



MANUAL MIG SET-UP GUIDE: 7 STEPS

MATERIAL THICKNESS for 120 VAC

MATERIAL THICKNESS for 208-240 VAC

1 Select PROCESS	2 Select MATERIAL	3 Select WIRE TYPE/DIAMETER	4 Select SHIELD GAS	Set Steps 5-7	120 VAC					208-240 VAC									
					22 ga. (0.8 mm)	18 ga. (1.2 mm)	16 ga. (1.6 mm)	1/8" (3.2 mm)	3/16" (4.8 mm)	22 ga. (0.8 mm)	18 ga. (1.2 mm)	16 ga. (1.6 mm)	1/8" (3.2 mm)	3/16" (4.8 mm)	1/4" (6.4 mm)	5/16" (8.0 mm)	3/8" (9.5 mm)		
MIG MAN (Manual MIG)	Mild Steel Gas Shielded	ER70S-6 .023" (0.6 mm)	75% Argon 25% CO ₂	5 Wire Feed Speed	175	215	235	400		175	215	235	400	600					
				6 Voltage	15	16	17	18		15	16	17	18	20					
				7 Inductance	0-2	0-2	3-5	3-5		0-2	0-2	3-5	3-5	3-5					
		Wire Feed Speed	140	170	215	325	360	140	170	215	325	360	395	420	450				
		Voltage	15	16	17	19.5	20	15	16	17	18	20	20.5	22	22.5				
		Inductance	4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6			
	Mild Steel Gasless	ER70S-6 .035" (0.9 mm)	75% Argon 25% CO ₂	Wire Feed Speed		135	165	280	300		135	165	280	300	340	390	415		
				Voltage		16	17	19	19.5		16	17	19	19.5	20	21.5	22		
				Inductance		4-6	4-6	4-6	4-6		4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	
		E71T-11 .030" (0.8 mm)	Self Shielding Flux Cored Wire	Wire Feed Speed	130	140	220	250		130	140	220	250	272	300	390			
				Voltage		16	17	19.5	20		16	17	19.5	20	21.5	22	23		
				Inductance		4-6	4-6	4-6	4-6		4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	
E71T-11 .035" (0.9 mm)	Self Shielding Flux Cored Wire	Wire Feed Speed	120	130	200	240		120	130	200	240	272	300	390					
		Voltage		16	17	19.5	20		16	17	19.5	20	21.5	22	23				
		Inductance		4-6	4-6	4-6	4-6		4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6			
E71T-11 .045" (1.2 mm)	Self Shielding Flux Cored Wire	Wire Feed Speed										160	180	200	225	230			
		Voltage										22.5	23.5	24	25	25.5			
		Inductance										4-6	4-6	4-6	4-6	4-6	4-6		
Stainless Steel Gas Shielded	ER308L/ER316L .030" (0.8 mm)	98% Argon 2% CO ₂	Wire Feed Speed	220	245	260	420	550	220	245	260	420	550	600	650				
			Voltage	15	16	16.5	22	24	15	16	16.5	22	24	25	26				
			Inductance	4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6		
Aluminum Gas Shielded Spool Gun	ER4043 .035" (0.9 mm)	100% Argon	Wire Feed Speed			250	460	480			250	460	480	500	550	550			
			Voltage			13	19	21			13	19	21	23	23.5	23.5			
			Inductance			3-5	3-5	3-5				3-5	3-5	3-5	3-5	3-5	3-5	3-5	



STICK SET-UP GUIDE: 6 STEPS



LIFT TIG SET-UP GUIDE: 6 STEPS

1 Select PROCESS	2 Select MATERIAL	3 Select ELECTRODE TYPE	4 Select ELECTRODE DIAMETER	5 Set AMP RANGE		6 Set POLARITY	1 Select PROCESS	2 Select MATERIAL	3 Select TUNGSTEN DIAMETER	4 Select FILLER ROD (If Needed)	5 Set AMP RANGE		6 Select Shielding GAS							
				120 VAC	208-240 VAC						120 VAC	208-240 VAC								
STICK	Mild Steel	E6011	3/32" (2.5 mm)	40-75	40-75	ELECTRODE POSITIVE	Mild Steel	1/16" (1.6 mm)	1/16" (1.6 mm)	3/32" (2.5 mm)	1/8" (3.2 mm)	10-70	10-70	100% Argon						
			1/8" (3.2 mm)	70-110	70-110							15-140	15-150							
			5/32" (4.0 mm)	80-110	80-145															
		E6013	3/32" (2.5 mm)	70-95	70-95	ELECTRODE POSITIVE						Stainless Steel	1/16" (1.6 mm)		1/16" (1.6 mm)	3/32" (2.5 mm)	1/8" (3.2 mm)	10-60	10-60	100% Argon
			1/8" (3.2 mm)	100-110	100-135													15-135	15-135	
			5/32" (4.0 mm)	145-180	130-200															
	E7018	3/32" (2.5 mm)	70-110	70-110	ELECTRODE POSITIVE	Mild Steel	1/16" (1.6 mm)	1/16" (1.6 mm)	3/32" (2.5 mm)	1/8" (3.2 mm)	10-60	10-60	100% Argon							
		1/8" (3.2 mm)	90-110	90-160							15-140	15-150								
		5/32" (4.0 mm)	130-200	130-200																
	Stainless Steel	E308L/E316L	3/32" (2.5 mm)	30-60	30-60	ELECTRODE POSITIVE	Stainless Steel	1/16" (1.6 mm)	1/16" (1.6 mm)	3/32" (2.5 mm)	1/8" (3.2 mm)	10-60		10-60	100% Argon					
			1/8" (3.2 mm)	55-95	55-95							15-135		15-135						
			5/32" (4.0 mm)	80-110	80-140															

CONSUMABLES

Mig Gun Contact Tips	Drive Rolls	Tig Tungstens	Collets	Collet Bodies
11 23	Drive Roll, Solid (.024"(.030")	1/16" EwCe-2	1/16"	1/16"
11 30	Drive Roll, Solid (.030"(.035")	3/32" EwCe-2	3/32"	3/32"
11 35	Drive Roll, Solid (.035"(.045")	1/8" EwCe-2	1/8"	1/8"
11 45	Drive Roll, Flux Cored (Knurled .030"(.035")			
	Drive Roll, Flux Cored (Knurled .035"(.045")			