

HPP MIG WIRE - TYPICAL OPERATING PARAMETERS

BUILDUP AND JOINING WIRES

HPP #	Size	Amps	Volts	Wire Stick Out	SPRAY ARC MODE SHIELDING GAS	Amps	Volts	Wire Stick Out	SHORT ARC MODE SHIELDING GAS	Polarity
103M	0.035	140-220	22-29	1/2"-3/4"	98%Ar + 2% O2	60-140	14-22	1/2"-3/4"	75%Ar + 25%CO2	DCRP
103M	0.045	180-260	23-30	1/2"-3/4"	98%Ar + 2% O2	80-160	15-24	1/2"-3/4"	75%Ar + 25%CO2	DCRP
103M	1/16"	230-350	24-31	1/2"-3/4"	98%Ar + 2% O2			1/2"-3/4"	75%Ar + 25%CO2	DCRP
104M	0.035	140-220	22-29	1/2"-3/4"	98%Ar + 2% O2	60-140	14-22	1/2"-3/4"	75%Ar + 25%CO2	DCRP
104M	0.045	180-260	23-30	1/2"-3/4"	98%Ar + 2% O2	80-160	15-24	1/2"-3/4"	75%Ar + 25%CO2	DCRP
104M	1/16" (.062)	230-350	24-31	1/2"-3/4"	98%Ar + 2% O2			1/2"-3/4"	75%Ar + 25%CO2	DCRP
105M	0.035	140-220	22-29	1/2"-3/4"	98%Ar + 2% O2	60-140	14-22	1/2"-3/4"	75%Ar + 25%CO2	DCRP
105M	0.045	180-260	23-30	1/2"-3/4"	98%Ar + 2% O2	80-160	15-24	1/2"-3/4"	75%Ar + 25%CO2	DCRP
105M	1/16"	230-350	24-31	1/2"-3/4"	98%Ar + 2% O2			1/2"-3/4"	75%Ar + 25%CO2	DCRP
151M	0.035	140-220	22-29	1/2"-3/4"	99%Ar 1%O2 or 98%Ar 2%O2	60-140	14-22	1/2"-3/4"	90%He 7.5%Ar 2.5%CO2 or 75/25	DCRP
151M	0.045	180-260	23-30	1/2"-3/4"	99%Ar 1%O2 or 98%Ar 2%O2	80-160	15-24	1/2"-3/4"	90%He 7.5%Ar 2.5%CO2 or 75/25	DCRP
160M	.030	xxxx	xxxx	xxxx	98%Ar + 2% O2	25-180	14-24	1/4"-3/8"	75%Ar + 25%CO2 or Straight CO2	DCRP
160M	0.035	xxxx	xxxx	xxxx	98%Ar + 2% O2	60-225	15-24	1/4"-3/8"	75%Ar + 25%CO2 or Straight CO2	DCRP
160M	0.045	xxxx	xxxx	xxxx	98%Ar + 2% O2	100-325	17-34	3/8"-1/2"	75%Ar + 25%CO2 or Straight CO2	DCRP
164Mfc	0.035	xxxx	xxxx	xxxx	xxxx	100-225	22-27	3/8"-1/2"	75%Ar + 25%CO2 or Straight CO2	DCRP
164Mfc	0.045	xxxx	xxxx	xxxx	xxxx	125-250	24-27	3/8"-1/2"	75%Ar + 25%CO2 or Straight CO2	DCRP
164Mfc	1/16"	xxxx	xxxx	xxxx	xxxx			3/8"-3/4"	75%Ar + 25%CO2 or Straight CO2	DCRP
164Mfc	5/64"	xxxx	xxxx	xxxx	xxxx			3/8"-3/4"	75%Ar + 25%CO2 or Straight CO2	DCRP
673M	0.030	xxxx	xxxx	xxxx	xxxx	60-170	13-24	3/8"-3/4"	Argon	DCRP
673M	0.035	xxxx	xxxx	xxxx	xxxx	70-180	15-26	3/8"-3/4"	Argon	DCRP
673M	0.045	xxxx	xxxx	xxxx	xxxx				Argon	DCRP
673M	3/64"	xxxx	xxxx	xxxx	xxxx	140-260	20-29	3/8"-3/4"	Argon	DCRP

* mig parameter chart is only a guide

HPP MIG WIRE - TYPICAL OPERATING PARAMETERS

BUILDUP AND JOINING WIRES

HPP #	Size	Amps	Volts	Wire Stick Out	SHORT ARC MODE SHIELDING GAS	Polarity
254M	1/16" (.062)	100-200	22-28	1/2"-3/4"	open arc wire or CO2	DCRP
254M	3/32" (.093)	200-300	24-28	1"-11/4"	open arc wire or CO2	DCRP
254M	7/64" (.109)	350-500	32-37	11/4"-11/2"	open arc wire or CO2	DCRP

310M	0.035	150-180	26-28	1/2"	98% Ar 2% CO2	DCRP
310M	0.045	220-250	27-29	1/2"	98% Ar 2% CO2	DCRP

BUILD UP AND HARDFACING WIRES

HPP #	Size	Amps	Volts	Wire Stick Out	SHIELDING GAS	Polarity	Hardness
220M fc	1/16" (.062)	175-350	24-28	1/2"-1"	75%Ar + 25%CO2 or CO2	DCRP	55-60 RC
220M fc	0.045	150-250	22-26	1/2"-3/4"	75%Ar + 25%CO2 or CO2	DCRP	55-60 RC

220M mc	1/16" (.062)	175-350	24-28	1/2"-1"	75%Ar + 25%CO2	DCRP	55-60 RC
220M mc	0.045	150-250	22-26	1/2"-3/4"	75%Ar + 25%CO2	DCRP	55-60 RC

222M	1/16" (.062)	145-195	18-24	1/2"-3/4"	None	DCRP	up to 50-55 RC
222M	0.045	150-275	25-28	1"-11/4"	None	DCRP	up to 50-55 RC
222M	7/64" (.109)	350-450	26-30	11/2"-2"	None	DCRP	up to 50-55 RC

225M	0.045	145-195	18-24	1/2"-3/4"	None	DCRP	up to 50-55 RC
225M	1/16" (.062)	150-275	25-28	3/4"-11/4"	None	DCRP	up to 50-55 RC
225M	7/64" (.109)	175-500	28-32	1"-11/2"	None	DCRP	up to 50-55 RC

226M	0.045	150-200	22-26	1/2"-3/4"	open arc wire or CO2	DCRP	40-45 RC
226M	1/16" (.062)	175-350	24-28	1/2"-1"	open arc wire or CO2	DCRP	40-45 RC
226M	7/64" (.109)	300-700	30-36	1"-11/2"	open arc wire or CO2	DCRP	40-45 RC

252M	0.045	150-200	21-28	1/2"-3/4"	open arc wire or CO2	DCRP	58 -62 RC
252M	1/16" (.062)	175-350	24-28	1/2"-1"	open arc wire or CO2	DCRP	58 -62 RC

** for spray arc use higher of parameters // for short arc use lower of parameters

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