

Miller[®] 141 Silicon Bronze Parameters

Machine Set-up:

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

		24 ga		22 ga		20 ga		18 ga		16 ga		14 ga		1/8"	
Wire Size		Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS
120 Volt	.030"	1	55	2.5	60	3	65	3.5	70	4	75	5.5	90	7.5	100
	.035"	-	-	2.5	50	2.5	50	3	60	4.5	70	5	70	10	95

Joint Type/Position: Lap Joint – 2F

		24 ga		22 ga		20 ga		18 ga		16 ga		14 ga		1/8"	
Wire Size		Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS
120 Volt	.030"	1	55	2.5	60	3	60	3.5	70	4	75	5	90	7.5	90
	.035"	-	-	2.5	50	3	50	3	55	4	70	4	70	7.5	95

Joint Type/Position: Butt Joint – 1G

		24 ga		22 ga		20 ga		18 ga		16 ga		14 ga		1/8"	
Wire Size		Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS
120 Volt	.030"	1	55	2.5	60	3	60	3.5	70	4	70	5.5	90	-	-
	.035"	-	-	2	45	2	50	2.5	55	4	70	4	70	7.5	90