

Miller[®] 255 & Multimatic[®] 255 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 MIG (GMAW)										
	24 ga/0.6 mm		20 ga/0.9mm		18 ga/1.2 mm		14 ga/2.0 mm		1/8"/3.2 mm	
Wire Size	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS
.030"	12.4	135	14	196	14	225	15.1	362	15.1	401
.035"	12.9	120	14	154	14	165	15.5	275	16	375

Joint Type/Position: T-Joint – 2F Pulsed MIG (GMAWP)												
	24 ga/0.6 mm		20 ga/0.9 mm		18 ga/1.2 mm		14 ga/2.0 mm		1/8"/3.2 mm		3/16"/4.8 mm	
Wire Size	WFS		WFS		WFS		WFS		WFS		WFS	
.035"			150		170		190		285		380	