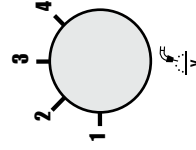


140 MIG SET-UP CHART

MATERIAL (Wire)	GAS	WIRE Ø	MATERIAL THICKNESS													
			24 Gauge .0236" (.6 mm)	22 Gauge .0315" (.8 mm)	20 Gauge .0354" (.9 mm)	18 Gauge .0236" (1.2 mm)	1/8" (3 mm)	3/16" (4.5 mm)	1/4" (6.4 mm)							
Mild Steel	Solid Wire 75% Ar + 25% CO ₂ (ER70S-6)	.023" (0.6 mm)	1	3	1	3	2	7.5	2	7.5	3	8.5	4	9	-	-
			1	2	1	2	1	3.5	2	5.5	3	7	4	8	4	8
			-	-	-	-	2	3	2	4	3	6	4	8	4	8
	Flux Core Wire (No Gas) (E71T-GS)	.030" (0.8 mm)	1	2	1	2	1	3	2	5	4	8	4	9	4	9
			-	-	-	-	1	2	2	4	4	8	4	8.5	4	8.5
			1	3	1	3	1	3.5	2	6	3	8.5	4	9	-	-
Stainless Steel	Solid Wire 98% Ar 2% CO ₂	.030" (0.8 mm)	-	-	1	2	1	3.5	2	4	3	7	4	8	4	8
			-	-	-	-	1	3	1	3.5	2	4	3	7	4	8
			-	-	-	-	1	3	1	3	3	3.5	3	7	4	8

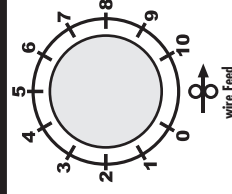
Regulation Knob

Arc Voltage Control

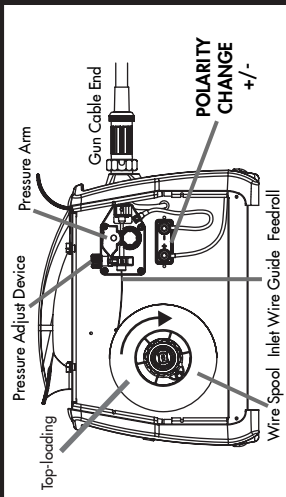


This control sets the arc welding voltage. It is proportional to the amount of heat in the arc. Position 6 is the highest arc voltage or heat setting.

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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