

MAG 211 VOLTAGE/WIRE SPEED SELECTION CHART



Voltage “V” → **1/6** ← Wire feed speed ∅

- : setting not recommended

The setting in the following chart is just for start only and can be fine tune during welding.

Material	Steel						Stainless steel			Aluminum	
Wire type	Solid ER70S-6			Flux core E71T-1			ER308,ER308L,ER 308LSi			ER4043	
Wire size (in) (mm)	0.023" 0.6	0.030" 0.8	0.035" 0.9	0.023" 0.6	0.030" 0.8	0.035" 0.9	0.023" 0.6	0.030" 0.8	0.035" 0.9	0.030" 0.8	0.035" 0.9
3/8" (9.5mm)	-	7/7	8/9	6/3.2	6/5.2	6/6.5	10/7	10/8.5	10/9.5	10/8	-
1/4" (6.4mm)	6/4.8	6/6	7/7	6/3	6/5	6/6.2	8/6.5	8/8	8/9	8/7	8/8
3/16" (4.8mm)	4/4.2	4/5.2	6/7	4/2.5	4/4	4/5.5	7/6	7/7.5	7/8.5	7/6.5	7/7.5
1/8" (3.2mm)	4/4	4/5	4/6.5	3/2	3/3.2	3/4.2	6/5	7/7	7/8	6/6	6/7
14ga. (2.0mm)	4/3.5	3/3.4	4/6	2/2	3/3	-	4/4	6/6	6/7.5	4/5	4/5.5
16ga. (1.6mm)	3/2.8	3/3.2	3/4	1/1.8	1/2	-	4/3.7	4/4.7	6/7	-	-
18ga. (1.2mm)	3/2.2	3/2.8	3/3.5	-	-	-	4/3.5	4/4.5	4/5.2	-	-
20ga. (0.9mm)	1/1.2	1/1.8	1/2.2	-	-	-	4/3.5	4/4	-	-	-
22ga. (0.8mm)	-	1/1.8	1/2	-	-	-	4/2.8	-	-	-	-