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## Recommended Welding Parameters and Wire Feed Speeds

These are intended to be starting point recommendations. Wire type (metal core, Flux core) as well as whether the wire is operated open arc or with gas, straight or reverse polarity will have an impact on the settings to some degree.

<i>Diameter, Polarity, Estimated Stick out inches (mm)</i>	<i>Range</i>	<i>Wire Feed Speed  (in/min) and (m/min)</i>	<i>Voltage  (Volts)</i>	<i>Approximate Current  (Amps)</i>
	<i>Low - thin metals and out-of position Mid - optimum for flat High - thick base metal and high deposition</i>			
0.045 in (1.1mm), DC+  Stick-out 1 in (25mm)	Low	200 in/min or (5.1 m/min)	21	125
	Mid	400 in/min or (10.2 m/min)	25	185
	High	500 in/min or (12.7 m/min)	27	210
1/16 in (1.6 mm), DC+  Stick-out 7/8 in (22mm)	Low	200 in/min or (5.1 m/min)	28	240
	Mid	300 in/min or (7.6 m/min)	31	300
	High	450 in/min or (11.4 m/min)	33	350
3/32 in (2.0 mm), DC+  Stick-out 1-1/8 in (32 mm)	Low	125 in/min or (3.2 m/min)	26	250
	Mid	150 in/min or (3.8 m/min)	29	325
	High	200 in/min or (5.1 m/min)	32	400
5/64 in (2.0 mm), DC+  Stick-out 1-1/16 in (27 mm)	Low	125 in/min or (3.2 m/min)	26	250
	Mid	200 in/min or (5.1 m/min)	30	350
	High	250 in/min or (6.4 m/min)	32	400
7/64 in (2.8 mm), DC+  Stick-out 1-1/8 in (30mm)	Low	75 in/min or (1.9 m/min)	27	250
	Mid	125 in/min or (3.2 m/min)	30	340
	High	175 in/min or (4.4 m/min)	32	420