

# Multimatic® 220 AC/DC Silicon Bronze Parameters

## Machine Set-up:

Process Select: MIG Steel C25  
 Auto-Set: Turned Off (*Use Manual Mode*)  
 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"	11.9	258	12.6	305	13.1	374	14.0	393	14.2	435	14.5	465	-	-
	.035"	12.4	150	13.7	175	13.7	215	14.0	215	14.8	240	15.3	310	-	-
240 Volt	.030"	11.9	258	12.6	305	13.1	374	14.0	393	14.2	435	14.5	465	-	-
	.035"	12.4	150	13.7	175	13.7	215	14.0	215	14.8	240	15.3	310	15.5	380

### 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"	13.4	173	13.9	259	14.0	300	14.2	320	14.2	334	15.1	386	16.1	416
	.035"	12.4	135	13.2	161	13.7	186	14.0	215	14.5	226	15.3	250	15.5	375
240 Volt	.030"	13.4	173	13.9	259	14.0	300	14.2	320	14.2	334	15.1	386	16.1	416
	.035"	12.4	135	13.2	161	13.7	186	14.0	215	14.5	226	15.3	250	15.5	375

### Joint Type/Position: Butt Joint – 1G

	Wire Size	22 ga		20 ga		18 ga		16 ga		14 ga		1/8"	
		Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS	Volts	WFS
120 Volt	.030"	13.9	259	14.0	300	14.2	320	14.2	334	15.1	386	15.8	416
	.035"	13.2	161	13.7	186	14.0	215	14.3	226	15.0	250	15.0	375
240 Volt	.030"	13.9	259	14.0	300	14.2	320	14.2	334	15.1	386	15.8	416
	.035"	13.2	161	13.7	186	14.0	215	14.3	226	15.0	250	15.0	375