RECOMMENDED PARAMETERS FOR MIG/MAG MODE SETTING
(when using the standard set of cables supplied with the machine)

Ст3кп steel (Fe37-3FN)	Diameter of a welding wire ER307Ti (Св-08Х20Н9Г7Т)	Material thickness	0,8mm	1,0mm	1,5mm	2mm	3mm	4mm	5mm	6mm	8mm	10mm	12mm
CO2	**Ø 0,6mm**	Feeder speed Source voltage	5,3m/min 16,4V	5,7m/min 17,0V	6,6m/min 19,6V	7,4m/min 20,5V	8,0m/min 20,6V	8,8m/min 21,1V					
	Ø 0,8mm	Feeder speed Source voltage	2,9m/min 16,7V	3,9m/min 17,6V	5,7m/min 19,5V	6,8m/min 20,6V	7,5m/min 22,6V	8,9m/min 24V	10m/min 25,5V	9,1m/min 25,7V	9,1m/min 25,7V		
	Ø 1,0mm	**Feeder speed Source voltage**		**2,2m/min 16,6V**	**2,5m/min 18V**	**3,3m/min 18,9V**	**4,2m/min 20,2V**	**5,1m/min 22,4V**	**5,4m/min 23,8V**	**5,3m/min 25V**	**5,5m/min 25,2V**	**5,5m/min 25,5V**	
	Ø 1,2mm	Feeder speed Source voltage	2,1m/min 18,8V	2,1m/min 19,6V	3m/min 20,6V	4,2m/min 21,6V	4,4m/min 22,1V	5,3m/min 22,9V	5,6m/min 23,2V	6,2m/min 23,7V	6,3m/min 24,4V	6,6m/min 25,5V	

Ст3кп steel (Fe37-3FN)	Diameter of a welding wire ER307Ti (Св-08Х20Н9Г7Т)	Material thickness	0,8mm	1,0mm	1,5mm	2mm	3mm	4mm	5mm	6mm	8mm	10mm	12mm
82% Ar + 18% CO2	Ø 0,8mm	Feeder speed Source voltage	2,5m/min 17,8V	2,9m/min 18V	3,4m/min 18,8V	4,3m/min 19,7V	4,9m/min 20,3V	6m/min 21,4V	6,6m/min 22,2V	7,3m/min 23V			
	Ø 1,0mm	**Feeder speed Source voltage**		**2,1m/min 17,3V**	**2,3m/min 19,2V**	**3m/min 20,1V**	**3,4m/min 20,1V**	**3,8m/min 22,4V**	**5,2m/min 23V**	**5,4m/min 24V**	**5,6m/min 24,5V**	**5,6m/min 24,7V**	
	Ø 1,2mm	Feeder speed Source voltage			2m/min 17,3V	2,4m/min 17,7V	2,7m/min 21,3V	3,6m/min 21,6V	4,5m/min 21,6V	5,1m/min 23V	5,2m/min 24V	5,4m/min 24,5V	5,4m/min 24,5V

Ст3кп steel	Diameter of a welding wire ER70-S6 (Св-08Г2С)	Material thickness	0,8mm	1,0mm	1,5mm	2mm	3mm	4mm	5mm	6mm	8mm	10mm	12mm
82% Ar + 18% CO2	Ø 0,6mm	Feeder speed Source voltage	5,0m/min 16,5V	5,0m/min 16,5V	6,2m/min 17,9V	6,8m/min 18,6V	8,1m/min 19,4V	10,0m/min 20,0V					
	Ø 0,8mm	**Feeder speed Source voltage**	3,0m/min 14,3V	3,7m/min 15,9V	4,5m/min 16,2V	4,9m/min 17,1V	5,3m/min 19,3V	5,9m/min 19,9V	6,5m/min 20,5V	6,5m/min 20,5V	7,1m/min 21,0V		
	Ø 1,0mm	Feeder speed Source voltage	**2,5m/min 12,7V**	**2,8m/min 12,7V**	**3,8m/min 14,1V**	**4,1m/min 14,6V**	**4,4m/min 16,0V**	**4,8m/min 16,7V**	**5,0m/min 17,2V**	**5,5m/min 18,0V**	**5,6m/min 18,7V**	**6,8m/min 19,4V**	
	Ø 1,2mm	**Feeder speed Source voltage**		2,4m/min 13,9V	2,9m/min 15,3V	3,6m/min 15,8V	4,1m/min 17,3V	4,4m/min 17,9V	4,8m/min 18,6V	5,6m/min 18,6V	5,7m/min 19,5V	7,5m/min 20,2V	

Ст3кп steel	Diameter of a welding wire ER70-S6 (Св-08Г2С)	Material thickness	0,8mm	1,0mm	1,5mm	2mm	3mm	4mm	5mm	6mm	8mm	10mm	12mm
100% CO2	Ø 0,6mm	Feeder speed Source voltage	5,3m/min 16,4V	5,7m/min 17,0V	6,6m/min 19,6V	7,4m/min 20,5V	8,0m/min 20,6V	8,8m/min 21,1V					
	Ø 0,8mm	**Feeder speed Source voltage**	**3,0m/min 14,1V**	**3,5m/min 16,0V**	**4,6m/min 17,8V**	**5,0m/min 18,6V**	**5,3m/min 19,3V**	**5,7m/min 19,6V**	**6,1m/min 20,3V**	**6,1m/min 20,5V**	**5,7m/min 20,6V**		
	Ø 1,0mm	Feeder speed Source voltage	2,0m/min 12,6V	2,3m/min 13,2V	3,0m/min 13,8V	3,3m/min 15,8V	4,3m/min 16,9V	4,5m/min 18,6V	4,5m/min 19,1V	4,8m/min 21,0V	4,9m/min 20,5V	4,5m/min 20,4V	
	Ø 1,2mm	**Feeder speed Source voltage**			**2,4m/min 13,5V**	**2,7m/min 15,1V**	**4,0m/min 18,7V**	**4,2m/min 19,4V**	**4,7m/min 19,5V**	**4,9m/min 19,6V**	**5,5m/min 20,9V**	**5,8m/min 21,1V**	**6,0m/min 21,8V**

09Г2С (ANSI A 516-55) steel	Diameter of a welding wire ER70-S6 (Св-08Г2С)	Material thickness	0,8mm	1,0mm	1,5mm	2mm	3mm	4mm	5mm	6mm	8mm	10mm	12mm
CO2	Ø 0,8mm	Feeder speed Source voltage	2,2m/min 12,6V	2,5m/min 12,9V	3,8m/min 14,7V	4,6m/min 15,9V	5,1m/min 17V	5,8m/min 17,6V	6,4m/min 18,4V	6,5m/min 18,7V	7m/min 19,5V		
	Ø 1,0mm	**Feeder speed Source voltage**		**2,3m/min 13,7V**	**2,5m/min 14V**	**2,7m/min 16,1V**	**3m/min 17,4V**	**3,3m/min 18V**	**3,7m/min 19V**	**3,9m/min 19,2V**	**4m/min 19,5V**	**4,4m/min 19,9V**	
	Ø 1,2mm	Feeder speed Source voltage		2m/min 14V	2,3m/min 14,7V	2,6m/min 15,3V	3,5m/min 16,4V	4m/min 19,7V	4,7m/min 20,2V	4,9m/min 20,4V	5m/min 21,8V	5,4m/min 22,1V	5,4m/min 22,6V

09Г2С (ANSI A 516-55) steel	Diameter of a welding wire ER70-S6 (Св-08Г2С)	Material thickness	0,8mm	1,0mm	1,5mm	2mm	3mm	4mm	5mm	6mm	8mm	10mm	12mm
82% Ar + 18% CO2	Ø 0,8mm	Feeder speed Source voltage	2m/min 15,4V	2,4m/min 16,8V	2,6m/min 17,4V	3,5m/min 17,6V	4,5m/min 19V	5,1m/min 19,7V	6,1m/min 20,8V	6,8m/min 21,5V	7,4m/min 22V	7,4m/min 22V	
	Ø 1,0mm	**Feeder speed Source voltage**		**2m/min 15V**	**2,6m/min 16,8V**	**3m/min 18,3V**	**3,4m/min 19V**	**4m/min 19,6V**	**4,7m/min 20,5V**	**5,3m/min 21,1V**	**5,7m/min 22,2V**	**5,7m/min 22,2V**	
	Ø 1,2mm	Feeder speed Source voltage			2,1m/min 16,5V	2,6m/min 17V	3,1m/min 17,5V	3,6m/min 18,6V	4,4m/min 20V	4,8m/min 21,5V	5,3m/min 22V	5,5m/min 22,1V	5,5m/min 23,1V

09Г2С (ANSI A 516-55) steel	Diameter of a welding wire ER307Ti (Св-08Х20Н9Г7Т)	Material thickness	0,8mm	1,0mm	1,5mm	2mm	3mm	4mm	5mm	6mm	8mm	10mm	
CO2	Ø 0,8mm	Feeder speed Source voltage	2,8m/min 16,3V	3,9m/min 17,2V	5,5m/min 19V	6,5m/min 20,4V	7,5m/min 22,4V	8,5m/min 23,6V	9,6m/min 25V	8,7m/min 25,4V	8,7m/min 25,4V		
	Ø 1,0mm	**Feeder speed Source voltage**		**2,2m/min 16,2V**	**2,6m/min 17,6V**	**3,2m/min 18,4V**	**4m/min 20,1V**	**5,2m/min 22,2V**	**5,1m/min 23,4V**	**5m/min 24,5V**	**5,2m/min 25V**	**5,2m/min 25,2V**	
	Ø 1,2mm	Feeder speed Source voltage	2m/min 19V	2,2m/min 19,2V	2,9m/min 20,1V	4m/min 21,4V	4,5m/min 21,9V	5m/min 22,6V	5,3m/min 23V	6m/min 23,5V	6,2m/min 24,2V	6,5m/min 25,3V	

12Х18Н10Т (AISI321) steel	Diameter of a welding wire ER307Ti (Св-08Х20Н9Г7Т)	Material thickness	0,8mm	1,0mm	1,5mm	2mm	3mm	4mm	5mm	6mm	8mm	10mm	12mm
CO2	Ø 0,8mm	Feeder speed Source voltage	2m/min 14,5V	2,1m/min 16,1V	2,6m/min 16,8V	2,9m/min 17,2V	3,4m/min 18,1V	6m/min 19,5V	6,1m/min 19,8V	6,6m/min 20,1V	6,6m/min 20,1V		
	Ø 1,0mm	**Feeder speed Source voltage**		**2m/min 14,7V**	**2,5m/min 16,8V**	**2,7m/min 17,2V**	**3,8m/min 18,6V**	**4,3m/min 19,7V**	**4,5m/min 19,9V**	**4,9m/min 20,8V**	**4,6m/min 20V**		
	Ø 1,2mm	Feeder speed Source voltage		2m/min 14,7V	2,1m/min 15,9V	2,4m/min 17,1V	2,8m/min 18V	3m/min 19,2V	3,4m/min 19,8V	4,4m/min 20,5V	5m/min 20,5V	5,5m/min 21,8V	5,5m/min 21,8V

12Х18Н10Т (AISI321) steel	Diameter of a welding wire ER70-S6 (Св-08Г2С)	Material thickness	0,8mm	1,0mm	1,5mm	2mm	3mm	4mm	5mm	6mm	8mm	10mm	12mm
CO2	Ø 0,8mm	Feeder speed Source voltage		2,4m/min 15,5V	3m/min 16,3V	3,8m/min 17,5V	4,7m/min 18,4V	4,9m/min 19,9V	5,1m/min 20,5V	5,3m/min 21,5V	5,3m/min 21,5V		
	Ø 1,0mm	**Feeder speed Source voltage**		**2m/min 14V**	**2,2m/min 15,5V**	**2,7m/min 16,6V**	**3,4m/min 17,6V**	**3,9m/min 18,1V**	**4,3m/min 18,8V**	**5,2m/min 20,2V**	**5,6m/min 21,2V**		
	Ø 1,2mm	Feeder speed Source voltage			2m/min 14V	2,4m/min 15,7V	2,8m/min 16,6V	3,4m/min 17,2V	4,2m/min 19,1V	4,3m/min 20,2V	4,5m/min 20,8V	4,8m/min 21,5V	4,9m/min 22V

12Х18Н10Т (AISI321) steel	Diameter of a welding wire ER70-S6 (Св-08Г2С)	Material thickness	0,8mm	1,0mm	1,5mm	2mm	3mm	4mm	5mm	6mm	8mm	10mm	12mm
82% Ar + 18% CO2	Ø 0,8mm	Feeder speed Source voltage	2m/min 15,8V	2m/min 16V	2,4m/min 16,5V	3,3m/min 17,8V	4,4m/min 18,4V	5,5m/min 21,2V	6m/min 22,6V	6,3m/min 21,4V	6,3m/min 21,4V		
	Ø 1,0mm	**Feeder speed Source voltage**		**2m/min 15,5V**	**2,1m/min 16,2V**	**2,4m/min 17,9V**	**2,7m/min 18,4V**	**3m/min 18,9V**	**3,7m/min 19,9V**	**4,5m/min 20,8V**	**5,2m/min 22,4V**	**5,2m/min 22,4V**	
	Ø 1,2mm	Feeder speed Source voltage			2m/min 15V	2,1m/min 17,1V	2,5m/min 18,6V	3m/min 19,2V	3,7m/min 20,2V	4,2m/min 21,2V	4,4m/mi n 22,1V	5,1m/min 23,9V	5,2m/min 24,3V

20Х20Н14С (AISI309) steel	Diameter of a welding wire ER307Ti (Св-08Х20Н9Г7Т)	Material thickness	0,8mm	1,0mm	1,5mm	2mm	3mm	4mm	5mm	6mm	8mm	10mm	12mm
CO2	Ø 0,8mm	Feeder speed Source voltage		2,3m/min 15,4V	2,7m/min 16,1V	3,9m/min 16,2V	4,3m/min 16,8V	4,3m/min 16,9V	4,5m/min 17,5V	4,7m/min 17,7V	4,7m/min 17,7V		
	Ø 1,0mm	**Feeder speed Source voltage**		**2m/min 14V**	**2,4m/min 14,7V**	**2,5m/min 16V**	**3m/min 16,8V**	**4m/min 18V**	**4m/min 18V**	**4,1m/min 18V**	**4,4m/min 18,9V**		
	Ø 1,2mm	Feeder speed Source voltage			2,2m/min 15,2V	2,6m/min 17,4V	2,7m/min 17,6V	3,5m/min 18,7V	3,7m/min 19,1V	4,4m/min 20V	4,6m/min 20,1V	4,7m/min 20,2V	4,7m/min 20,3V

09Г2С	Diameter of a welding wire ER307Ti (Св-08Х20Н9Г7Т)	Material thickness	0,8mm	1,0mm	1,5mm	2mm	3mm	4mm	5mm	6mm	8mm	10mm	12mm
82% Ar + 18% CO2	Ø 0,8mm	Feeder speed Source voltage	2,5m/min 18,2V	2,9m/min 18,5V	3,8m/min 19,3V	4,9m/min 20,4V	5,5m/min 21V	6,4m/min 21,9V	7,2m/min 22,9V	7,7m/min 23,5V			
	Ø 1,0mm	**Feeder speed Source voltage**		**2m/min 17,1V**	**2,1m/min 18,3V**	**3,2m/min 20,8V**	**3,5m/min 22,3V**	**4,4m/min 23,3V**	**5m/min 23,9V**	**6m/min 24,9V**	**5,8m/min 24,7V**	**5,9m/min 25,3V**	
	Ø 1,2mm	Feeder speed Source voltage			2,1m/min 17,3V	2,6m/min 18,1V	3m/min 21V	3,8m/min 21,8V	4,7m/min 22,7V	5,2m/min 23,2V	5,6m/min 24,4V	5,7m/min 24,6V	5,5m/min 24,8V

12Х18Н10Т (AISI321) steel	Diameter of a welding wire ER307Ti (Св-08Х20Н9Г7Т)	Material thickness	0,8mm	1,0mm	1,5mm	2mm	3mm	4mm	5mm	6mm	8mm	10mm	12mm
82% Ar + 18% CO2	Ø 0,8mm	Feeder speed Source voltage	2,1m/min 17,1V	2,1m/min 17,4V	2,2m/min 17,8V	2,9m/min 19,1V	3,6m/min 20V	4,5m/min 20,4V	4,9m/min 20,9V	5m/min 20,6V			
	Ø 1,0mm	**Feeder speed Source voltage**		**2m/min 17,8V**	**2m/min 18,3V**	**2,3m/min 19,1V**	**2,7m/min 20,4V**	**3,7m/min 21,5V**	**3,9m/min 21,6V**	**4,4m/min 22,1V**	**5,1m/min 22,4V**	**5,1m/min 22,4V**	
	Ø 1,2mm	Feeder speed Source voltage			2m/min 17V	2,3m/min 18,2V	3m/min 19,3V	3,7m/min 22V	3,8m/min 22,1V	3,9m/min 21V	4m/min 21,1V	4m/min 21,1V	4,1m/min 21,2V

20Х20Н14С (AISI309) steel	Diameter of a welding wire ER307Ti (Св-08Х20Н9Г7Т)	Material thickness	0,8mm	1,0mm	1,5mm	2mm	3mm	4mm	5mm	6mm	8mm	10mm	12mm
82% Ar + 18% CO2	Ø 0,8mm	Feeder speed Source voltage	2,4m/min 16,8V	2,4m/min 17,2V	2,4m/min 17,6V	2,8m/min 18,4V	3,9m/min 20,2V	4,1m/min 19,7V	4,5m/min 20,3V	4,6m/min 20,4V			
	Ø 1,0mm	**Feeder speed Source voltage**		**2m/min 17V**	**2,3m/min 17,5V**	**2,5m/min 18,2V**	**2,8m/min 19,1V**	**3,1m/min 19,5V**	**4m/min 20,9V**	**4,2m/min 21,1V**	**4,3m/min 21,3V**	**4,3m/min 21,3V**	
	Ø 1,2mm	Feeder speed Source voltage			2m/min 16,6V	2,2m/min 17,3V	2,5m/min 19,2V	4m/min 22V	4,1m/min 22,2V	4,3m/min 22,4V	4,8m/min 22,5V	4,9m/min 22,6V	5,3m/min 22,6V