













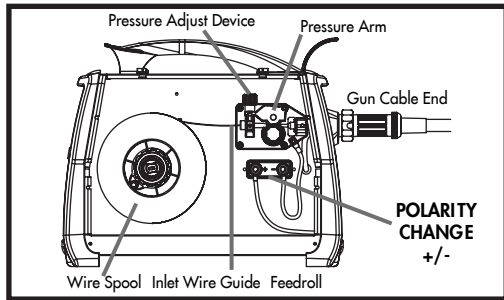
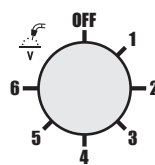


# 210 MIG SET-UP CHART

MATERIAL (Wire)	GAS	WIRE Ø	MATERIAL THICKNESS													
			22 Gauge .0315" (.8 mm)	20 Gauge .0354" (.9 mm)	18 Gauge .0472" (1.2 mm)	16 Gauge 1/16" (1.6 mm)	1/8" (3 mm)	3/16" (4.5 mm)	1/4" (6.4 mm)							
Regulation Knob			Voltage Setting 	Wire Feed Setting 	Voltage Setting 	Wire Feed Setting 	Voltage Setting 	Wire Feed Setting 	Voltage Setting 	Wire Feed Setting 	Voltage Setting 	Wire Feed Setting 	Voltage Setting 	Wire Feed Setting 	Voltage Setting 	Wire Feed Setting 
Mild Steel	Solid Wire 75% Ar 25% CO <sub>2</sub> (ER70S-6)	.023" (0.6 mm)	1	1.6	1	1.6	1	2	3	3.5	4	5.5	4	5.5	5	10
		.030" (0.8 mm)	1	1.5	1	1.5	1	1.5	2	2	3	2.5	4	4.3	5	6
		.035" (0.9 mm)	-	-	1	1.3	1	1.4	2	1.6	3	2	4	3.3	5	4.5
	Solid Wire 100% CO <sub>2</sub> (ER70S-6)	.023" (0.6 mm)	1	1.6	1	1.6	1	1.9	3	3.5	5	6.5	5	10	5	10
		.030" (0.8 mm)	1	1.4	1	1.4	1	1.5	3	2.3	4	3.0	5	5.3	6	7.4
		.035" (0.9 mm)	-	-	1	1.2	2	1.4	3	1.7	4	2.4	5	3.5	5	3.7
	Flux Core Wire (No Gas) (E71T-GS)	.030" (0.8 mm)	-	-	-	-	1	1.6	2	1.9	4	4.3	5	6	6	10
.035" (0.9 mm)		-	-	-	-	1	1.4	2	1.6	4	3	5	5.5	6	6	
.045" (1.2 mm)		-	-	-	-	-	-	3	1.8	4	2	4	2.5	6	3.5	
Stainless Steel	Solid Wire 90% He 7.5% Ar 2.5% CO <sub>2</sub>	.023" (0.6 mm)	-	-	-	-	2	2.6	2	3	4	3.6	5	5.7	5	5.7
		.030" (0.8 mm)	-	-	-	-	2	2	2	2	3	2.5	5	3.7	-	-
		.035" (0.9 mm)	-	-	-	-	2	2	2	2	3	2.5	5	3	-	-
Aluminum	Solid Wire 100% Argon	.030" (0.8 mm)	-	-	-	-	-	3	3.5	4	4.5	5	6	6	10	
		.035" (0.9 mm)	-	-	-	-	-	-	3	3.5	4	4.7	5	6.2	5	6.2



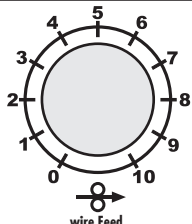
### Arc Voltage Control



This control sets the arc welding voltage. It is proportional to the amount of heat in the arc.

Position 6 is the highest arc voltage or heat setting.

### Wire Speed Control



This sets the wire feed speed (WFS) of the electrode wire through the MIG gun.

Position 0 is 80 IPM  
Position 10 is 700 IPM



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