



PROFESSIONAL PRODUCTS...  
SUPERIOR RESULTS™

## THE HARRIS PRODUCTS GROUP RECOMMENDED WELDING PARAMETERS FOR MILD STEEL/LOW ALLOY GMAW (MIG)

### GMAW (MIG)

CO<sub>2</sub> shielding yields a short-circuiting transfer, 90/10 (Argon/CO<sub>2</sub>) can give a short circuit transfer but is usually used in spray transfer

#### Short Circuit Transfer: SOLID GMAW - Using CO<sub>2</sub>

WIRE SIZE	WELDING CURRENT (AMPS)	ARC VOLTAGE	WIRE FEED SPEED, IP
.023"	30 - 90	14 -19	200 - 400
.030"	40 - 145	15 - 21	160 - 380
.035"	50 - 180	16 - 22	150 - 340
.045"	75 - 250	17 - 22	100 - 220

#### Spray Transfer: Using 90/10 (Ar/CO<sub>2</sub>)

WIRE SIZE	WELDING CURRENT (AMPS)	ARC VOLTAGE	WIRE FEED SPEED, IP
.030"	135 - 230	24 - 28	390 - 670
.035"	165 - 300	24 - 28	360 - 520
.045"	200 - 375	24 - 30	210 - 390
1/16"	275 - 500	24 - 32	150 - 360
3/32"	300 - 600	24 - 33	75 - 125