

### Wire Welding (MIG/Flux-Cored) Parameters for Spoolmate™ 100

Material	Wire Type	Polarity*	Shielding Gas	Wire Dia.	24 ga. 120 V / 240 V	22 ga. 120 V / 240 V	20 ga. 120 V / 240 V	18 ga. 120 V / 240 V	16 ga. 120 V / 240 V	14 ga. 120 V / 240 V	1/8" 120 V / 240 V	3/16" 240 V	1/4" 240 V	3/8" 240 V
Steel	Solid Wire ER70S-6	DCEP	Ar/CO <sub>2</sub> "C25"	0.024	16 / 3.7	16 / 3.7	16.2 / 4.6	16.7 / 8.8	17.7 / 9.3	18.4 / 9.9	18.9 / 10			
				0.030	15.4 / 0	15.4 / 0	16 / 0.6	17 / 1	17 / 3.2	17.8 / 4.8	19.5 / 6	20.1 / 6.9	21.8 / 7.5	
				0.035			16 / 0.2	17 / 0.8	17.7 / 1.6	18.4 / 1.5	19.6 / 2.8	20.8 / 3.9	21 / 4.3	22.1 / 5
			CO <sub>2</sub> "C100"	0.024	17 / 0.7	17 / 0.7	17.5 / 1.3	18.6 / 2.5	19.8 / 3.8	21 / 8.9	21.8 / 10			
				0.030	17 / 0.3	17 / 0.3	17.5 / 0.5	18.6 / 1.5	17.4 / 3.2	19.3 / 3.9	21.2 / 5.1	21.8 / 5.6		
				0.035			17.5 / 0.3	18.6 / 1.2	19.8 / 1.9	20.5 / 2.2	20.9 / 2.9	21.8 / 3.2		
Stainless Steel	Flux-Cored E71T-11	DCEN	None "Flux"	0.030						18.3 / 3.6	18.5 / 3.8	20.5 / 5.2	22.5 / 8.6	
				0.035							18.5 / 3.5	20.5 / 4.7	21.5 / 5.5	22 / 6.5
Aluminum	Aluminum ER4043	DCEP	Argon	0.030						14.8 / 8.5	15.2 / 8.8	20.7 / 9.8	22.5 / 10	
				0.035						14.8 / 8.2	15.2 / 8.6	20.3 / 9.7	21.4 / 9.9	

### Wire Welding (MIG/Flux-Cored) Parameters for Spoolmate™ 150

Material	Wire Type	Polarity*	Shielding Gas	Wire Dia.	24 ga. 120 V / 240 V	22 ga. 120 V / 240 V	20 ga. 120 V / 240 V	18 ga. 120 V / 240 V	16 ga. 120 V / 240 V	14 ga. 120 V / 240 V	1/8" 120 V / 240 V	3/16" 240 V	1/4" 240 V	3/8" 240 V
Steel	Solid Wire ER70S-6	DCEP	Ar/CO <sub>2</sub> "C25"	0.030	15.4 / 0	15.4 / 0	16 / 0.5	17 / 1	17.7 / 1.4	17.8 / 4.8	19.5 / 6	20.1 / 6.9	21.8 / 7.4	
				0.035			16 / 0.2	17 / 0.6	17.7 / 1.1	18.4 / 1.3	19.6 / 2.2	20.8 / 3.9	21 / 4.3	22.1 / 4.7
			CO <sub>2</sub> "C100"	0.030	17 / 0.2	17 / 0.2	17.5 / 0.5	18.6 / 1.1	19.8 / 1.5	19.3 / 3.6	21.2 / 4.6	21.3 / 5.2		
				0.035			17.5 / 0.1	18.6 / 0.6	19.8 / 1	20.5 / 1.2	19.3 / 3.6	21.2 / 4.6	21.3 / 5.2	
	Flux-Cored E71T-11	DCEN	None "Flux"	0.030						18.3 / 3.3	19.3 / 4.1	21.4 / 7.9	22.5 / 8.6	
				0.035							18.5 / 3.2	20.5 / 4.4	21.5 / 5.3	22 / 6.5
Stainless Steel	Stainless Steel	DCEP	"Trigas"	0.030		18 / 0	18.3 / 0.4	18.5 / 0.8	18.9 / 1.1	19.4 / 1.6	21.5 / 7	22.5 / 7.2		
				0.035			18.3 / 0.1	18.5 / 0.2	18.9 / 0.4	19.4 / 0.9	20.9 / 3.7	21.5 / 3.9	22.3 / 4.2	
Aluminum	Aluminum ER4043	DCEP	Argon	0.030					14.8 / 7.5	18 / 7.9	20.7 / 8.4	21.6 / 8.9		
				0.035					15.4 / 3.8	18 / 6.5	19.3 / 7.8	20.4 / 8.8		
	Aluminum ER5356	DCEP	Argon	0.030					14.5 / 8.9	15.7 / 9.2				
				0.035					15.8 / 7.4	17.2 / 8.7	19.2 / 10			

\*Polarity selection is done automatically by the power source.

Note: Some parameters are not available in 120 V due to limited input power. **Blue values** are only available when connected to 240 V.