

Millermatic® 190 Silicon Bronze Parameters

Machine Set-up:

Auto-Set: Turned Off (*Use Manual Mode*)
 Polarity: DCEP
 Shielding Gas: Argon
 Flow Rate: 30-35 CFH
 Material: Mild Steel

Joint Type/Position: T-Joint – 2F

	Wire Size	20 ga		18 ga		16 ga		14 ga		1/8"	
		Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS
240 Volt	.030"	3	45	4	55	4	60	4.5	75	5.5	90
	.035"	3	35	3.5	40	4	50	4	55	5.5	70

Joint Type/Position: Lap Joint – 2F

	Wire Size	20 ga		18 ga		16 ga		14 ga		1/8"	
		Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS
240 Volt	.030"	3	55	4	60	4	65	4.5	80	5.5	90
	.035"	3	35	3.5	40	4	50	4	60	5.5	70

Joint Type/Position: Butt Joint – 1G

	Wire Size	20 ga		18 ga		16 ga		14 ga		1/8"	
		Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS
240 Volt	.030"	3	45	4	55	4	60	4.5	75	5	80
	.035"	3	30	3	35	3.5	45	4	50	5.5	70