

140 MP MIG SET-UP CHART

MATERIAL (Wire)	GAS	WIRE Ø	MATERIAL THICKNESS														
			22 Gauge .0315" (.8 mm)			18 Gauge .0236" (1.2 mm)			16 Gauge 1/16" (1.6 mm)			12 Gauge .0984" (2.5 mm)			1/8" (3 mm)		
Regulation Knob			Left Knob	Right Knob MIG Man	Right Knob MIG Syn	Left Knob	Right Knob MIG Man	Right Knob MIG Syn	Left Knob	Right Knob MIG Man	Right Knob MIG Syn	Left Knob	Right Knob MIG Man	Right Knob MIG Syn	Left Knob	Right Knob MIG Man	Right Knob MIG Syn
Mild Steel	Solid Wire 75% Ar + 25% CO ₂ (ER70S-6)	.023" (0.6 mm)	25	17.8	82	42	18.5	69	51	19.5	66	71	20.6	52	78	22	52
		.030" (0.8 mm)	22	15.1	65	33	16.7	65	44	18	65	55	19.7	65	60	20.7	65
		.035" (0.9 mm)	22	15.5	68	28	16.4	68	33	17.1	68	44	18.7	68	-	-	-
	Solid Wire 100% CO ₂ (ER70S-6)	.023" (0.6 mm)	37	19.3	80	48	19.9	73	59	21.2	70	85	23.7	59	74	24.6	55
		.030" (0.8 mm)	24	15.8	69	33	17.5	69	44	18.9	69	60	21.9	69	-	-	-
		.035" (0.9 mm)	-	-	-	19	18.2	92	30	19.7	90	38	21.1	93	-	-	-
Flux Core Wire (No Gas) (E71T-GS)	.035" (0.9 mm)	-	-	-	-	-	-	18	14.7	66	30	16.5	66	37	17.2	66	
Aluminum	Solid Wire 100% Argon	.030" (0.8 mm)	-	-	-	44	14.3	34	55	14.4	26	76	15.8	15	86	17.1	17

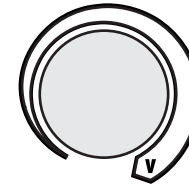
140 MP TIG SET-UP CHART

MATERIAL (Wire)	GAS	TUNGSTEN ELECTRODE Ø	MATERIAL THICKNESS							
			22 Gauge .0315" (.8 mm)		18 Gauge .0236" (1.2 mm)		16 Gauge 1/16" (1.6 mm)		1/8" (3 mm)	
Regulation Knob			Left Knob		Left Knob		Left Knob		Left Knob	
			Mild Steel	Stainless Steel	Mild Steel	Stainless Steel	Mild Steel	Stainless Steel	Mild Steel	Stainless Steel
Mild Steel	Solid Wire 100% Argon	.040" (1.0 mm)	35-50	20-35	45-60	30-55	-	-	-	-
		1/16" (1.6 mm)	-	-	-	-	60-90	40-70	80-100	65-100

140 MP STICK SET-UP CHART

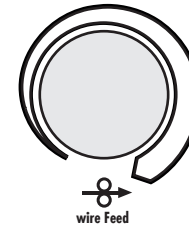
MATERIAL (Wire)	ELECTRODE TYPE	ELECTRODE DIAMETER			
		1/16" (1.6 mm)	.0787" (2 mm)	3/32" (2.4 mm)	1/8" (3 mm)
Regulation Knob		Left Knob	Left Knob	Left Knob	Left Knob
Mild Steel	6013	30-35	40-70	70-80	-
	7018	30-35	40-70	70-80	80
Stainless Steel	316	30-35	40-70	40-80	60-80

Arc Voltage Control



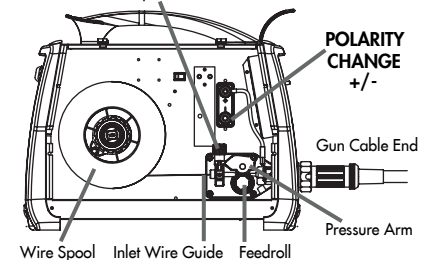
This control sets the arc welding voltage. It is proportional to the amount of heat in the arc.

Wire Speed Control



This sets the wire feed speed (WFS) of the wire through the MIG gun.

Pressure Adjust Device



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