

Welding Guide for 230 Volt Wire Welding Package

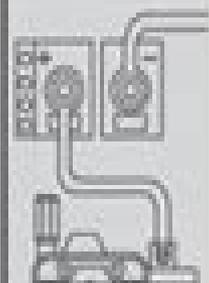
Settings are approximate. Adjust as required. Thicker materials can be welded using proper technique, joint preparation and multiple passes.

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.

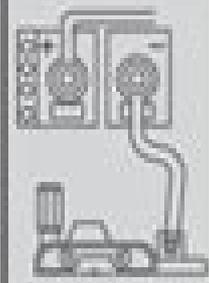
Material Being Welded	Wire Type and Polarity Setting	Suggested Shielding Gas @ 30-35 cfm Flow Rate	Diameter of Wire Being Used	Recommended Voltage and Wire Speed Settings for thickness of metal being welded. Number on left of slash is Voltage Setting,* Number on right of slash is Wire Feed Setting.								
				24 ga. .024 in. (.6 mm)	26 ga. .026 in. (.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" (.6 mm)	1 / 20	2 / 40	3 / 50	4 / 50	5 / 50	6 / 50	-	-	
			.030" (.8 mm)	-	1 / 40	2 / 50	3 / 50	4 / 60	5 / 60	6 / 60*	7 / 60*	
			.035" (.9 mm)	-	1 / 40	4 / 40	5 / 40	6 / 50	6 / 50	7 / 50*	7 / 50*	
Steel	Solid Wire ER70S-6 *Set Polarity for (DCSP)	100% CO ₂	.024" (.6 mm)	-	-	3 / 20	4 / 40	5 / 50	6 / 50	7 / 50*	-	
			.030" (.8 mm)	-	-	4 / 40	5 / 40	6 / 50	6 / 50	7 / 50*	7 / 50*	
			.035" (.9 mm)	-	-	5 / 20	4 / 20	5 / 40	6 / 40	7 / 40*	7 / 40*	
Stainless Steel	Stainless Steel *Set Polarity for (DCSP)	Tri-Mix 80% He/17% Ar/3% CO ₂	.024" (.6 mm)	-	3 / 40	3 / 40	4 / 30	5 / 50	6 / 50	7 / 50	-	
			.030" (.8 mm)	-	3 / 20	3 / 20	4 / 30	5 / 30	6 / 50	7 / 50*	-	
			.035" (.9 mm)	-	3 / 10	3 / 20	4 / 30	5 / 40	6 / 40	7 / 50*	-	
Steel	Flux Core E71T-11 *Set Polarity for (DCEN)	No Shielding Gas Required Good for Windy or Outdoor Applications	.030" (.8 mm)	-	1 / 20	1 / 40	2 / 40	4 / 50	5 / 40	6 / 40*	-	
			.035" (.9 mm)	-	1 / 20	1 / 20	2 / 40	3 / 50	4 / 50	5 / 50*	7 / 50*	
			.045" (1.2 mm)	-	-	-	1 / 20	2 / 20	4 / 15	5 / 20	6 / 20*	
Aluminum With Optional SpoolRunner™ 100 Speed Gun	Aluminum -- 4043 Al. *Set Polarity for (DCSP)	100% Argon**	.030" (.8 mm)	-	-	-	1 / 20	5 / 50	6 / 50	-	-	
	.035" (.9 mm)		-	-	-	-	5 / 50	6 / 50	7 / 50	-		
Aluminum With Optional SpoolRunner™ 100 Speed Gun	Aluminum -- 5052 Al. *Set Polarity for (DCSP)	100% Argon**	.030" (.8 mm)	-	-	-	1 / 15	5 / 50	6 / 50	-	-	
	.035" (.9 mm)		-	-	-	-	5 / 15	6 / 50	7 / 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 SpoolRunner™ 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.

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M Woodhall



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