

# Miller<sup>®</sup> 212 Auto-Set Silicon Bronze Parameters

## Machine Set-up:

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

		20 ga		18 ga		16 ga		14 ga		1/8"	
Wire Size		Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS
240 Volt	.030"	2.5	55	2.5	60	3	70	3.5	80	-	-
	.035"	0	50	1.5	50	2	60	2	65	3.5	80

### Joint Type/Position: Lap Joint – 2F

		20 ga		18 ga		16 ga		14 ga		1/8"	
Wire Size		Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS
240 Volt	.030"	2	50	3	60	3	65	3.5	70	3.5	80
	.035"	-	-	1	50	1.5	55	2	60	3	70

### Joint Type/Position: Butt Joint – 1G

		20 ga		18 ga		16 ga		14 ga		1/8"	
Wire Size		Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS
240 Volt	.030"	-	-	2.5	60	3	60	3	70	3.5	80
	.035"	-	-	0	45	1.5	55	2	60	3	70