

Miller[®] 252 Silicon Bronze Parameters

Machine Set-up:

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	.035"	14.8	218	14.7	250	14.8	270	15.5	320	15.5	380

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	.035"	14	210	14.5	213	14.8	260	15.3	295	15.5	380

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	.035"	-	-	14.5	213	14.8	230	14.8	270	15.5	380