

Welding Guide for 230 Volt Wire Welding Package

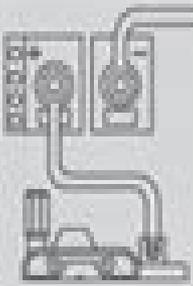
Settings are approximate. Adjust as required. Thicker materials can be welded using proper technique, joint preparation and multiple passes.

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.

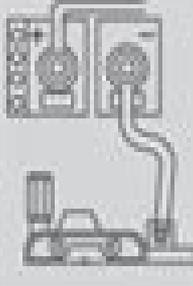
Material Being Welded	Wire Type and Polarity Setting	Suggested Shielding Gas @ 30-35 cfm Flow Rate	Diameter of Wire Being Used	Recommended Voltage and Wire Speed Settings for thickness of metal being welded. Number on left of slash is Voltage Setting,* Number on right of slash is Wire Feed Setting.								
				24 ga. .024 in. (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	47/60	57/80	67/90	-	-	
			.030" (0.8 mm)	-	17/40	27/50	37/60	47/80	67/90*	77/90*		
			.035" (0.9 mm)	-	17/40	47/60	57/80	67/90	77/90*	77/90*		
Steel	Solid Wire ER70S-6 *Set Polarity for (DCSP)	100% CO ₂	.024" (0.6 mm)	-	-	17/20	17/40	17/60	47/80	77/90*	-	
			.030" (0.8 mm)	-	-	47/60	57/80	67/90	77/90*	77/90*		
			.035" (0.9 mm)	-	-	17/20	47/20	57/40	67/60	77/80*	77/80*	
Stainless Steel	Stainless Steel *Set Polarity for (DCSP)	Tri-Mix 80% Arg/15% Ar/5% CO ₂	.024" (0.6 mm)	-	17/40	17/60	47/80	57/90	77/90	-	-	
			.030" (0.8 mm)	-	17/20	17/30	47/50	57/60	67/80	77/90*	-	
			.035" (0.9 mm)	-	17/10	17/30	47/50	57/60	77/80	77/90*	-	
Steel	Flux Core E71T-11 *Set Polarity for (DCSN)	No Shielding Gas Required Good for Windy or Outdoor Applications	.030" (0.8 mm)	-	17/20	17/40	17/60	47/80	57/90	67/90*	-	
			.035" (0.9 mm)	-	17/20	17/30	17/40	17/50	47/80	67/90*	77/90*	
			.045" (1.2 mm)	-	-	-	17/20	17/30	47/50	57/60	67/70*	
Aluminum With Optional SpoolRunner™ 100 Speed Gun	Aluminum -- 4043 AL *Set Polarity for (DCSP)	100% Argon**	.030" (0.8 mm)	-	-	-	17/20	17/30	47/50	-	-	
			.035" (0.9 mm)	-	-	-	-	17/30	47/50	77/80	-	
	Aluminum -- 5356 AL *Set Polarity for (DCSP)	100% Argon**	.030" (0.8 mm)	-	-	-	17/10	17/30	47/50	-	-	
			.035" (0.9 mm)	-	-	-	-	17/10	47/50	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, bend speed, bend 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 feedability issues associated with the soft aluminum wire. A "push angle" for the torch is normally recommended for aluminum.

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Miller Welding Guide Fcaw: Bestsellers in 2023 The year 2023 has witnessed a noteworthy surge in literary brilliance, with numerous engrossing novels captivating the hearts of readers worldwide. Lets delve into the realm of bestselling books, exploring the engaging narratives that have captivated audiences this year. Miller Welding Guide Fcaw : Colleen Hoover "It Ends with Us" This poignant tale of love, loss, and resilience has gripped readers with its raw and emotional exploration of domestic abuse. Hoover expertly weaves a story of hope and healing, reminding us that even in the darkest of times, the human spirit can succeed. Uncover the Best : Taylor Jenkins Reids "The Seven Husbands of Evelyn Hugo" This spellbinding historical fiction novel unravels the life of Evelyn Hugo, a Hollywood icon who defies expectations and societal norms to pursue her dreams. Reids compelling storytelling and compelling characters transport readers to a bygone era, immersing them in a world of glamour, ambition, and self-discovery. Discover the Magic : Delia Owens "Where the Crawdads Sing" This captivating coming-of-age story follows Kya Clark, a young woman who grows up alone in the marshes of North Carolina. Owens spins a tale of resilience, survival, and the transformative power of nature, captivating readers with its evocative prose and mesmerizing setting. These top-selling novels represent just a fraction of the literary treasures that have emerged in 2023. Whether you seek tales of romance, adventure, or personal growth, the world of literature offers an abundance of engaging stories waiting to be discovered. The novel begins with Richard Papen, a bright but troubled young man, arriving at Hampden College. Richard is immediately drawn to the group of students who call themselves the Classics Club. The club is led by Henry Winter, a brilliant and charismatic young man. Henry is obsessed with Greek mythology and philosophy, and he quickly draws Richard into his world. The other members of the Classics Club are equally as fascinating. Bunny Corcoran is a wealthy and spoiled young man who is always looking for a good time. Charles Tavis is a quiet and reserved young man who is deeply in love with Henry. Camilla Macaulay is a beautiful and intelligent young woman who is drawn to the power and danger of the Classics Club. The students are all deeply in love with Morrow, and they are willing to do anything to please him. Morrow is a complex and mysterious figure, and he seems to be manipulating the students for his own purposes. As the students become more involved with Morrow, they begin to commit increasingly dangerous acts. The Secret History is a masterful and thrilling novel that will keep you wondering until the very end. The novel is a warning tale about the dangers of obsession and the power of evil.

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