

Multimatic™ 215 Silicon Bronze Parameters

Machine Set-up:

Process Select: MIG Steel C25
 Auto-Set: Turned Off (*Use Manual Mode*)
 Polarity: DCEP
 Shielding Gas: Argon
 Flow Rate: 30-35 CFH
 Material: Mild Steel

Joint Type/Position: T-Joint – 2F

	Wire Size	24 ga		22 ga		20 ga		18 ga		16 ga		14 ga		1/8"	
		Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS
120 Volt	.030"	11.0	258	13.0	313	13.1	374	14.0	393	14.0	415	14.5	455	-	-
	.035"	12.9	160	13.7	175	13.7	190	14.0	205	14.2	240	15.0	261	-	-
240 Volt	.030"	11.9	258	13.0	313	13.1	374	14.0	393	14.0	415	14.5	455	-	-
	.035"	12.9	160	13.7	175	13.7	190	14.0	205	14.2	240	15.0	261	16.0	375

Joint Type/Position: Lap Joint – 2F

	Wire Size	24 ga		22 ga		20 ga		18 ga		16 ga		14 ga		1/8"	
		Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS
120 Volt	.030"	14.0	139	14.0	173	14.0	213	14.0	241	14.0	292	15.1	362	16.1	402
	.035"	12.4	117	13.1	143	13.2	154	13.6	165	14.5	226	15.3	250	16.0	375
240 Volt	.030"	14.0	139	14.0	173	14.0	213	14.0	241	14.0	292	15.1	362	16.1	402
	.035"	12.4	117	13.2	143	13.2	154	13.6	165	14.5	226	15.3	250	16.0	375

Joint Type/Position: Butt Joint – 1G

	Wire Size	24 ga		22 ga		20 ga		18 ga		16 ga		14 ga		1/8"	
		Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS
120 Volt	.030"	-	-	14.0	173	14.0	213	14.0	241	14.0	292	15.1	362	16.1	402
	.035"	-	-	13.1	143	13.1	154	14.0	165	14.3	226	14.1	250	15.5	375
240 Volt	.030"	-	-	14.0	173	14.0	213	14.0	241	13.9	292	15.1	362	15.4	402
	.035"	-	-	13.1	143	13.1	154	13.5	165	14.3	226	15.0	250	15.5	375