TYPICAL WELDING PARAMETERS OF MILD & LOW ALLOY TIG, MIG AND SMAW					
Process	Diameter of Wire		Voltage (V)	Amperage (A)	Shielding Gas
	Inches	Millimeters			
TIG (GTAW)	0.035	0.9	12-Oct	50 - 70	100% Argon
	0.045	1.2	12-Oct	70 - 100	
	1/16"	1.6	15-Dec	100 - 125	
	3/32"	2.4	15 - 20	125 - 175	
	1/8"	3.2	15 - 20	175 - 250	
MIG (GMAW) SPRAY TRANSFER	0.035	0.9	28 - 32	165 - 200	98% Argon + 2% Oxygen or 75% Argon + 25% CO2
	0.045	1.2	30 - 34	180 - 220	
	1/16"	1.6	30 - 34	230 - 260	
MIG (GMAW) SHORT CIRCUITING TRANSFER	0.035	0.9	22 - 25	100 - 140	100% CO2
	0.045	1.2	23 - 26	120 - 150	75% Argon + 25% CO2

TYPICAL WELDING PARAMETERS OF MILD STEEL & LOW ALLOY SMAW (ELECTRODES)				
Diameter of Rod		Voltage (V)	Amperage (A)	
Inches	Millimeters		Flat	Vertical & Overhead
3/32"	2.4	21-25	65-80	65-75
1/8"	3.2	21-25	90-110	80-95
5/32"	4.0	21-26	135-160	120-140
3/16"	4.8	22-26	160-210	140-160

TYPICAL WELDING PARAMETERS OF MILD & LOW ALLOY STEEL FCAW (FLUX CORED)							
Diameter of Wire		FLAT		VERTICAL - UP		OVERHEAD	
Inches	Millimeters	Voltage (V)	Amperage (A)	Voltage (V)	Amperage (A)	Voltage (V)	Amperage (A)
0.035	0.9	20-30	130-250	16-23	90-180	20-28	130-240
0.045	1.14	23-30	150-280	22-26	150-250	24-29	150-250
16-Jan	1.6	25-34	180-400	21-27	180-300	24-30	180-310