

MAG 251 VOLTAGE/WIRE SPEED SELECTION CHART



Voltage “V” \longrightarrow 1/6 \longleftarrow Wire feed speed \varnothing

- : 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	
	Solid ER70S-6			Flux core E71T-1			ER308,ER308L,ER 308LSi			ER4043	
Wire type											
Wire size (in)	0.023"	0.035"	0.045"	0.023"	0.035"	0.045"	0.023"	0.035"	0.040"	0.035"	0.045"
(mm)	0.6	0.9	1.2	0.6	0.9	1.2	0.6	0.9	1.2	0.9	1.2
1/2" (12.7mm)	-	-	8/7	-	-	7/7	-	-	10/9.5	-	10/9.5
3/8" (9.5mm)	-	7/5.5	7/5.5	6/3	6/5	6/6.5	10/7	10/8.5	10/9	-	9/9
1/4" (6.4mm)	6/4.2	6/4.2	7/6	6/2.7	6/4.5	6/6	8/6	8/8	9/9	8/8	8/8.5
3/16" (4.8mm)	4/4	4/4.2	6/6	4/2.3	4/3	4/5	7/6	7/7	8/8	7/7	7/8
1/8" (3.2mm)	4/3.5	4/4	4/5.5	3/2	3/3	3/4.2	6/5	7/6.5	7/7	6/6.5	6/7
14ga. (2.0mm)	4/3.5	4/3.5	4/5	2/2	-	-	4/4	6/6	6/6.5	4/5	4/5.5
16ga. (1.6mm)	3/2.8	3/2.8	3/3	1/1.8	-	-	4/3.7	6/5.5	6/6	-	-
18ga. (1.2mm)	3/2.2	3/2.2	3/3	-	-	-	4/3.5	4/5	4/5.5	-	-
20ga (0.9mm)	1/1.2	1/1.8	1/2	-	-	-	4/3	-	-	-	-
22ga. (0.8mm)	1/1	1/1.5	-	-	-	-	4/2.8	-	-	-	-

