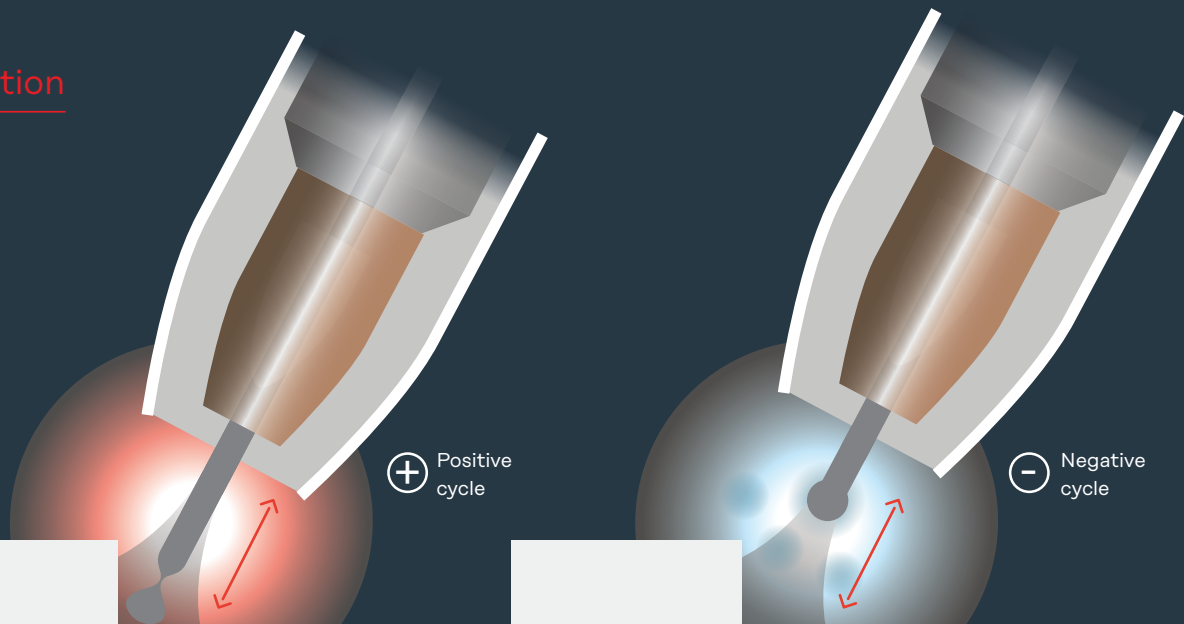


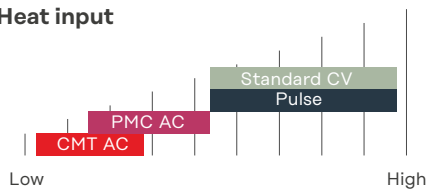
# CMT AC



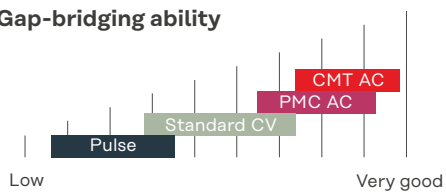
The Fronius solution  
for even lower  
heat input



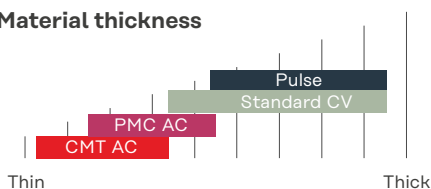
## Heat input



## Gap-bridging ability



## Material thickness



CMT AC is a MIG/MAG welding process  
in which the polarity of the wire electrode  
is reversed.

The CMT AC process achieves a remarkably low heat input with the same deposition rate by reversing the wire movement and the polarity of the wire electrode. With this technology, you can easily adjust the positive and negative components with the help of correction parameters and thus achieve extremely precise control over the heat input.



CMT AC is available on the **iWave AC/DC** with **Multiprocess Pro**.

For further information visit: [www.fronius.com](http://www.fronius.com)

# Overview and features

## Application

- Thin and ultra-thin metal sheets
- Automobile industry
- Additive welding

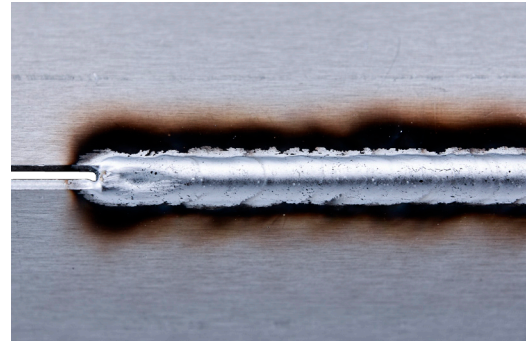


CMT AC

Base material: AlMg3;  
 Filler metal: AlMg4.5;  
 Sheet thickness: 1.5 mm; Air gap: 1.5 mm.

## Advantages

- CMT AC is the Fronius process with the lowest heat input
- Excellent gap-bridging ability
- Perfectly suited to additive welding
- Maximum controllable heat input, especially for additive manufacturing processes
- Gleaming welds due to reduced magnesium oxides (for AlMg wires)
- Process with the lowest welding fume emissions



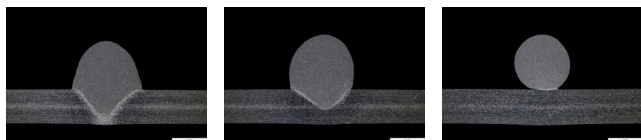
CMT DC+

# Precise adaptation of the heat input to your requirements

The correction parameters AC Power Balance (for aluminum) and Positive & Negative Cycle (for steel/CrNi-steel) allow precise adjustment of the heat input to the specific requirements of each application.

## Correction parameters

### Aluminum – AC Power Balance



+10

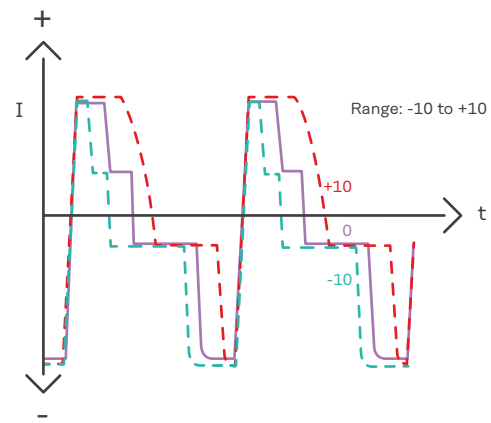
An increase in the correction leads to a bigger positive phase ratio and thus a higher heat input.

0

Default setting

-10

A reduction in the correction leads to a bigger negative phase ratio and thus a lower heat input.



## Steel/CrNi-steel – Positive & Negative Cycle

Range: 1 to 100

