

Multimatic™ 200 Silicon Bronze Parameters

Machine Set-up:

Process Select: MIG Steel C25
 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
120 Volt	.030"	15	275	16.6	355	17.3	370	-	-	-	-
	.035"	15	215	15.8	265	16.5	290	17.3	315	18.5	350
240 Volt	.030"	15	275	16.6	355	17.3	370	-	-	-	-
	.035"	15	215	15.8	265	16.5	290	17.3	215	18.5	355

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
120 Volt	.030"	15	275	16.3	340	17.3	370	18.6	400	-	-
	.035"	15	215	15.8	265	16.5	285	17.3	310	18.5	340
240 Volt	.030"	15	275	16.3	340	17.3	370	18.6	400	-	-
	.035"	15	215	15.8	265	16.5	285	17.3	310	18.5	340

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
120 Volt	.030"	15	275	16.3	340	16.6	355	18.6	400	-	-
	.035"	-	-	15.8	250	16.1	278	16.5	290	18.5	340
240 Volt	.030"	15	275	16.3	340	16.6	355	18.6	400	-	-
	.035"	-	-	15.8	250	16.1	278	16.5	290	18.5	340