



OptX™ PARAMETER CHART



QUESTIONS?



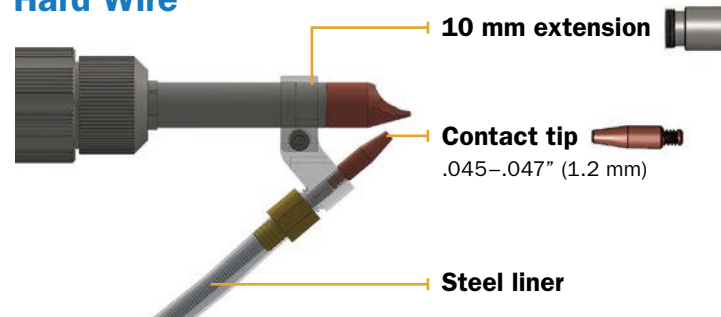
1-866-931-9730
 PWSService@millerwelds.com
 MillerWelds.com/optxinfo

Steel/Stainless Steel

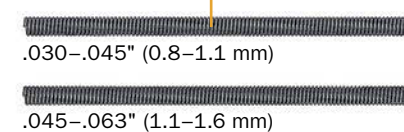
Material	Shielding Gas	Weld Type	Wire Size	Program	20 ga (.04")		18 ga (.05")		16 ga (.06")		14 ga (.08")		12 ga (.11")		1/8" (.13")		3/16" (.19")		1/4" (.25")		5/16" (.31")		
					Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power
Steel	100% Nitrogen	Spot	—	A3	400	—	500	—	600	—	800	—	1,000	—	1,290	—	1,890	—	2,000**	—	—	—	
		Autogenous	—	A4	310	—	390	—	470	—	620	—	750	—	970	—	1,480	—	1,940*	—	1,940*	—	
		Wire ER70S-6	.045"	A5	720	15	790	15	920	15	1,060	15	1,300	15	1,500	15	1,840	10	2,000*	5	—	—	
		Cleaning	—	C0	Low																		
			—	C1	Medium																		
			—	C2	High																		
Stainless Steel	100% Nitrogen	Spot	—	A0	320	—	400	—	480	—	650	—	850	—	1,050	—	1,530	—	2,000	—	—	—	
		Autogenous	—	A1	310	—	390	—	470	—	620	—	800	—	970	—	1,480	—	1,940*	—	2,000*	—	
		Wire 308L	.045"	A2	720	15	790	15	920	15	1,060	15	1,360	15	1,600	15	1,720	10	2,000*	5	—	—	
		Cleaning	—	C0	Low																		
			—	C1	Medium																		
			—	C2	High																		

Note: Parameters are suggested settings.
 Additional adjustments may be required.
 *Wobble Frequency set at -25
 **Wobble Length set at -2

Hard Wire



Steel liner



V-groove





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Aluminum

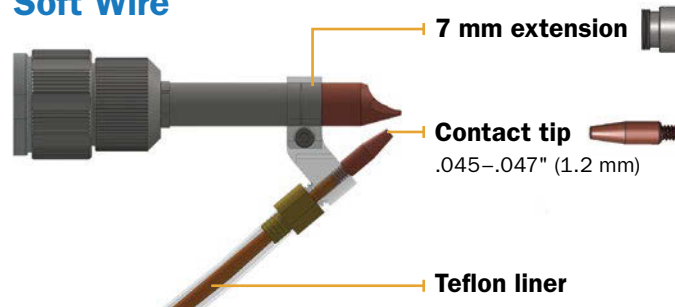
Material	Shielding Gas	Weld Type	Wire Size	Program	20 ga (.03")		18 ga (.04")		16 ga (.05")		14 ga (.06")		12 ga (.08")		1/8" (.13")		3/16" (.19")		1/4" (.25")		5/16" (.31")		
					Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power
Aluminum 6XXX	100% Argon	Spot	—	F3	—	—	300*	—	400	—	480	—	600	—	950	—	1,500	—	—	—	—	—	
		Autogenous	—	F4	—	—	300	—	400	—	480	—	600	—	900	—	1,400	—	—	—	—	—	
		Wire 5356	.047"	F5	—	—	500	20	600	20	750	20	900	20	1,300	20	1,700	20	—	—	—	—	
		Cleaning	—	H0	Low																		
—			H1	Medium																			
—			H2	High																			
Aluminum 5XXX		Spot	—	F0	—	—	300*	—	375	—	450	—	550	—	900	—	1,600	—	—	—	—	—	
		Autogenous	—	F1	—	—	300	—	400	—	450	—	600	—	900	—	1,350*	—	1,750*	—	—	—	
		Wire 5356	.047"	F2	—	—	500	20	600	20	750	20	900	20	1,300	20	1,700	20	2,000	15	—	—	
		Cleaning	—	H0	Low																		
—	H1		Medium																				
—	H2		High																				

Note: Parameters are suggested settings. Additional adjustments may be required.

*Wobble Frequency set at -25

**Wobble Length set at -2

Soft Wire



Teflon liner

.030-.047" (0.8-1.2 mm)

.047-.063" (1.2-1.6 mm)

U-groove

