



# OptX™ 1kW PARAMETER CHART



QUESTIONS?

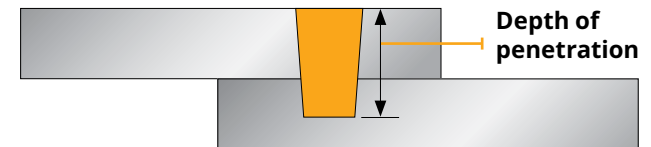
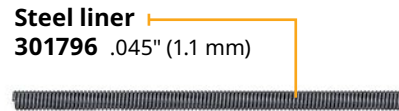
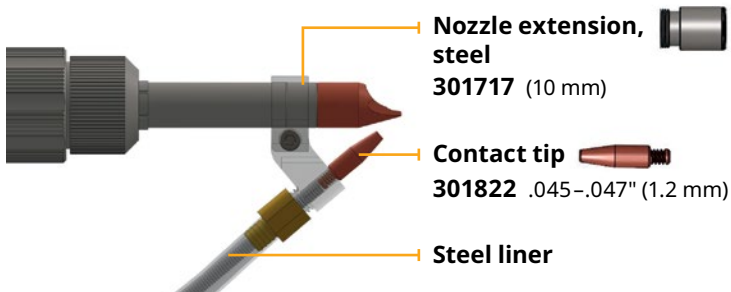


1-866-931-9730  
 PWSService@millerwelds.com  
 MillerWelds.com/optxinfo

## Steel/Stainless Steel (Parameters are suggested settings. Additional adjustments may be required.)

Material	Shielding Gas	Weld Type	Wire Size	Program	Depth of Penetration											
					20 ga (.04")		18 ga (.05")		16 ga (.06")		14 ga (.08")		12 ga (.11")		1/8" (.13")	
					Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS
Steel	100% Nitrogen	Spot	—	A3	210	—	270	—	330	—	420	—	660	—	850	—
		Autogenous	—	A4	310	—	390	—	470	—	620	—	750	—	970	—
		Wire ER70S-6	.045"	A5	520	15	600	15	720	15	920	15	1,000	10	—	—
Stainless Steel		Spot	—	A0	200	—	270	—	340	—	430	—	700	—	780	—
		Autogenous	—	A1	310	—	390	—	470	—	620	—	800	—	970	—
		Wire 308L	.045"	A2	480	15	540	15	640	15	820	15	1,000	12	—	—

### Steel/Stainless Steel Wire





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## Aluminum (Parameters are suggested settings. Additional adjustments may be required.)

Material	Shielding Gas	Weld Type	Wire Size	Program	Depth of Penetration											
					20 ga (.03")		18 ga (.04")		16 ga (.05")		14 ga (.06")		12 ga (.08")		1/8" (.13")	
					Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS
Aluminum 6XXX	100% Argon	Spot	—	F3	—	—	300*	—	400	—	480	—	600	—	950	—
		Autogenous	—	F4	—	—	300	—	400	—	480	—	600	—	900	—
		Wire 5356	.047"	F5	—	—	500	20	600	20	750	20	900	20	—	—
Spot		—	F0	—	—	300*	—	380	—	450	—	550	—	900	—	
Autogenous		—	F1	—	—	—	300	—	400	—	450	—	600	—	900	—
Wire 5356		.047"	F2	—	—	—	—	500	20	600	20	750	20	900	20	—
Aluminum 5XXX																

### Aluminum Wire

