

# Welding Guide for 230 Volt Wire Welding Package

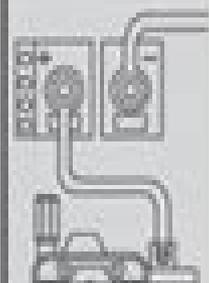
Settings are approximate. Adjust as required. Thicker materials can be welded using proper technique, joint preparation and multiple passes.

Recommended Voltage and Wire Speed Settings for thickness of metal being welded. Number on left of slash is Voltage Setting,\* Number on right of slash is Wire Feed Setting.

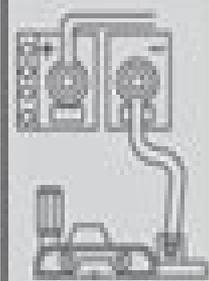
Material Being Welded	Wire Type and Polarity Setting	Suggested Shielding Gas @ 20-25 cfm Flow Rate	Diameter of Wire Being Used	Recommended Voltage and Wire Speed Settings for thickness of metal being welded. Number on left of slash is Voltage Setting,* Number on right of slash is Wire Feed Setting.								
				24 ga. .024 in. (0.6 mm)	26 ga. .026 in. (0.6 mm)	18 ga. .048 in. (1.2 mm)	16 ga. .060 in. (1.5 mm)	11 ga. .188 in. (4.8 mm)	3/16 in. (4.8 mm)	1/4 in. (6.4 mm)	5/16 in. (8.0 mm)	
Steel	Solid Wire ER70S-6 *Set Polarity for (DCSP)	C <sub>2</sub> Gas Mixture 75% Argon/25% CO <sub>2</sub> . Produces less spatter Better Appearance	.024" (0.6 mm)	17/20	21/40	27/50	47/50	57/50	67/50	-	-	
			.030" (0.8 mm)	-	17/40	27/50	37/50	47/50	57/50	67/50*	77/50*	
			.035" (0.9 mm)	-	17/40	47/40	57/40	67/50	67/50	77/50*	77/50*	
Steel	Solid Wire ER70S-6 *Set Polarity for (DCSP)	100% CO <sub>2</sub>	.024" (0.6 mm)	-	-	17/20	17/40	17/50	47/50	47/50	77/50*	
			.030" (0.8 mm)	-	-	47/40	57/40	57/50	67/50	77/50*	77/50*	
			.035" (0.9 mm)	-	-	57/20	47/20	57/40	67/40	77/40*	77/40*	
Stainless Steel	Stainless Steel *Set Polarity for (DCSP)	Tri-Mix 80% He/17% Ar/3% CO <sub>2</sub>	.024" (0.6 mm)	-	17/40	17/40	47/50	57/50	67/50	77/50	-	
			.030" (0.8 mm)	-	17/20	17/20	47/30	57/30	67/50	77/50*	-	
			.035" (0.9 mm)	-	17/10	17/20	47/30	57/40	67/40	77/50*	-	
Steel	Flux Core E71T-11 *Set Polarity for (DCSN)	No Shielding Gas Required Good for Windy or Outdoor Applications	.030" (0.8 mm)	-	17/20	17/40	17/40	47/50	57/50	67/50	-	
			.035" (0.9 mm)	-	17/20	17/20	17/40	17/50	47/50	47/50	77/50*	
			.045" (1.2 mm)	-	-	-	17/20	17/20	47/10	57/20	67/20*	
Aluminum With Optional SpoolRunner™ 100 Speed Gun	Aluminum -- 4043 Al. *Set Polarity for (DCSP)	100% Argon**	.030" (0.8 mm)	-	-	-	17/20	17/50	47/50	-	-	
	.035" (0.9 mm)		-	-	-	-	17/50	47/50	47/50	77/50	-	
Aluminum With Optional SpoolRunner™ 100 Speed Gun	Aluminum -- 5356 Al. *Set Polarity for (DCSP)	100% Argon**	.030" (0.8 mm)	-	-	-	17/10	17/50	47/50	-	-	
	.035" (0.9 mm)		-	-	-	-	17/10	17/50	47/50	77/100	-	
Match leaded groove to diameter of wire being used. Set Tension Knob Setting to 0 at start. Adjust tension per instructions in the manual.			<b>CAUTION!</b> Do not change voltage switch position while welding. See owners manual for more information.				Wire Speed listed is a starting value only. Wire Speed setting can be fine tuned while welding. Wire Speed also depends on other variables such as stick out, travel speed, weld angle, cleanliness of metal, etc.					

## CHANGING POLARITY

**DCSP**  
Electrode Positive  
For Solid Wire



**DCSN**  
Electrode Negative  
For Flux Cored Wire



\* Multiple passes may be required depending on the application and joint design.

\*\* Aluminum wire settings are with the SpoolRunner™ 100 Speed Gun attached. A spool gun eliminates many feasibility issues associated with the soft aluminum wire. A "push angle" for the torch is normally recommended for aluminum.

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**LM Reder**



## **Miller Welding Guide Fcaw:**

*A Practical Guide to Welding Solutions* Robert W. Messler, Jr., 2019-01-14 As critically important as welding is to a wide spectrum of manufacturing construction and repair it is not without its problems Those dependent on welding know only too well how easy it is to find information on the host of available processes and on the essential metallurgy that can enable success but how frustratingly difficult it can be to find guidance on solving problems that sooner or later arise with welding welds or weldments Here for the first time is the book those that practice and or depend upon welding have needed and awaited *A Practical Guide to Welding Solutions* addresses the numerous technical and material specific issues that can interfere with success Renowned industrial and academic welding expert and prolific author and speaker Robert W Messler Jr guides readers to the solutions they seek with a well organized search based on how a problem manifests itself i e as distortion defect or appearance where it appears i e in the fusion zone heat affected zone or base metal or it certain materials or situations

*The Farm Welding Handbook* Richard Finch, [Welding Licensing Exam Study Guide, Second Edition](#) Rex Miller, Mark R. Miller, 2021-11-19 Everything you need to pass the welding certification exams fully updated for the latest advances This thoroughly revised study guide helps you pass your licensing certification exams including the AWS certification exam and obtain your professional license Inside you ll find a valuable review of material that is most likely to appear on welding certification exams from basic safety and cutting practices to different types of welding including plasma arc shielded metal arc oxyacetylene flux cored gas metal and gas tungsten brazing soldering and more [Welding Licensing Exam Study Guide Second Edition](#) features Over 1 000 updated multiple choice and true false practice exam questions and answers Numerous welding calculations and troubleshooting tips Hundreds of detailed drawings and illustrations New Info on plastic pipes and tubing New Methods of welding repair and maintenance In depth coverage of welding tools and their uses The latest welding safety practices Guidance on studying welding methods SI and English units for all problems and equations Welding and Cutting Processes Plasma Arc Cutting and Welding Shielded Metal Arc Welding Oxyacetylene Welding Flux Cored Arc Welding Gas Metal Arc Welding Gas Tungsten Arc Welding Braze Welding Brazing Soldering Lead Tin and Zinc Identifying Metals Cast Iron and Its Alloys Wrought Iron Carbon Steels Low and High Alloy Steels Hardfacing Tool and Die Steels Reactive and Refractory Metals Galvanized Metals Soft Metals and Their Alloys Submerged Arc Welding Arc Welding Electrodes Types of Joints Welding Positions Welding Tips and Tests Common Welding Problems Certifications Conversion Tables Welding Terminology Tips for Producing Good Welds [Welding Licensing Exam Study Guide](#) Rex Miller, Mark R. Miller, 2007-06-07 Get Everything You Need to Help You Pass the Certified Welding Exams on the First Try The [Welding Licensing Exam Study Guide](#) contains everything needed to pass the Welding Code Book and Fundamentals exams with flying colors This career building resource includes calculations and troubleshooting tips that equip you with the skills knowledge and confidence required to ace these certification tests The [Welding Licensing Exam Study Guide](#) features

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**Oil and Gas Pipelines** R. Winston Revie, 2015-04-20 A comprehensive and detailed reference guide on the integrity and safety of oil and gas pipelines both onshore and offshore Covers a wide variety of topics including design pipe manufacture pipeline welding human factors residual stresses mechanical damage fracture and corrosion protection inspection and monitoring pipeline cleaning direct assessment repair risk management and abandonment Links modern and vintage practices to help integrity engineers better understand their system and apply up to date technology to older infrastructure Includes case histories with examples of solutions to complex problems related to pipeline integrity Includes chapters on stress based and strain based design the latter being a novel type of design that has only recently been investigated by designer firms and regulators Provides information to help those who are responsible to establish procedures for ensuring pipeline integrity and safety

**Welding Design & Fabrication**, 1983 **Welding Journal**, 1989 *Summaries of CANMET Energy Research Contracts, 1984-1985* Canada Centre for Mineral and Energy Technology, 1988 Each summary includes the contractor dates for beginning and end funding objectives procedures results application and ongoing work and supporting documents Coverage includes conservation in residential heating systems and industrial processes petroleum supply including recovery of bitumen and heavy oil treatment of bitumen oil emulsions and effluent waters upgrading synthetic crude distillates catalytic processes for hydrocarbon conversion conversion of natural gas and oil shales to liquid fuels materials for hydrocarbon processing oil and gas pipelines and for offshore structures coal mining preparation carbonization gasification liquefaction conventional combustion fluidized bed combustion coal liquid mixture combustion combustion technologies for pollution abatement materials for coal utilization and conversion and slurry transport renewable energy including biomass heating systems and materials for advanced energy conservation systems

**CANMET Report** Canada Centre for Mineral and Energy Technology, 1988 **Automatic Submerged Arc Welding with Metal Powder Additions to Increase Productivity and Maintain Quality. Final Report** P. D. Thomas, 1986 [ASM Handbook](#) ASM International. Handbook Committee, 1990 Volume 6 is the most comprehensive reference book ever produced on the major joining technologies and their applications

to engineered materials With over 500 illustrations and 400 tables this book includes practical advice on consumable selection and procedure development as well as joining fundamentals Find the Answers in Four Major Sections

Fundamentals of Joining addresses fundamental principles including basic chemistry physics and metallurgical concepts Joining Processes provides details on all major joining processes including process parameters advantages and limitations applications equipment and health and safety Materials Selection for Joined Assemblies describes how to optimize materials selection for particular applications Consumable Selection Procedure Development and Practice Considerations serves as a guide to practices for joining specific materials based on comprehensive up to date information and data on all principal materials types and joining processes Additional topics include joint evaluation and quality control modelling of joining processes underwater welding space welding cryogenic welding joining of composites and plastics intelligent automation for joining technology corrosion of weldments thermal spray coating cutting processes health and safety and welding terms and definitions Portions of this Volume have been updated in and are replaced by ASM Handbook Volume 6A Welding Fundamentals and Processes

*Welding Technology Fundamentals* William A. Bowditch, Kevin E. Bowditch, 1991 Welding Technology Fundamentals covers the equipment and techniques associated with the welding and cutting processes most widely used in industry today These processes include oxyfuel gas welding and cutting shielded metal arc welding gas metal arc welding flux cored arc welding gas tungsten arc welding and resistance welding Technical information regarding weld inspection and testing welder qualification drawing interpretation and welding symbols is also included The text is organized into eight sections which can be studied independently or in sequence Written in easy to understand format this text is extensively illustrated and includes many tables and charts for selecting the variables required to make a good weld

**How To Weld** Todd Bridigum, 2008-08-25 Welding is a skill that any do it yourself enthusiast needs in his or her arsenal How to Weld is the perfect introduction for newbies and an excellent refresher for veteran welders a work so comprehensive that most readers won't need any further instruction In How to Weld a bestselling installment in the Motorbooks Workshop series AWS certified welding instructor Todd Bridigum thoroughly describes process and art of fusing metals including Tools and equipment commonly used Types of metals and their weldability Welding techniques Shop and site safety Types of joints In addition all popular types of welding variants are covered including gas welding shielded metal arc or stick welding gas metal arc welding MIG gas tungsten arc welding TIG brazing soldering and even metal cutting Each skills section concludes with a series of exercises each illustrated with captioned sequential color photography to fully explain and detail the techniques learned Mechanics automotive enthusiasts farmers metalworkers and other DIYers who can't bond metal can't make repairs and they can't create in short they can't do much of anything except bolt together pre-made parts With this thorough and completely illustrated all color tutorial by an experienced college level instructor readers can get on the path fabricating and fixing metals on their own How To Weld is the only book about welding they'll ever need The Motorbooks

Workshop series covers topics that engage and interest auto and motorcycle enthusiasts Written by subject matter experts and illustrated with step by step and how it s done reference images Motorbooks Workshop is the ultimate resource for how to know how Popular Mechanics ,1983-07 Popular Mechanics inspires instructs and influences readers to help them master the modern world Whether it s practical DIY home improvement tips gadgets and digital technology information on the newest cars or the latest breakthroughs in science PM is the ultimate guide to our high tech lifestyle Automation ,1988 *Engineering Journal* ,2007 **Fleet Owner** ,1986 *World Dredging & Marine Construction* ,1987 **DE/domestic Engineering** ,1986 The Work Boat ,1980

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