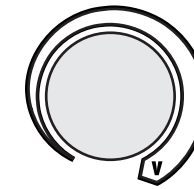


190 MP MIG SET-UP CHART

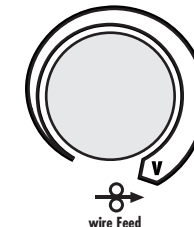
MATERIAL (Wire)	GAS	WIRE Ø	MATERIAL THICKNESS																							
			22 Gauge .0315" (.8 mm)			18 Gauge .0236" (1.2 mm)			16 Gauge 1/16" (1.6 mm)			12 Gauge .0984" (2.5 mm)			1/8" (3 mm)			.1575" (4 mm)			3/16" (5 mm)			1/4" (6 mm)		
Regulation Knob			Left Knob	Right Knob MIG Man	Right Knob MIG Syn	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	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	65	22.2	65	75	23	65	80	23.7	65
		.035" (0.9 mm)	22	15.5	68	28	16.4	68	33	17.1	68	44	18.7	68	55	21.3	75	60	22.1	76	-	-	-	-	-	-
	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	75	23.6	69	85	24.9	69	90	25.8	69	-	-	-
		.035" (0.9 mm)	-	-	-	19	18.2	92	30	19.7	90	38	21.1	93	46	22.7	96	55	24	97	-	-	-	-	-	-
	Flux Core Wire (No Gas) (E71T-GS)	.035" (0.9 mm)	-	-	-	-	-	-	18	14.7	66	30	16.5	66	37	17.2	66	48	18.8	66	59	20.8	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	100	21.2	23	-	-	-	-	-	-

Arc Voltage Control



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

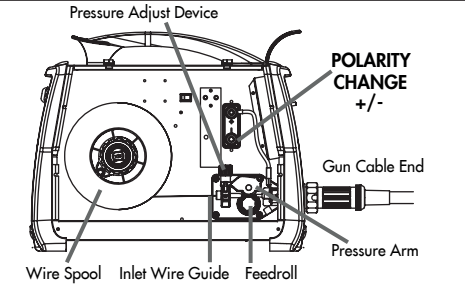
Wire Speed Control



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

190 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)		3/16" (5 mm)		1/4" (6 mm)	
Regulation Knob			Left Knob		Left 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	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	-	-	-	-
		3/32" (2.4 mm)	-	-	-	-	-	-	-	-	15-165	100-150	-	-
		5/32" (4mm)	-	-	-	-	-	-	-	-	-	-	160-180	135-180



230V INPUT VOLTAGE REQUIRED

190 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)	5/32" (4 mm)
Regulation Knob		Left Knob	Left Knob	Left Knob	Left Knob	Left Knob
Mild Steel	6013	30-35	40-70	70-95	100-135	145-160
	7018	30-35	40-70	70-110	90-160	130-160
Stainless Steel	316	30-35	40-70	40-80	60-110	90-150



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