

Material	Wire Type	Gas Flow Rates 15-25	Diameter of Wire	Parameter	Plate Thickness							
					1 mm	1.5mm	2mm	2.5mm	3mm	4mm	5mm	6mm
Steel	Gasless Flux Cored Wire E71T-11	No Gas	0.9mm	Amps	65	80	125	150	160	200	220	249
				Volts	13	14	14.5	18.5	21	24	24.9	25.1
			1.2mm	Amps	65	80	125	150	160	200	220	249
				Volts	13	14	14.5	18.5	24	25	26	27.1
	Mild Steel Solid Wire	Ar80%-CO2 20% Ar95%-CO2 5%	0.8mm	Amps	60	80	110	140	160	180	200	250
				Volts	14.5	14.8	16.7	18	19.7	22.3	24.5	28.5
			0.9mm	Amps	65	80	120	155	180	200	220	250
				Volts	15.2	17	19.5	20.1	23.1	23	24.5	28.5
			1.0mm	Amps	70	90	130	140	199	220	240	250
				Volts	15.2	17	18.9	20.1	21.9	24.5	26.5	28.5
1.2mm	Amps	70	99	148	159	200	225	239	245			
	Volts	15.5	15.9	17.9	18.5	21.9	24.9	26	27.1			
Stainless Steel	ER316L Solid wire	Ar98%-CO2 2%	0.8mm	Amps	55	80	100	122	145	150	190	200
				Volts	13.5	15.5	13.5	19.2	20.7	22.5	22.9	23.5
			0.9mm	Amps	53	83	107	148	165	200	210	220
				Volts	13.5	15.2	16.9	20	22.1	22.5	23.5	23.5
			1.0mm	Amps	53	100	130	160	180	200	215	225
				Volts	13.5	15.2	16.9	20.5	21.1	22.5	23.5	23.9
			1.2mm	Amps	53	100	130	160	180	200	220	240
				Volts	13.5	15.2	16.9	20.5	21.1	22.5	23.5	24.1
Silicon Bronze	ERCuSi-A	100% Argon	0.8mm	Amps	90	105	11	140	146	166	180	200
				Volts	14.7	14.9	15.9	17	17.9	19.3	21.5	23.5
			0.9mm	Amps	62	100	125	155	170	200	185	205
				Volts	13.5	17	19.5	20.3	20.1	23.5	21.5	23.5
			1.0mm	Amps	80	110	130	140	170	200	189	210
				Volts	14	17	19.5	20.3	20.1	23.1	22.1	23.5
			1.2mm	Amps	80	110	130	140	170	200	195	220
				Volts	14	17	19.5	20.3	20.1	23.5	22.5	24.5
Aluminum	AlSi	100% Argon	1.0mm	Amps	62	83	100	120	146	160	190	210
				Volts	13	14.2	15.5	16.5	19.9	22.5	23.8	24.8
			1.2mm	Amps	71	91	115	128	140	160	195	210
				Volts	14.9	15.9	16.8	17.9	19.9	22.5	24.8	24.8
	AlMg		1.0mm	Amps	69	85	105	125	140	160	195	210
				Volts	13.9	15.2	16.6	16.9	19.9	22.5	24.8	24.8
			1.2mm	Amps	72	91	115	128	140	160	195	210
				Volts	14.9	15.9	16.8	17.9	19.9	22.5	24.8	24.8