

# MIG Quick Setup Guide

**NOTE TO USER:** This guide is offered only as a basic starting point for settings. Additional adjustments may be required up to 15%. Joint design, technique and welding position will affect settings. Be sure to set Inductance before fine tuning settings.

## 240V Input

### 120V Input

Metal	Diameter	Wire Type	Polarity	Shielding Gas	Inductance	22 ga. 8mm	20 ga. 9mm	18 ga. 1.2mm	16 ga. 1/16" 1.5mm	14 ga. 5/64" 1.9mm	12ga 7/64" 2.7mm	11ga 1/8" 3 mm	10 ga. 9/64" 3.4mm	7 ga. 3/16" 4.5mm	3 ga. 1/4" 6mm	5/16" 8mm	3/8" 9.5mm						
STEEL	.023"/.6mm	ER70S-6	DCEP +	75/25 Ar/CO <sub>2</sub>	30-60%	15.5V	130 IPM	16.0V	180 IPM	16.5V	260 IPM	17.2V	300 IPM	17.5V	380 IPM	18.0V	420 IPM						
STEEL	.030"/.8mm	ER70S-6	DCEP +	75/25 Ar/CO <sub>2</sub>	50-70%	15.8V	100 IPM	16.2V	140 IPM	16.5V	180 IPM	17.2V	240 IPM	17.5V	260 IPM	18.0V	290 IPM	300 IPM	320 IPM	380 IPM	420 IPM		
STEEL	.035"/.9mm	ER70S-6	DCEP +	75/25 Ar/CO <sub>2</sub>	60-75%			16.2V	110 IPM	16.5V	160 IPM	17.4V	200 IPM	17.6V	230 IPM	18.1V	260 IPM	270 IPM	290 IPM	320 IPM	340 IPM	400 IPM	410 IPM
STEEL	.045"/1.2mm	ER70S-6	DCEP +	75/25 Ar/CO <sub>2</sub>	60-75%					17.5V	100 IPM	17.8V	120 IPM	18.2V	130 IPM	18.7V	140 IPM	150 IPM	160 IPM	190 IPM	190 IPM	210 IPM	23.3V
STAINLESS	.030"/.8mm	ER308L	DCEP +	98/2 Ar/CO <sub>2</sub>	70-90%					18.0V	300 IPM	18.6V	330 IPM	19.6V	400 IPM	19.8V	450 IPM	23.0V	500 IPM				
STAINLESS	.035"/.9mm	ER308L	DCEP +	98/2 Ar/CO <sub>2</sub>	70-90%					18.1V	180 IPM	18.6V	210 IPM	19.6V	260 IPM	20.5V	350 IPM	20.4V	290 IPM	300 IPM	400 IPM	450 IPM	460 IPM
ALUMINUM	.035"/.9mm	4043/5356	DCEP +	100% Argon	30-65%									21.0V	375 IPM	21.5V	390 IPM	22.0V	410 IPM	22.0V	420 IPM	24.0V	450 IPM
FLUX-CORED	.035"/.9mm	E71T-11	DCEN -	No Gas	30-70%					15.5V	70 IPM	16.0V	130 IPM	19.0V	340 IPM	20.0V	280 IPM	22.0V	340 IPM	22.0V	360 IPM	22.5V	370 IPM

Use the optional AHP recommended Spool Gun for welding Aluminum or, as an alternative, use the main gun with an optional polymer liner and optional .035" U-groove drive roll.

For Flux-Cored (Gasless) operation, use knurled drive roll. Be sure to change polarity to Electrode Negative (-) by changing terminal under the cover location and relocate work clamp to the Positive (+) lug.



## Generator Requirement\*: Minimum of 9500 W Surge with 5% or Less THD (Clean Power Rated)

\* Use with generators smaller than the minimum required wattage or with generators not labeled as producing 5% or less Total Harmonic Distortion (THD) by the generator manufacturer will void the warranty.

### Stick Setup Guide

NOTE: Some electrode manufacturer's Amperage suggestions may vary.

Rod Class	Diameter	Input	Arc Force	Polarity	120V				240V			
					14 ga. 5/64" 1.9mm	12 ga. 7/64" 2.7mm	11 ga. 1/8" 3 mm	10 ga. 9/64" 3.4mm	7 ga. 3/16" 4.5mm	3 ga. 1/4" 6mm		
E7018	3/32"	120/240V	10-30%	DCEP +	55-70A	70-75A	70-80A	70-85A	75-90A	80-95A		
E7018	1/8"	240V	10-40%	DCEP +				85-90A	90-100A	90-125A		
E7014	3/32"	120/240V	20-30%	DCEP +	70-80A	80-85A	85-90A	85-95A	90-110A	90-115A		
E7014	1/8"	240V	20-40%	DCEP +				95-100A	95-120A	95-130A		
E6010/6011	3/32"	120/240V	50-70%	DCEP +			55-65A	60-65A	65-70A	70-80A		
E6010/6011	1/8"	240V	50-70%	DCEP +			70-75A	75-80A	80-85A	85-95A		

