

ALL ABOUT WELD - MIG PARAMETER REFERENCE CHART

Material: mild steel, CO2 / Ar-CO2 shielding. Starting points, adjust to fit-up.

Thickness	Wire Size	Voltage	Wire Speed (IPS)	Gas (CFH)
1.5 mm	0.8 mm	15-16 V	120-150	12-15
3.0 mm	0.9 mm	17-18 V	150-200	14-18
4.5 mm	1.0 mm	18-20 V	180-240	15-20
6.0 mm	1.0 mm	20-22 V	220-280	18-22
8.0 mm	1.2 mm	22-24 V	260-320	20-25
10+ mm	1.2 mm	24-27 V	300-380	22-28

Notes: short-circuit for thin material, spray transfer above ~24 V with

Ar-rich gas. These are starting points - verify with test welds.