

Miller[®] 211 Silicon Bronze Parameters

Machine Set-up:

Process Select: MIG Steel C25
 Auto-Set: Turned Off (*Use Manual Mode*)
 Polarity: DCEP
 Shielding Gas: Argon
 Flow Rate: 30-35 CFH
 Material: Mild Steel

Joint Type/Position: T-Joint – 2F

	Wire Size	24 ga		22 ga		20 ga		18 ga		16 ga		14 ga		1/8"	
		Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS
120 Volt	.030"	3	50	4	60	4	65	4	70	4	75	4	80	-	-
	.035"	4	35	4	35	4	40	4	40	5	50	5	50	-	-
240 Volt	.030"	3	50	4	60	4	65	4	70	4	75	4	80	-	-
	.035"	4	35	4	35	4	40	4	40	5	50	5	50	5	65

Joint Type/Position: Lap Joint – 2F

	Wire Size	24 ga		22 ga		20 ga		18 ga		16 ga		14 ga		1/8"	
		Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS
120 Volt	.030"	4	30	4	35	4	40	4	45	4	55	5	65	5	70
	.035"	4	30	4	30	4	35	4	35	5	45	5	45	5	65
240 Volt	.030"	4	30	4	35	4	40	4	45	4	55	5	65	5	70
	.035"	4	30	4	30	4	35	4	35	5	45	5	45	5	65

Joint Type/Position: Butt Joint – 1G

	Wire Size	24 ga		22 ga		20 ga		18 ga		16 ga		14 ga		1/8"	
		Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS
120 Volt	.030"	3.5	30	3.5	35	4	40	4	45	4	55	4.5	65	4.5	70
	.035"	3.5	30	4	30	4	35	4	35	4.5	45	5	45	5	65
240 Volt	.030"	3	30	3.5	35	4	40	4	45	4	55	4.5	65	5	70
	.035"	3.5	30	4	30	4	35	4	35	4.5	45	4.5	45	5	65