

Mig Welding Parameters Reference

Note: This parameter setting is for reference only.

Material	Wire Type	Shielding Gas 20-30 SCFH	Polarity Setting	Wire Size	Settings	Material Thickness-220V					
						18 Ga. 1.2mm	16 Ga. 1.6mm	14 Ga. 2.0mm	1/8" 3.2mm	3/16" 4.8mm	1/4" 6.4mm
Mild Steel	Solid Wire ER70S-6	C25 75% Ar 25% CO2	DCEP	0.025" 0.6mm	Wire speed Voltage Inductance	145 16.5 3-5	190 17 3-5	260 18 3-5	300 19 3-5	-	-
				0.030" 0.8mm	Wire speed Voltage Inductance	105 15.5 5-10	135 16 5-10	165 17 5-10	260 18.5 5-10	300 19.5 5-10	-
				0.040" 1.0mm	Wire speed Voltage Inductance	100 16 5-10	125 17 5-10	160 17.5 5-10	180 18 5-10	260 19.5 5-10	280 20 5-10
		C100 100% CO2	DCEP	0.025" 0.6mm	Wire speed Voltage Inductance	150 17.5 1-3	190 17 1-3	220 19 1-3	300 21.5 1-3	-	-
				0.030" 0.8mm	Wire speed Voltage Inductance	120 16.5 3-6	130 17.5 3-6	170 17.5 3-6	200 19 3-6	300 22 3-6	-

				0.040" 1.0mm	Wire speed Voltage Inductance	120 17 3-6	140 17.5 3-6	170 18.5 3-6	190 22 3-6	260 22 3-6	300 22 3-6
	Flux- Cored E71T-11	None	DCEN	0.030" 0.8mm	Wire speed Voltage Inductance	80 13.5 5-10	95 14.5 5-10	135 16 5-10	250 18 5-10	-	-
				0.040" 1.0mm	Wire speed Voltage Inductance	80 14 5-10	80 14.5 5-10	110 15.5 5-10	200 17 5-10	275 20 5-10	320 21 5-10
Stainles s Steel	ER308L	Tri-Mix 90% He 7.5% Ar 2.5% CO2	DCEP	0.040" 1.0mm	Wire speed Voltage Inductance	100 18.5 5-10	120 18.5 5-10	145 19 5-10	230 21 5-10	270 21.5 5-10	300 22.5 5-10