

Welding Guide for 230 Volt Wire Welding Package

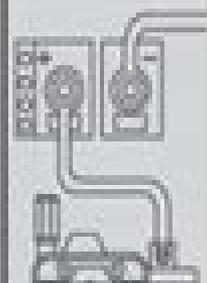
Settings are approximate. Adjust as required. Thicker materials can be welded using proper technique, joint preparation and multiple passes.

Recommended Voltage and Wire Speed Settings for thickness of metal being welded. Number on left of slash is Voltage Setting,* Number on right of slash is Wire Feed Setting.

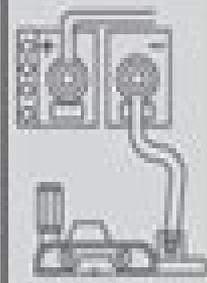
Material Being Welded	Wire Type and Polarity Setting	Suggested Shielding Gas 20-25 cfm Flow Rate	Diameter of Wire Being Used	Recommended Voltage and Wire Speed Settings for thickness of metal being welded. Number on left of slash is Voltage Setting,* Number on right of slash is Wire Feed Setting.								
				24 ga. .024 in. (0.6 mm)	26 ga. .026 in. (0.6 mm)	18 ga. .048 in. (1.2 mm)	16 ga. .060 in. (1.5 mm)	11 ga. .188 in. (4.8 mm)	3/16 in. (4.8 mm)	1/4 in. (6.4 mm)	5/16 in. (8.0 mm)	
Steel	Solid Wire ER70S-6 *Set Polarity for (DCSP)	C ₂ Gas Mixture 75% Argon/25% CO ₂ . Produces less spatter Better Appearance	.024" (0.6 mm)	17/20	21/40	27/50	47/50	57/50	67/50	-	-	
			.030" (0.8 mm)	-	17/40	27/50	27/50	57/50	67/50	77/50*	77/50*	
			.035" (0.9 mm)	-	17/40	47/40	57/40	67/50	67/50	77/50*	77/50*	
Steel	Solid Wire ER70S-6 *Set Polarity for (DCSP)	100% CO ₂	.024" (0.6 mm)	-	-	17/20	17/40	57/50	67/50	77/50*	-	
			.030" (0.8 mm)	-	-	47/40	57/40	67/50	67/50	77/50*	77/50*	
			.035" (0.9 mm)	-	-	17/20	47/20	57/40	67/40	77/40*	77/40*	
Stainless Steel	Stainless Steel *Set Polarity for (DCSP)	Tri-Mix 80% He/17% Ar/3% CO ₂	.024" (0.6 mm)	-	17/40	17/40	47/50	57/50	77/50	-	-	
			.030" (0.8 mm)	-	17/20	17/20	47/50	57/50	67/50	77/50*	-	
			.035" (0.9 mm)	-	17/10	17/20	47/30	57/40	77/40	77/50*	-	
Steel	Flux Core E71T-11 *Set Polarity for (DCEN)	No Shielding Gas Required Good for Windy or Outdoor Applications	.030" (0.8 mm)	-	17/20	17/40	17/40	47/50	57/50	67/50	-	
			.035" (0.9 mm)	-	17/20	17/20	17/40	57/50	67/50	67/50	77/50*	
			.045" (1.2 mm)	-	-	-	17/20	17/20	47/10	57/20	67/20*	
Aluminum With Optional SpoolFunner™ 100 Speed Gun	Aluminum -- 4043 Al. *Set Polarity for (DCSP)	100% Argon**	.030" (0.8 mm)	-	-	-	17/20	57/50	67/50	-	-	
	.035" (0.9 mm)		-	-	-	-	57/50	67/50	77/50	-		
	Aluminum -- 5356 Al. *Set Polarity for (DCSP)	100% Argon**	.030" (0.8 mm)	-	-	-	17/10	57/50	67/50	-	-	
	.035" (0.9 mm)		-	-	-	-	57/10	67/50	77/100	-		
Match feeded groove to diameter of wire being used. Set Tension Knob Setting to 0 at start. Adjust tension per instructions in the manual.			CAUTION! Do not change voltage switch position while welding. See owners manual for more information.				Wire Speed listed is a starting value only. Wire Speed setting can be fine tuned while welding. Wire Speed also depends on other variables such as stick out, travel speed, weld angle, cleanliness of metal, etc.					

CHANGING POLARITY

DCSP
Electrode Positive
For Solid Wire



DCEN
Electrode Negative
For Flux Cored Wire



* Multiple passes may be required depending on the application and joint design.

** Aluminum wire settings are with the SpoolFunner™ 100 Speed Gun attached. A spool gun eliminates many feasibility issues associated with the soft aluminum wire. A "push angle" for the torch is normally recommended for aluminum.

Miller Welding Guide Fcaw

Rosina Ehmann



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1. Understanding the eBook Miller Welding Guide Fcaw
 - The Rise of Digital Reading Miller Welding Guide Fcaw
 - Advantages of eBooks Over Traditional Books
2. Identifying Miller Welding Guide Fcaw
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Miller Welding Guide Fcaw
 - User-Friendly Interface
4. Exploring eBook Recommendations from Miller Welding Guide Fcaw
 - Personalized Recommendations
 - Miller Welding Guide Fcaw User Reviews and Ratings
 - Miller Welding Guide Fcaw and Bestseller Lists
5. Accessing Miller Welding Guide Fcaw Free and Paid eBooks
 - Miller Welding Guide Fcaw Public Domain eBooks
 - Miller Welding Guide Fcaw eBook Subscription Services
 - Miller Welding Guide Fcaw Budget-Friendly Options

6. Navigating Miller Welding Guide Fcaw eBook Formats
 - ePub, PDF, MOBI, and More
 - Miller Welding Guide Fcaw Compatibility with Devices
 - Miller Welding Guide Fcaw Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Miller Welding Guide Fcaw
 - Highlighting and Note-Taking Miller Welding Guide Fcaw
 - Interactive Elements Miller Welding Guide Fcaw
8. Staying Engaged with Miller Welding Guide Fcaw
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Miller Welding Guide Fcaw
9. Balancing eBooks and Physical Books Miller Welding Guide Fcaw
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Miller Welding Guide Fcaw
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Miller Welding Guide Fcaw
 - Setting Reading Goals Miller Welding Guide Fcaw
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Miller Welding Guide Fcaw
 - Fact-Checking eBook Content of Miller Welding Guide Fcaw
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements

- Interactive and Gamified eBooks

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