

MIG Welding Settings Chart – Wire Speed & Voltage

1. Wire Type 2. Gas 3. Flow Rate	Wire Size Diameter	Machine Settings	Material Thickness									
			3/32" (0.5mm)	5/16" (8mm)	1/4" (6.4mm)	3/16" 4.8mm	12 ga (2.8mm)	14 ga (2.0mm)	16 ga (1.6mm)	18 ga (1.2mm)	20 ga (0.9mm)	22 ga (0.8mm)
1. ER70S-6	.035" (0.6mm)	Voltage	-	-	-	20.5	20	19	18	17.5	17	17
		Wire Speed	-	-	-	320	240	200	180	165	150	140
	.030" (0.8mm)	Voltage	22	20.5	20	19	19	18.5	18	17.5	17	-
		Wire Speed	390	335	280	240	200	180	155	140	110	-
	.035" (0.9mm)	Voltage	22.5	22	21.5	20	19.5	19	18	18	-	-
		Wire Speed	310	285	260	225	180	170	150	125	-	-
	.045" (1.2mm)	Voltage	23	22	21	19	19	18	18	17	-	-
		Wire Speed	340	320	280	155	140	120	110	75	-	-
2. 75% Ar / 25% Co2	.035" (0.6mm)	Voltage	-	-	-	19	18	18	17.5	16.5	16	16
		Wire Speed	-	-	-	320	250	230	220	175	160	145
	.030" (0.8mm)	Voltage	20	19.5	19	18	18	17.5	17	16.5	16	16
		Wire Speed	390	335	280	240	200	180	155	140	110	100
	.035" (0.9mm)	Voltage	21	20.5	20	19	18.5	17.5	17	17	16	16
		Wire Speed	310	285	260	225	180	170	150	125	100	80
	.045" (1.2mm)	Voltage	21	20.5	20	18	18	17	17	16	-	-
		Wire Speed	340	320	180	155	140	120	110	75	-	-
3. MIG - Flux Core	.030" (0.8mm)	Voltage	20	19	18.5	17.5	16	15	14.5	14	-	-
		Wire Speed	375	340	300	275	240	180	150	125	-	-
	.035" (0.9mm)	Voltage	21	20	18.5	17.5	16	15	14.5	-	-	-
		Wire Speed	300	275	250	210	170	140	110	-	-	-
3. MIG - Tubular	.045" (1.2mm)	Voltage	22.5	21.5	19	17.5	16	15	-	-	-	-
		Wire Speed	250	220	180	140	100	75	-	-	-	-

110 Mig Welding Guide

Edward F. Craig

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A Management and Engineer's Guide to MIG Welding Quality, Costs, and Training Edward F. Craig, 1996 MIG and flux cored weld results achieved with the world's most utilized welding equipment are frequently influenced by weld sales advice. This 600 plus page book has been called the MIG bible by some readers. It's the most comprehensive book ever written on managing the MIG process. The book covers all aspects of controlling both the MIG and flux cored process. A MANAGER OR ENGINEER DOES NOT REQUIRE THE ABILITY TO WELD HOWEVER THEY SHOULD HAVE THE FUNDAMENTAL PROCESS KNOWLEDGE OF WHAT MAKES A GOOD MIG OR FLUX CORED WELD WHEN A MANAGER OR ENGINEER UNDERSTANDS HOW SALES INFLUENCE AND HYPE EFFECTS THE WELD SHOP THEY ARE WELL ON THEIR WAY TO WELD PROCESS MANAGEMENT. In the MIG Management book you will find Extensive data on MIG gas selection without sales input. Over 100 pages on the problems with the pulsed process. How to establish effective weld process controls for robot cells. How to use special techniques to increase robot weld speeds. How to optimize manual and robot weld deposition rates. How to control sheet metal welds in automotive plants. How to best utilize MIG and flux cored for pipe welds. All this along with a unique simple method for controlling weld costs. These are just a few of the important topics. Without question this is the most practical and comprehensive book you will ever find on managing the MIG process.

The Farm Welding Handbook Richard Finch, *Advanced Welding Techniques* Himanshu Vashishtha, Deepak Kumar, Ravindra V.

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