

MIG Welding Settings Chart – Wire Speed & Voltage

1. Wire Type 2. Gas 3. Flow Rate	Wire Size Diameter	Machine Settings	Material Thickness									
			1/8" (3.2mm)	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 2. Co2 3. 20 CFH	.03" (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	240	225	180	175	150	125	-	-
	.045" (1.2mm)	Voltage	23	22	21	19	19	18	18	17	-	-
		Wire Speed	240	220	200	155	140	120	110	75	-	-
1. ER70S-6 2. 75% AR / 25% Co2 3. 20 CFH	.03" (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	240	225	180	175	150	125	100	80
	.045" (1.2mm)	Voltage	21	20.5	20	18	18	17	17	16	-	-
		Wire Speed	240	220	180	155	140	120	110	75	-	-
1. E71T-GS 2. N/A - Flux Core 3. N/A - Tubular	.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	-	-	-
	.045" (1.2mm)	Voltage	22.5	21.5	19	17.5	16	15	-	-	-	-
		Wire Speed	230	205	180	140	100	75	-	-	-	-

110 Mig Welding Guide

Edward F. Craig



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