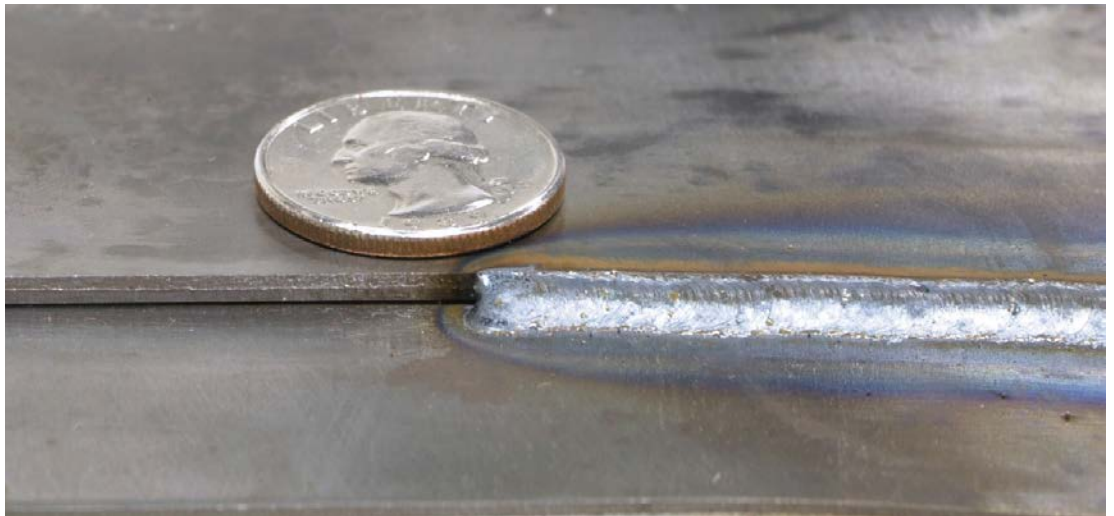


# AC-STT™

## The Superior Thin-Gauge Solution

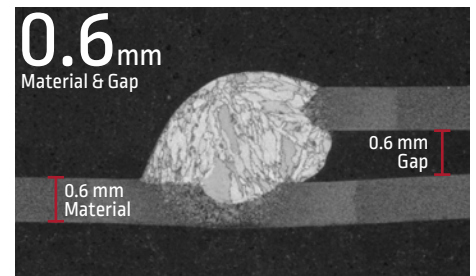
Based off of the patented STT® (Surface Tension Transfer) process, AC-STT™ combines the proven spatter-reducing technology of the STT® waveform with the balanced heat-input characteristics of AC GMAW, producing an advanced short-circuit process optimized specifically for thin-gauge materials.



AC-STT™ - the advanced short-circuit process optimized specifically for thin-gauge materials

### Ultra-Reliable on Ultra-Thin

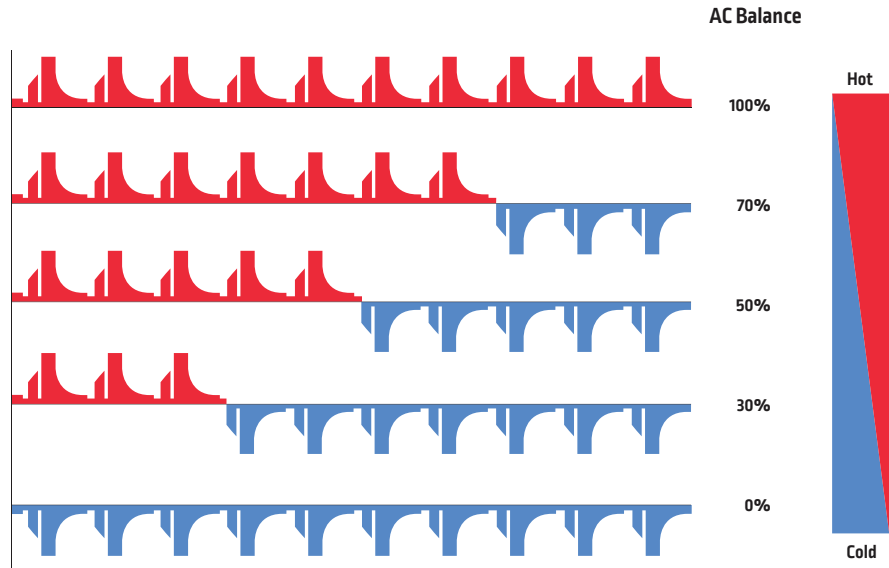
By continuously switching the waveform polarity, AC-STT™ provides maximum heat-input control while still maintaining high deposition rates, allowing for high-quality, repeatable welds on materials as thin as 0.6mm with excellent gap-bridging capabilities.



AC-STT™ accommodates materials as thin as 0.6 mm - with or without gap conditions

## Customized Penetration Profile

Utilizing Lincoln Electric's Waveform Control Technology®, operators can easily balance the waveform's ratio of DC+ or DC- polarity, allowing for a customized penetration profile that can accommodate a broad range of material thicknesses.



The duration of welding in positive or negative polarity can be directly controlled by the operator.

## The Lincoln Electric Solution

Equipment	Weld Process*
Power Wave® S500 and R450 with Power Wave® Advance Module	AC-STT
Power Feed® 84	
AutoDrive® 4R100	
AutoDrive® 4R220	
AutoDrive® S	
AutoDrive® SA	

\* Available as a FREE weld set update for current Power Wave S500 and R450 owners. Download at [www.powerwavesoftware.com](http://www.powerwavesoftware.com)

### LEGAL DISCLAIMER

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application.

These sample test results for elemental fume chemistry were obtained from welding fume produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application. Actual results will vary depending on many factors, including, but not limited to: the base material or substrate being welded, the welding procedure and welding process, and the unique conditions present in the workplace or welding environment. Users and employers have the sole responsibility for and control over workplace conditions, including the manner in which work is performed and the safety measures taken. Always read and follow applicable OSHA regulations as well as all information on product labeling and safety data sheets when using Lincoln Electric products. Safety data sheets for Lincoln Electric products can be found at <http://www.lincolnelectric.com/en-us/support/msds/Pages/sds-search.aspx>. Users and employers should have an industrial hygienist check worker exposure levels to be certain that they are within applicable OSHA PEL and ACGIH TLV limits for the particular application or weldment.

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The product performance data of this brochure and related attachments are from LINCOLN ELECTRIC application engineering laboratory. Except for special instructions, experiments on welding machines are conducted in accordance with the general standard of IEC60974-1; experiments on welding consumables are conducted in accordance with the general standard of AWS; for specific applicable standards on welding consumables please refer to the product page. The product performance data of this website and related attachments are from LINCOLN ELECTRIC American application engineering laboratory.