



INVEST IN THE FUTURE

MIG-MAG SYNERGIES

GYS expertise, at your service



Synergic mode

A synergy is a welding aid that facilitates the adjustment of welding power sources.

After entering 4 pieces of data:

- 1 Material/gas
- 2 Wire diameter
- 3 Welding mode
- 4 Thickness

The product automatically determines the ideal welding parameters and allows you to adjust the settings (wire feed speed, voltage, current, arc length).

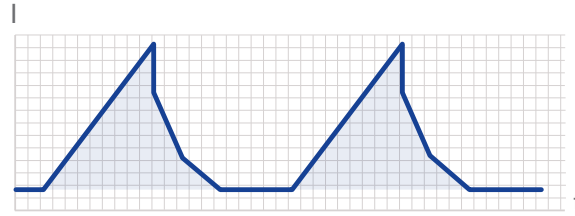
This eliminates time-consuming adjustments, and optimises the welding process.



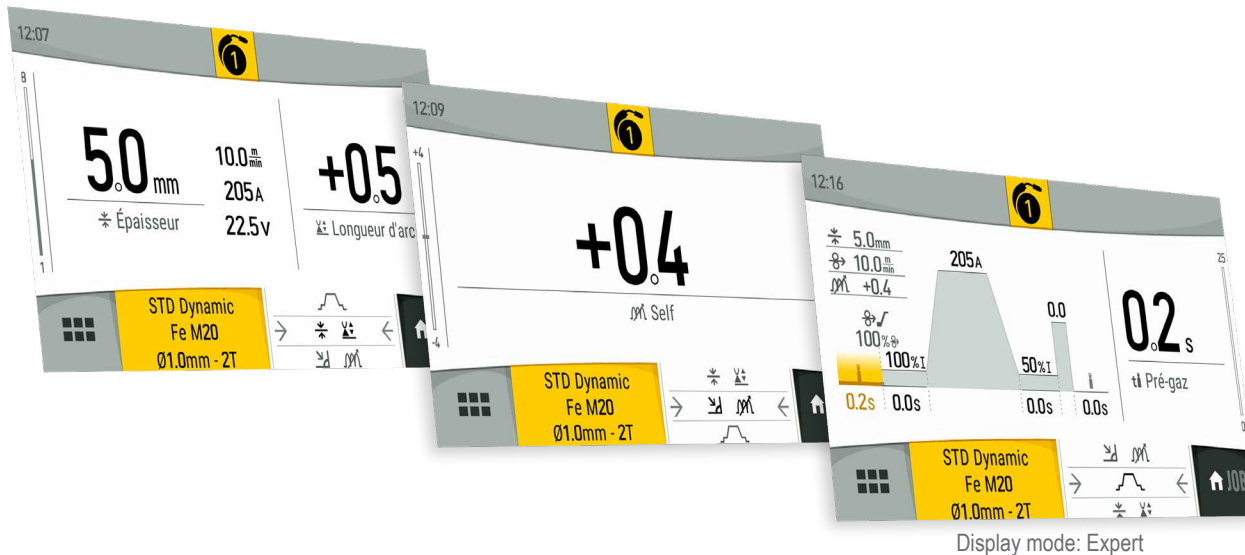
Welding mode #1

DYNAMIC STANDARD

Universal mode, high speed,
very compact



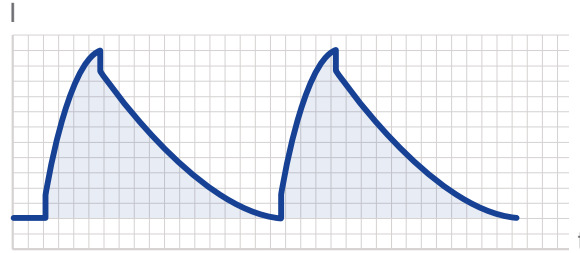
- Fully controlled and adaptive short circuit speed for easy welding
- Reduces globular phase and increases speed
- Quality weld in all positions
- Ideal for root passes on carbon and stainless steels
- Low spatter rate
- Excellent arc stability
- Range of use: 0.8 mm to 30 mm and more



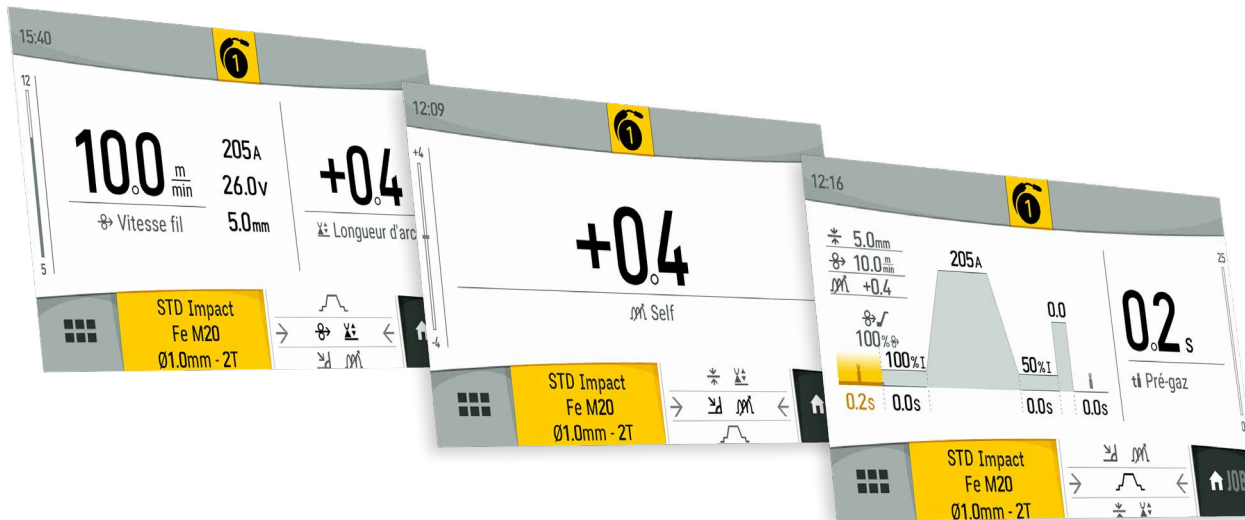
Welding mode #2

STANDARD IMPACT

Concentrated electric arc,
deep penetration



- Ideal for carbon steels
- High productivity, high welding speed
- Stable arc, low spatter, high deposition rate
- Ideal for multi-pass welding applications
- High heat transfer to the metal for a wide, smooth weld pool
- Application range: 1.5 mm to 30 mm and more



Display mode: Expert



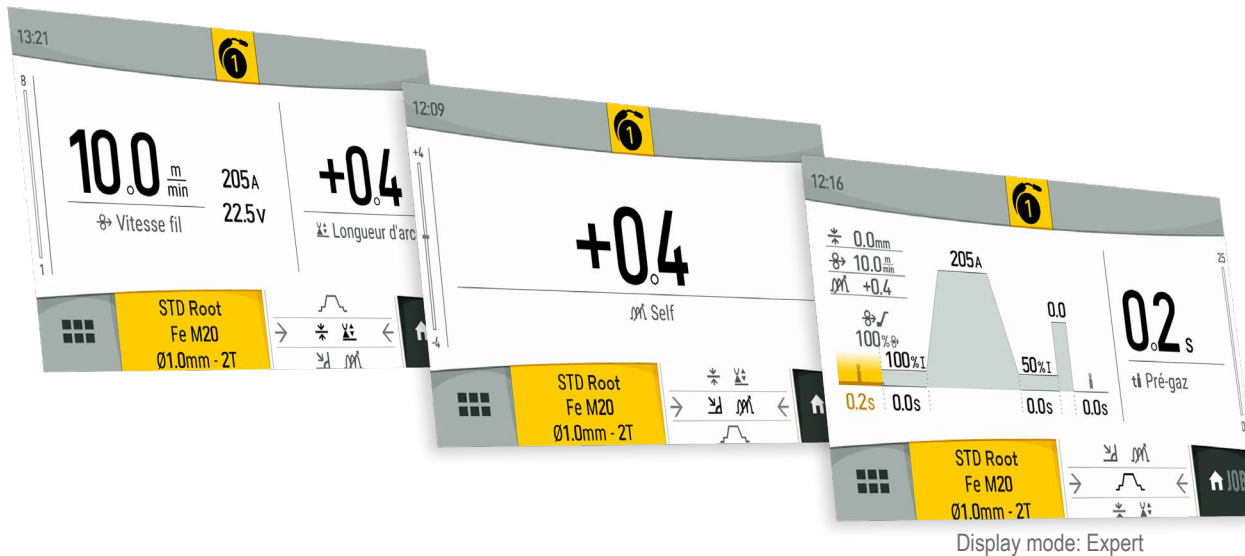
Welding mode #3

STANDARD ROOT

Bevel/chamfer root pass



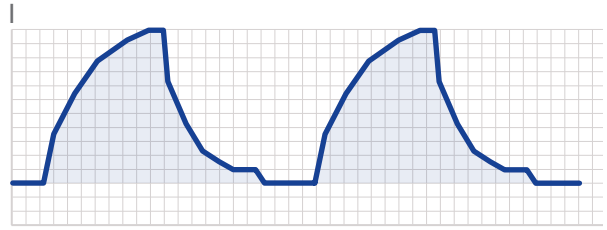
- Welding with penetration control
- Simplified welding of a root pass, without support, in all positions.
- Wider bead, flat root, superior fusion
- Used for pipeline welding
- Range of use: 0.5 mm to 5 mm



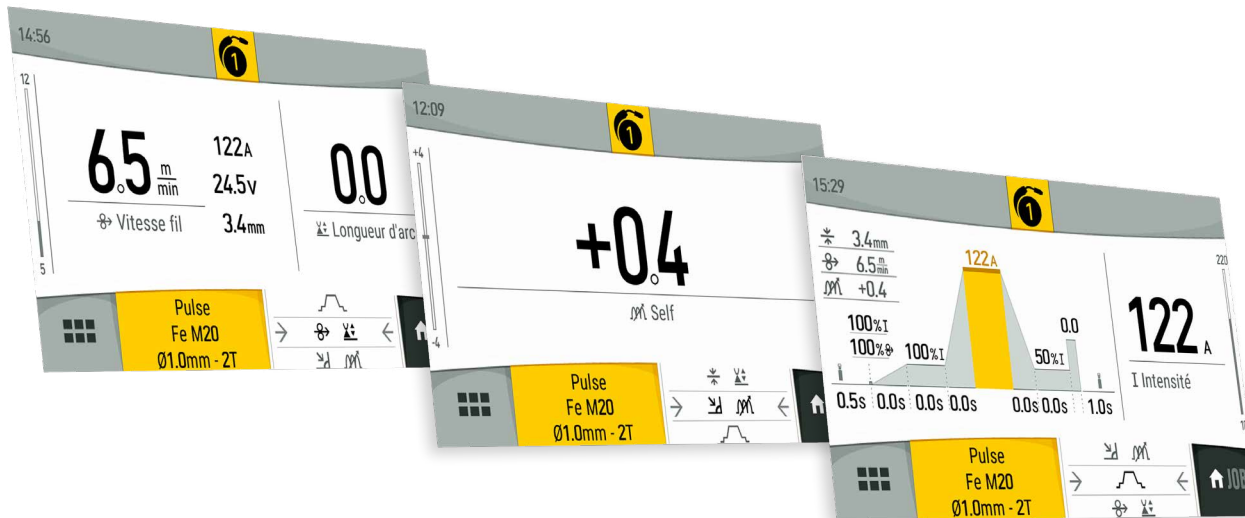
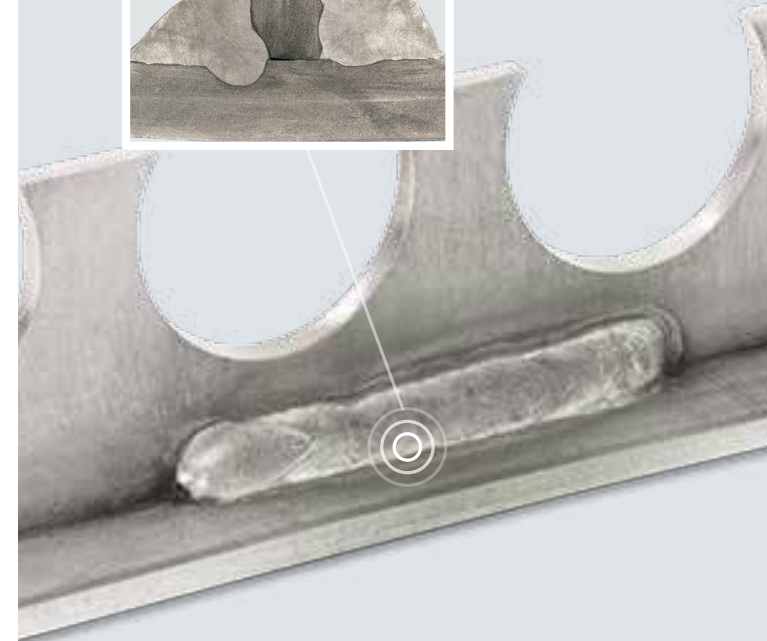
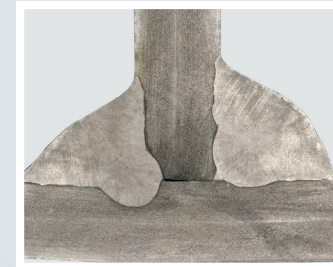
Welding mode #4

PULSE

Easy to control in all positions,
low spatter



- High quality joints with minimal finishing
- More concentrated, lower heat input into the workpiece
- Less distortion
- No final bead crater and no cold weld
- TIG appearance weld beads with 5 times higher productivity
- Excellent arc stability
- Application range: 0.8 mm to 30 mm and more

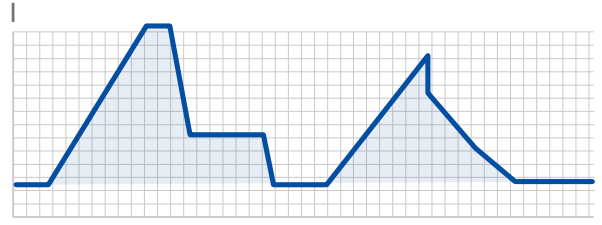


Display mode: Expert

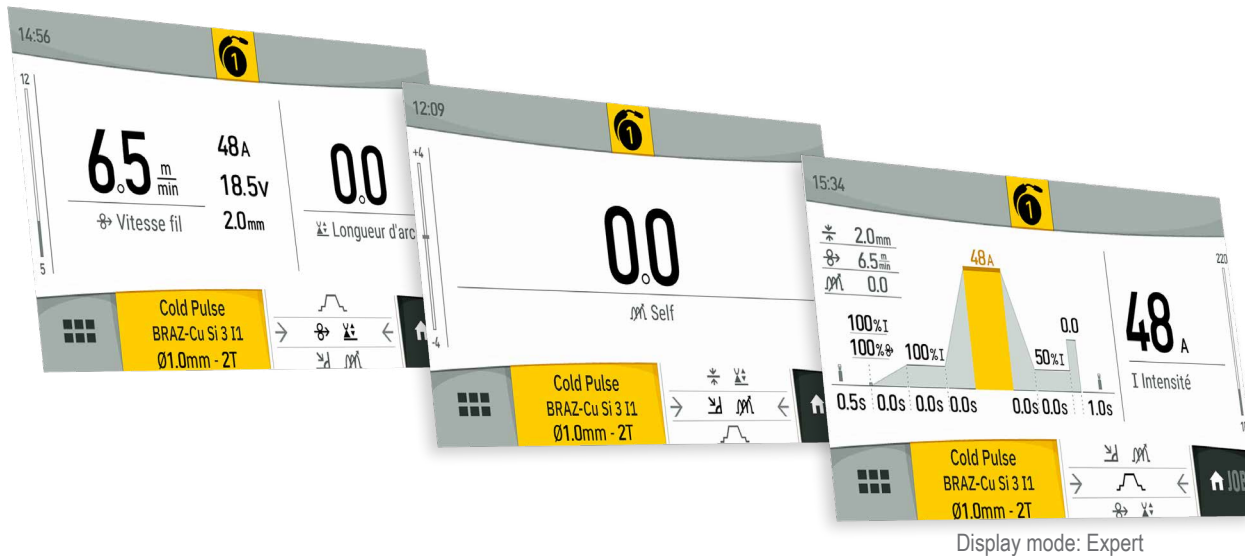
Welding mode #5

COLD PULSE

Very low heat input, spatter-free brazing



- Mode developed specifically for automotive manufacturers
- Extremely stable arc, ideal for thin sheets in all positions
- For brazing galvanised sheet metal with copper-silicon alloy filler wire
- Extremely low sheet deformation
- Compliance with manufacturer approvals
- Application range: 0.5 mm to 3 mm

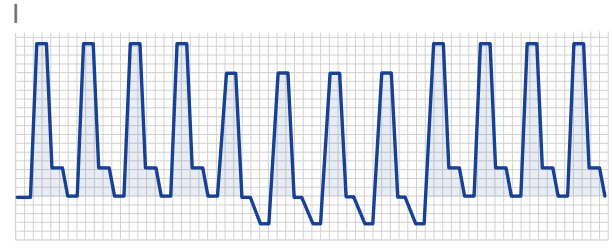


Welding mode #6

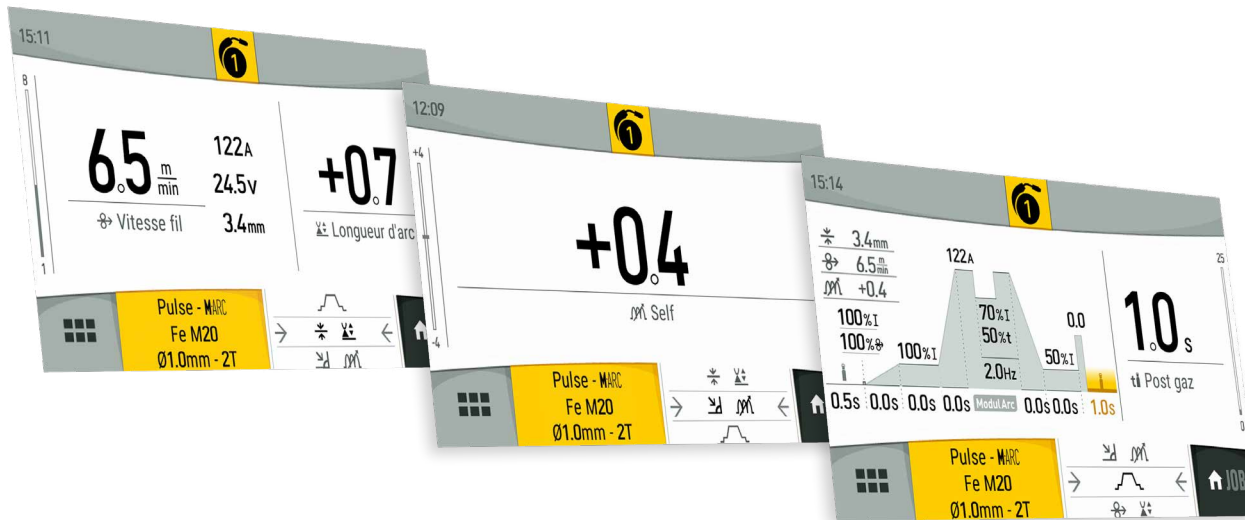
MODULARC

TIG appearance

MIG productivity



- Excellent welding quality in all positions
- Aesthetically superior weld beads
- Excellent control of heat input
- High productivity on aluminium
- Improved weld pool control for better operator comfort
- Range of use: 0.8 mm to 30 mm and more



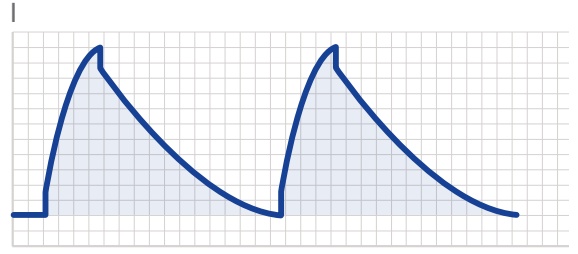
Display mode: Expert



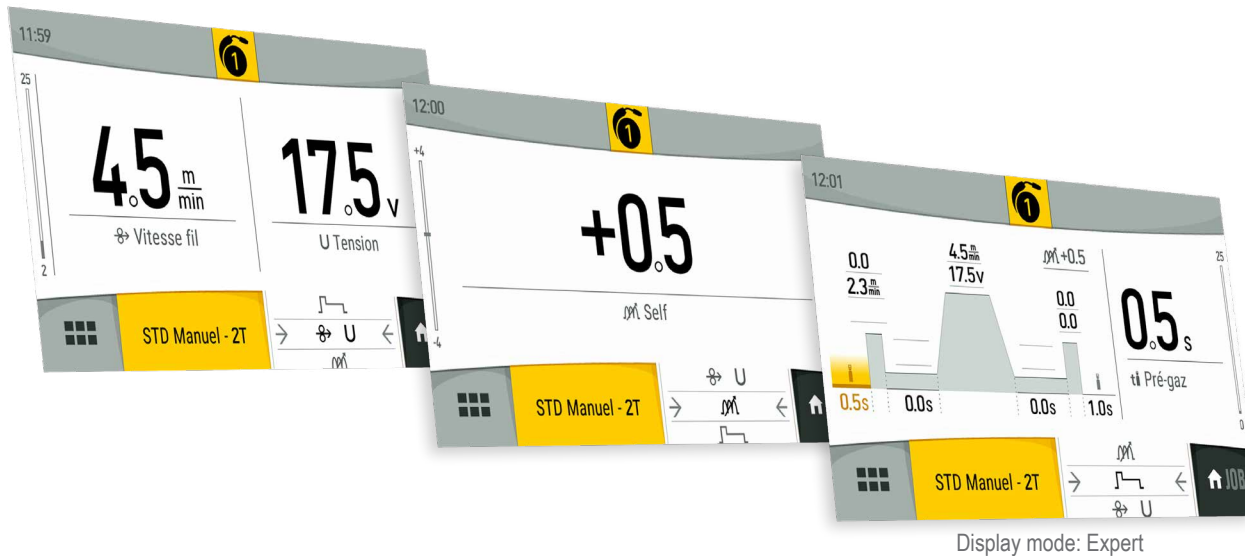
Welding mode #7

MANUAL

Simple and effective
Suitable for all wire



- Suitable for most welding applications
- Manual adjustment of wire voltage/speed and choke if required
- Ideal for welding on carbon steel
- Suitable for experienced welders and DMOS welding
- Operating range: 1mm to 30mm

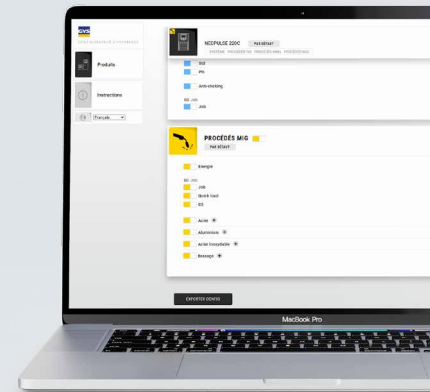
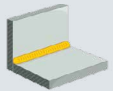


			DYNAMIC STANDARD				STANDARD IMPACT		STANDARD ROOT		PULSE			COLD PULSE	
Welding mode			0,6	0,8	1,0	1,2	0,8	1,0	0,8	1,0	0,8	1,0	1,2	0,8	1,0
Wire diameter			PB												
Welding position			PB												
Code synergie			006	008	010	012	708	710	108	110	508	510	512	608	610
STEEL	101	Fe Ar 15-20%Co2	M21	✓	✓	✓		✓	✓	✓	✓				
	102	Fe Ar 8-10%Co2	M20	✓	✓	✓			✓	✓	✓	✓			
	103	Fe 100%Co2	C1	✓	✓	✓			✓	✓					
	107	Mn4Ni3CrMo Ar 15-20%Co2	M21		✓						✓				
	108	Fe Ar 25%Co2	M21	✓	✓	✓					✓	✓			
ALUMINIUM	201	Al Mg 5 Ar 100%	I1		✓	✓	✓				✓	✓	✓		
	202	Al Mg 3 Ar 100%	I1		✓	✓	✓				✓	✓	✓		
	203	Al Si 5 Ar 100%	I1		✓	✓	✓				✓	✓	✓		
	204	Al Si 12 Ar 100%	I1		✓	✓	✓								
	206	Al Mg 2,7 Mn Ar100%	I1				✓						✓		
	207	Al Si 10 Cu 4 100%	I1				✓						✓		
	208	AlMg 4,5Mn 10-20%He	I3			✓	✓								
	209	AlMg 4,5Mn 100% Ar	I1			✓	✓								
	210	Al Mg 5 Ar 10-20%He	I3			✓	✓								
	211	Al Mg 3 Ar 10-20%He	I3			✓	✓								
	STAINLESS STEEL	301	Cr Ni 308 Ar 2%Co2	M12		✓	✓					✓	✓		
302		Cr Ni 316 Ar 2%Co2	M12		✓	✓					✓	✓			
303		Cr Ni 307 Ar 2%Co2 1%H	M11			✓						✓			
304		Cr Ni 309 Ar 2% Co2	M12		✓	✓					✓	✓			
305		Cr Ni 310 Ar 2%Co2	M12			✓						✓			
306		Cr Ni 307 Ar 2%Co2	M12			✓						✓			
308		DUPLEX 2209 Ar 2%Co2	M12									✓			
BRAZING		701	Cu Si 3 Ar 100%	I1		✓	✓					✓	✓		✓
	702	Cu Al 8 Ar 100%	I1		✓	✓					✓	✓			

Legend

- ✓ Synergy available for the product
- ✓ Synergy available for download via the interface configurator

PB Flat corner position



Interface configurator

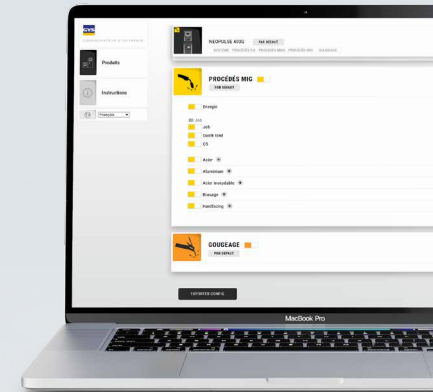
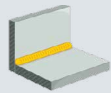
This tool, accessible via the Internet, allows you to customise the interface: activate or deactivate synergies, limit access to certain welding processes, hide functions, etc. A [GYS account](#) is required.

			Welding mode					STANDARD IMPACT			STANDARD ROOT			PULSE				COLD PULSE				
			DYNAMIC STANDARD					STANDARD IMPACT			STANDARD ROOT			PULSE				COLD PULSE				
			0,8	1,0	1,2	1,6'	2,4'	0,8	1,0	1,2	0,8	1,0	1,2	0,8	1,0	1,2	1,6'	0,8	1,0			
			PB					PB			PB			PB				PB				
			008	010	012	016	024	708	710	712	108	110	112	508	510	512	516	608	610			
	Welding mode	Wire diameter	Welding position					Synergy code														
STEEL	101	Fe Ar 15-20%Co2	M21	✓	✓	✓	✓		✓		✓		✓	✓	✓	✓						
	102	Fe Ar 8-10%Co2	M20	✓	✓	✓	✓				✓	✓	✓	✓	✓	✓	✓					
	103	Fe 100%Co2	C1	✓	✓	✓	✓				✓	✓	✓									
	104	FCW M Ar 15-20%Co2	M21			✓	✓															
	105	FCW R Ar 15-20%Co2	M21			✓	✓															
	106	FCW B Ar 15-20%Co2	M21			✓	✓															
	108	Fe Ar 25%Co2	M21	✓	✓	✓	✓							✓	✓	✓	✓					
ALUMINIUM	201	Al Mg 5 Ar 100%	I1	✓	✓	✓	✓						✓	✓	✓	✓						
	202	Al Mg 3 Ar 100%	I1	✓	✓	✓	✓						✓	✓	✓	✓						
	203	Al Si 5 Ar 100%	I1	✓	✓	✓	✓						✓	✓	✓	✓						
	204	Al Si 12 Ar 100%	I1	✓	✓	✓	✓							✓	✓	✓	✓					
	206	Al Mg 2,7 Mn Ar100%	I1			✓									✓							
	207	Al Si 10 Cu 4 100%	I1			✓										✓						
	208	AlMg 4,5Mn 10-20%He	I3		✓	✓									✓	✓						
	209	AlMg 4,5Mn 100% Ar	I1		✓	✓									✓	✓						
	210	Al Mg 5 Ar 10-20%He	I3		✓	✓									✓	✓						
	211	Al Mg 3 Ar 10-20%He	I3		✓	✓									✓	✓						
	STAINLESS	301	Cr Ni 308 Ar 2%Co2	M12	✓	✓	✓	✓						✓	✓	✓	✓					
302		Cr Ni 316 Ar 2%Co2	M12	✓	✓	✓	✓						✓	✓	✓	✓						
303		Cr Ni 307 Ar 2%Co2 1%H	M11		✓	✓								✓	✓							
304		Cr Ni 309 Ar 2% Co2	M12	✓	✓	✓								✓	✓							
305		Cr Ni 310 Ar 2%Co2	M12		✓									✓								
306		Cr Ni 307 Ar 2%Co2	M12		✓	✓								✓	✓							
308		DUPLEX 2209 Ar 2%Co2	M12											✓	✓							
BRAZING	701	Cu Si 3 Ar 100%	I1	✓	✓	✓							✓	✓	✓		✓	✓				
	702	Cu Al 8 Ar 100%	I1	✓	✓	✓							✓	✓	✓							
HARDFACING	501	HARDFACE Metal	O			✓	✓	✓														
	502	HARDFACE Basic	O			✓	✓	✓														
	503	HARDFACE Rutil	O			✓	✓	✓														
	504	HARDFACE COBALT Ar	I1			✓									✓							
	505	HARDFACE Cr Co2 2,5%	M12			✓									✓							
	507	FCW 308L ArCo2 2,5%	M12			✓									✓							
	506	HARDFACE Tool Co2 18%	M21			✓									✓							
	508	FCW ROBO Rutil 18%Co2	M21			✓																
	509	FCW 308L Rutil 18%Co2	M21			✓																
	510	FCW NiCr Basic 18%Co2	M21			✓																
	511	HARDFACE 60 HRC	M21			✓										✓						

Legend

- ✓ Synergy available for the product
- ✓ Synergy available for download via the interface configurator
- * Not available for NEOPULSE 320 C

PB Flat corner position



Interface configurator

This tool, accessible via the Internet, allows you to customise the interface: activate or deactivate synergies, limit access to certain welding processes, hide functions, etc. A [GYS account](#) is required.

GALAXY 220 / 250 / 320

GALAXY 400

	Welding mode	Wire diameter	Welding position	Synergy code
STEEL	101	Fe Ar Co2 15-20%	M21	
	102	Fe Ar Co2 8-12%	M20	
	103	Fe Co2 100%	C1	
	104	FCW M Ar Co2 15-20%	M21	
	113	Fe No Gas	O	
ALUMINIUM	216	Al Mg Ar 100%	I1	
	217	Al Si Ar 100%	I1	
STAINLESS STEEL	301	Cr Ni 308 Ar 2%Co2	M12	
	302	Cr Ni 316 Ar 2%Co2	M12	
BRAZING	701	Cu Si Ar 100%	I1	

STANDARD				PULSE		
0,8	1,0	1,2	1,6*	0,8	1,0	1,2
PB				PB		
708	710	712	716	508	510	512
✓	✓	✓		✓	✓	
✓	✓	✓		✓	✓	
✓	✓	✓				
		✓	✓			
		✓	✓			
✓	✓	✓		✓	✓	✓
	✓	✓			✓	✓
✓	✓	✓		✓	✓	
✓	✓	✓		✓	✓	
✓	✓			✓	✓	

STANDARD				PULSE			
0,8	1,0	1,2	1,6	0,8	1,0	1,2	1,6
PB				PB			
708	710	712	716	508	510	512	516
✓	✓	✓		✓	✓		
✓	✓	✓		✓	✓		
✓	✓	✓					
		✓	✓			✓	✓
		✓	✓			✓	✓
✓	✓	✓		✓	✓	✓	
	✓	✓			✓	✓	
✓	✓	✓		✓	✓	✓	
✓	✓			✓	✓		

Legend

- ✓ Synergy available for the product
- * Not available for GALAXY 220/250

PB Flat corner position

		Welding mode	Wire diameter	Welding position	Synergy code
STEEL	101	Fe Ar Co2 15-20%	M21		
	102	Fe Ar Co2 8-12%	M20		
	103	Fe Co2 100%	C1		
	104	FCW M Ar Co2 15-20%	M21		
	113	Fe No Gas	O		
ALUMINIUM	216	Al Mg Ar 100%	I1		
	217	Al Si Ar 100%	I1		
STAINLESS STEEL	301	Cr Ni 308 Ar 2%Co2	M12		
	302	Cr Ni 316 Ar 2%Co2	M12		
BRAZING	701	Cu Si Ar 100%	I1		

KRONOS

STANDARD				
0,8	1,0	1,2	1,6*	
PB				
708	710	712	716	
✓	✓	✓		
✓	✓	✓		
✓	✓	✓		
		✓	✓	
		✓	✓	
✓	✓	✓		
	✓	✓		
✓	✓	✓		
✓	✓	✓		
✓	✓			

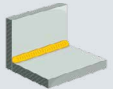
NEOMIG

STANDARD				
0,8	1,0	1,2	1,6	
PB				
708	710	712	716	
✓	✓	✓	✓	
✓	✓	✓	✓	
✓	✓	✓		
		✓	✓	
		✓	✓	
✓	✓	✓		
	✓	✓		
✓	✓	✓		
✓	✓	✓		
✓	✓			

Legend

- ✓ Synergy available for the product
- * Not available for KRONOS 250/320

PB Flat corner position

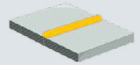


			Welding mode				IMPACT STANDARD			PULSE			COLD PULSE		
			Wire diameter				0,6	0,8	1,0	1,2	0,8	1,0	1,2	0,8	1,0
			Welding position				PA				PA			PA	
			Synergy code				006	008	010	012	508	510	512	608	610
STEEL	101	Fe Ar Co2 15-20%	M21	✓	✓	✓				✓	✓				
	102	Fe Ar Co2 8-10%	M20	✓	✓	✓				✓	✓				
	103	Fe Co2 100%	C1	✓	✓	✓									
	107	Mn4Ni2,5CrMo	M21		✓					✓					
	108	Fe Ar 25% Co2	M21	✓	✓	✓				✓	✓				
ALUMINIUM	201	Al Mg 5 Ar 100%	I1		✓	✓	✓			✓	✓	✓			
	202	Al Mg 3 Ar 100%	I1		✓	✓	✓			✓	✓	✓			
	206	Ford 5554	I1				✓					✓			
	203	Al Si 5 Ar 100%	I1		✓	✓	✓			✓	✓	✓			
	204	Al Si 12 100%	I1		✓	✓	✓			✓	✓	✓			
	206	Al Mg 2,7 Mn Ar100%	I1				✓					✓			
	207	Al Si 10 Cu 4 100%	I1				✓					✓			
STAINLESS STEEL	301	Cr Ni 308 Ar 2%Co2	M12		✓	✓				✓	✓				
	302	Cr Ni 316 Ar 2%Co2	M12		✓	✓				✓	✓				
BRAZING	701	Cu Si 3 Ar 100%	I1		✓	✓				✓	✓		✓	✓	
	702	Cu Al 8 Ar 100%	I1		✓	✓				✓	✓				

Legend

✓ Synergy available for the product

PA Flat position



P1/P3 GYS AUTO

E GYS AUTO

Welding mode
Wire diameter
Welding position
Synergy code

	103	Fe Co2 100%	C1
STEEL	107	Mn4Ni3CrMo Co2 8-12%	M20
	112	Fe Ar Co2 8-25%	M21
	206	Al Mg 2,7 Mn	I1
ALUMINIUM	207	TESLA Al Si 10 Cu4	I1
	216	Al Mg Ar 100%	I1
	217	Al Si Ar 100%	I1
	STAINLESS STEEL	309	Cr Ni Ar 2%Co2
701		Cu Si Ar 100%	I1
BRAZING	702	Cu Al Ar 100%	I1

STANDARD			
0,6	0,8	1,0	1,2
PA			
006	008	010	012
✓	✓	✓	
	✓		
✓	✓	✓	
		✓	✓
			✓
	✓	✓	✓
	✓	✓	✓
	✓	✓	
	✓	✓	

PULSE		
0,8	1,0	1,2
PA		
508	510	512
✓		
✓	✓	
	✓	✓
		✓
✓	✓	✓
	✓	✓
✓	✓	
✓	✓	

STANDARD			
0,6	0,8	1,0	1,2
PA			
706	708	710	712
✓	✓	✓	
✓	✓	✓	
	✓	✓	✓
	✓	✓	✓
	✓	✓	
	✓	✓	

Legend

✓ Synergy available for the product

PA Flat position

