

820 MIG

Recommended Welding Parameters*:

Diam. (in.)	<u>Optimum</u>			<u>Range</u>			CTWD
	Amperage	WFS	Voltage	Amperage	WFS	Voltage	
.035	200	550	29-30	160-250	350-750	24-35	½"-3/4"
.045	255	410	29-30	180-330	240-600	27-33	½"-1"
.052	300	350	29-30	220-460	220-620	25-35	½"-1
1/16	360	300	29-30	240-520	175-500	26-37	1"-1¼"
5/64	420	240	29-30	240-550	165-350	27-36	1"-1¼"

* With 75% Ar/25% CO2. For Ar/O2 mixes lower voltage by 3 volts.

Typical Short Arc Parameters (for out of position welding):

	Amperage	WFS	Voltage
.035	100	145	15-16
.045	140	150	16-17
.052	125	120	17-18