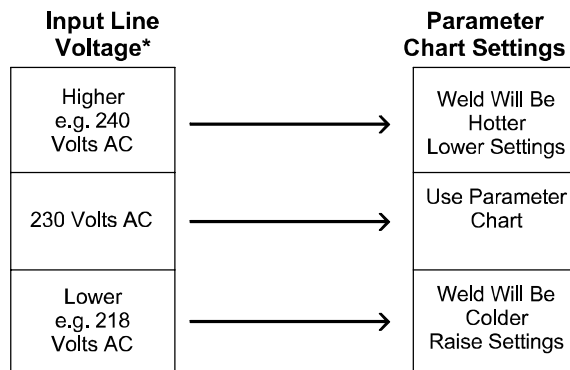







5-2. Weld Parameter Chart

Material	Suggested Wire Types	Suggested Shielding Gases And Flow Rate	Wire Sizes (Diameters)
STEEL	Solid (or hard) ER70s-6	75% Ar/ 25% CO ₂ 25 cfh (Ar/CO ₂ produces less spatter—better overall appearance)	0.023" (0.6mm)
			0.030" (0.8mm)
			0.035" (0.9mm)
	Solid (or hard) ER70s-6	100% CO ₂ 25 cfh	0.023" (0.6mm)
			0.030" (0.8mm)
			0.035" (0.9mm)

Material	Suggested Wire Types	Suggested Shielding Gases And Flow Rate	Wire Sizes (Diameters)
STEEL	Flux core E71T-11	No shielding gas required	0.030" (0.8mm)
			0.035" (0.9mm)
			0.045" (1.1mm)
STAINLESS STEEL	Stainless Steel ER 308, ER 308L ER 308LSi	Tri-Mix, 35 cfh (90% He/7.5% Ar/2.5% CO ₂)	0.023" (0.6mm)
			0.030" (0.8mm)
			0.035" (0.9mm)
Aluminum with optional Spoolmate™ 3035 spoolgun.	Aluminum 4043 ER	100% Ar 25 cfh	0.030" (0.8mm)
			0.035" (0.9mm)

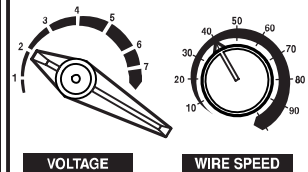
*Line voltage can affect weld output, settings on this chart are starting values only. You may need to adjust voltage and wire feed speed to optimize your settings.








							
	3/8" (9.5 mm)	1/4" (6.4 mm)	3/16" (4.8 mm)	1/8" (3.2 mm)	14 ga. (2.0 mm)	18 ga. (1.2 mm)	22 ga. (0.8 mm)
	—	5/90	4/80	3/65	3/60	2/35	1/20
	5/70	4/60	3/52	3/50	2/34	2/28	1/18
	5/55	4/48	3/42	3/40	3/35	2/22	—
	—	6/90	5/80	4/60	4/55	3/40	2/20
	—	6/70	5/60	4/45	3/30	2/18	—
	6/55	5/48	4/38	4/36	3/25	2/12	—

Select Voltage and Wire Speed Based on Thickness of Metal Being Welded.

To read Settings:
First number is voltage.
Second number is wire speed
(→) Means not recommended.

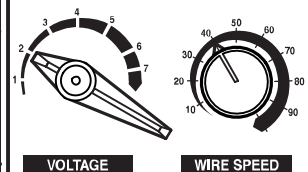


Example: 2/40

							
	3/8" (9.5 mm)	1/4" (6.4 mm)	3/16" (4.8 mm)	1/8" (3.2 mm)	14 ga. (2.0 mm)	18 ga. (1.2 mm)	22 ga. (0.8 mm)
	4/65	4/62	3/55	2/42	2/40	—	—
	4/52	4/50	3/40	2/32	2/30	—	—
	4/32	4/30	3/25	2/20	—	—	—
	7/95	6/90	5/85	5/80	4/75	3/52	3/50
	7/85	6/80	5/75	5/70	4/60	3/45	—
	7/70	6/65	5/60	4/50	3/40	3/35	—
	—	6/80	5/75	4/70	3/55	—	—
	7/80	6/70	5/65	4/60	3/50	—	—

Select Voltage and Wire Speed Based on Thickness of Metal Being Welded.

To read Settings:
First number is voltage.
Second number is wire speed
(→) Means not recommended.



Example: 2/40