

960FC

Typical Welding Parameters (Ar + 20-25%CO₂)*:

Optimum WFS				Range		
Diameter	Position	Amperage	ipm (cm/min)	Voltage	Amperage	Voltage
.045" (1.2 mm)	Flat	180	400 (1015)	27-28	125-200	25-30
	V-up/OH	140	300 (760)	26	120-165	25-27
1/16" (1.6 mm)	Flat	250	300 (760)	28	130-300	23-30
	V-up/OH	200	200 (510)	26	140-240	23-27
Use 1/2" Contact tip to work distance						

* For CO₂ shielding increase voltage by ½-1 volt