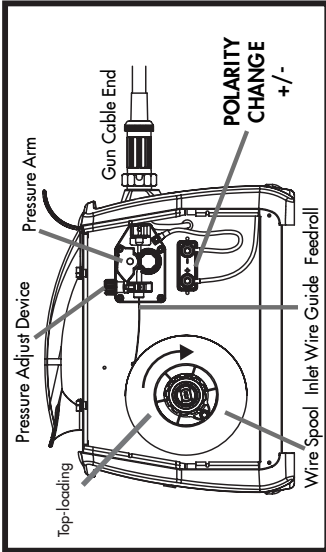


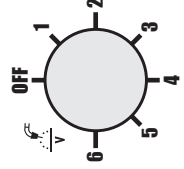
190 MIG SET-UP CHART

MATERIAL (Wire)	GAS	WIRE Ø	MATERIAL THICKNESS						
			24 Gauge .0236" (0.6 mm)	22 Gauge .0315" (0.8 mm)	18 Gauge .0236" (1.2 mm)	16 Gauge .0139" (1.6 mm)	1/8" (3 mm)	1/4" (6.4 mm)	
Mild Steel	Regulation Knob		Voltage Setting	Voltage Setting	Voltage Setting	Voltage Setting	Voltage Setting	Voltage Setting	Voltage Setting
			Wire Feed Setting	Wire Feed Setting	Wire Feed Setting	Wire Feed Setting	Wire Feed Setting	Wire Feed Setting	Wire Feed Setting
			1	2	3	4	5	6	7
			-	2	3	4	5	6	7
			-	2	3	4	4	5	6
			-	2	3	4	5	6	7
Solid Wire 75% Ar + 25% CO ₂ (ER70S-6)			1	2	3	4	5	6	7
			-	2	3	4	4.5	6	6
			-	2	3	4	4	4	7
Flux Core Wire (No Gas) (E71T-GS)			-	2	3	4	5	6	7
			-	2	3	4	3.5	5	6



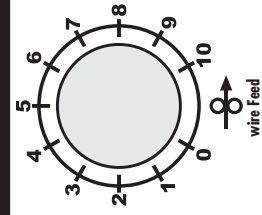
Arc Voltage Control

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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