	Ar	AlBZ8
62	1.0	CuAl9Fe	Ar	AlBZ9Fe

WiseRoot

Welding program number shown in panel

WiseRoot MatchCurve	Wire [mm]	Material	Shielding gas	Application
71	0.8	Fe	Ar+18%CO ₂	
72	0.8	Fe	Ar+8%CO ₂	
73	0.9	Fe	Ar+8%CO ₂	
74	1.0	Fe	Ar+8%CO ₂	
75	1.2	Fe	Ar+8%CO ₂	
76	1.14	Fe	Ar+18%CO ₂	
77	1.14	Fe	CO ₂	
78	0.9	Fe	CO ₂	
79	1.0	Fe	CO ₂	
80	1.2	Fe	CO ₂	
81	0.8	Ss-316	Ar+2%CO ₂	CrNiMo 19 12
82	1.0	Fe Ni based	Ar+18%CO ₂	E80S-Ni1
83	1.0	Fe Union X96	Ar+18%CO ₂	E120S-G
84	0.9	9CrMoV-N	Ar+18%CO ₂	E90S-B9
85	1.2	Fe Metal	Ar+18%CO ₂	E70C 6M 6C
86	1.6	ARNCO 300 XT	Ar+18%CO ₂	Cladding
87	1.2	Fe heat resisting steel	Ar+18%CO ₂	E90C-B3H4
90	1.0	Ss-316	Ar+3%CO ₂ +2%N ₂	CrNiMo 19 12
91	1.2	Ss-316	Ar+3%CO ₂ +2%N ₂	CrNiMo 19 12
92	0.8	Ss-316	Ar+30%He+2%CO ₂	CrNiMo 19 12
93	1.0	Ss-316	Ar+30%He+2%CO ₂	CrNiMo 19 12
94	1.0	Ss-316	Ar+30%He+2%CO ₂	CrNiMo 19 12 Backing gas N ₂
95	1.0	Ss-2209	Ar+30%He+0.5%CO ₂	CrNiMo 23 9 3
96	1.0	Ss-625	Ar+30%He+0.5%CO ₂	NiCr21Mo9Nb
97	1.0	Ss-2209	Ar+30%He+2%CO ₂	CrNiMo 23 9 3
98	1.0	Ss-2209	Ar+2%CO ₂	CrNiMo 23 9 3
99	1.0	Ss-904SLX	Ar+30%He+2%CO ₂	CrNiMo 20 25 5 Cu

Ordering information

MatchCurve, Welding Program

MatchCurves and Welding Program are readily available welding software for:

- FastMig Synergic
- FastMig Pulse
- FastMig M
- FastMig X
- KempArc
- KempArc Pulse
- A7 MIG Welder
- X8 MIG Welder

These welding programs can be purchased separately at Kemppi DataStore and installed to compatible equipment via the Kemppi DataGun or Mobile Maintenance. MIG/MAG welding programs are made for different parent materials, wire diameters and gas combinations.

Product	Ordering code
MatchCurve	9990401
MatchCustom	9990402

MatchCustom, Welding Program -t

MatchCustom and Welding Program -t is a bespoke welding software service for:

- FastMig Syn
- FastMig Pulse
- FastMig M
- FastMig X
- KempArc
- KempArc Pulse
- A7 MIG Welder
- X8 MIG Welder

MatchCustom or Welding Program -t are ordered via a Kemppi sales or Kemppi welding services by customers requiring software that suit materials or filler wires not readily available at Kemppi Datastore. The delivery routine for MatchCustom is via DataStore and downloading to compatible equipment is via DataGun or Mobile Maintenance.