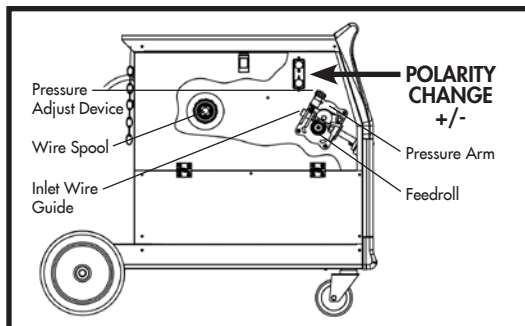
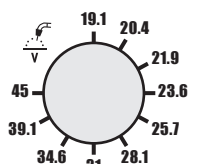


270 MIG SET-UP CHART

MATERIAL (Wire)	GAS	WIRE Ø	MATERIAL THICKNESS											
			22 Gauge .0315" (.8 mm)	18 Gauge .0472" (1.2 mm)	16 Gauge .063" (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
Mild Steel	Mix 75% Ar 25% CO ₂	.023" (0.6 mm)	20.4	220	23.6	250	25.7	310	31.0	550	-	-		
		.030" (0.8 mm)	21.9	160	23.6	190	25.7	250	31.0	490	39.1	560		
		.035" (0.9 mm)	21.9	140	23.6	180	28.1	200	31.0	360	43	500	45	640
		.045" (1.1 mm)	-	-	23.6	130	28.1	360	34	290	39.1	320	45	340
	100% CO ₂	.023" (0.6 mm)	21.9	170	23.6	190	23.6	220	28.1	310	-	-		
		.030" (0.8 mm)	-	-	25.7	170	28.1	270	34.6	310	45.0	590		
		.035" (0.9 mm)	-	-	25.7	180	28.1	210	34.6	300	39.1	420	45	650
		.045" (1.1 mm)	-	-	-	-	28.1	150	34.6	200	39.1	290	45	350
	Flux Core Wire (No Gas)	.035" (0.9 mm)	-	-	20.4	110	21.9	110	25.7	190	28.1	190	34.6	260
.045" (1.2 mm)		-	-	-	-	-	-	28.1	190	31.0	190	39.1	400	
Stainless Steel	Solid Wire 100% Argon	.023" (0.6 mm)	21.9	270	23.6	320	-	-	-	-	-	-		
		.030" (0.8 mm)	-	-	31.0	270	31.0	460	-	-	-	-		
		.035" (0.9 mm)	-	-	-	-	-	-	-	-	-	-	40	610
Aluminum AL4043/AL5356	Solid Wire 100% Argon	.035" (0.9 mm)	19.1	250	20.4	300	21.9	300	25.7	440	31.0	490	-	-
		.047" (1.2 mm)	20.4	210	20.4	210	21.9	260	25.7	370	31.0	410	-	-
Aluminum w/spool gun AL4043/AL5356	Solid Wire 100% Argon	.035" (0.9 mm)	Spot Welding 23.6	Spot Welding 5.5	21.9	5.5	23.6	5.6	31.0	6.5	34.6	7	-	-



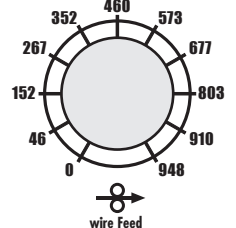
Arc Voltage Control



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

Voltage settings are approximate at no load.

Wire Speed Control

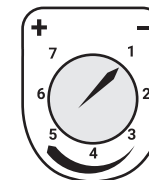


This sets the wire feed speed (WFS) of the electrode wire through the MIG gun.

WFS ranges 0-950 IPM

WFS arc approximate at no load

Spool Gun Control



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