

Material Number	Material	Max Power %	Rise Time 1	Soak Power 1	Soak Time 1	Rise Time 2	Soak Power 2	Soak Time 2	Feed Ramp Time	Idle Ramp Time	Suggested Max rate (Å/sec)	Sweep Amplitude
1	Solid Aluminum	50	1:00	22	1:00	1:00	26	1:00	0:30	5:00	5	0.2
2	Chromium w/ liner	15	1:00	2	1:00	1:00	3	1:00	0:30	5:00	2	0.2
3	Solid Nickel	38	2:00	9	1:30	2:00	10	1:00	0:30	7:00	3	0.2
4	Cobalt	30	4:00	7	1:00	3:00	10	2:00	3:00	15:00	≤ 1 !	0.2
5	Solid Titanium	22	1:30	6	1:00	1:30	8	1:00	0:30	5:00	5	0.2
6	Titanium w/ liner	25	1:30	7	1:00	1:00	9	1:00	0:30	5:00	5	0.2
7	Palladium w/ liner (with buttons)	13	3:00	6	3:00	3:00	8	3:00	2:00	15:00	≤ 1 !	0.2
8	Platinum w/ liner (with buttons)	38	3:00	15	2:00	3:00	22	2:00	2:00	15:00	≤ 1 !	0.2
9	Gold w/ liner (with buttons)	25	2:00	8	1:00	2:00	12	1:00	0:30	8:00	4	0.2
10	Silver w/ liner (with buttons)	15	2:00	4	3:00	2:00	5	3:00	0:30	8:00	4	0.2
11	Copper w/ liner	15	1:30	4	1:00	1:30	5	1:00	0:30	5:00	5	0.2
12	Moly. w/ liner (with buttons)	45	2:00	22	2:00	2:00	26	2:00	1:00	8:00	2	0.2
13	Germanium w/ liner	25	1:30	8	1:30	1:00	10	1:00	0:30	5:00	4	0.2