



# OptX™ 2kW PARAMETER CHART



QUESTIONS?



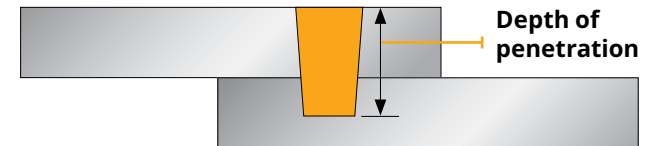
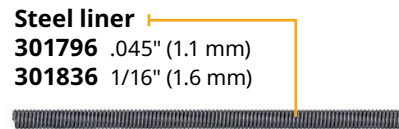
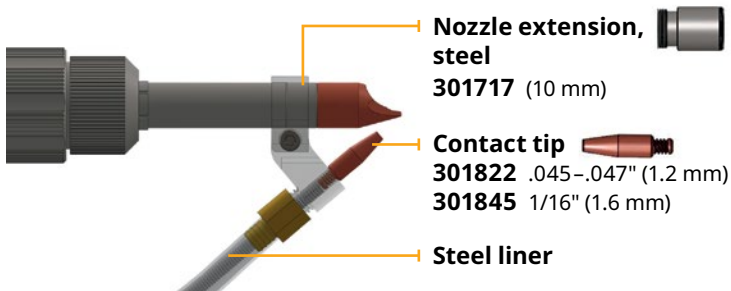
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 PWService@millerwelds.com  
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## Steel/Stainless Steel (Parameters are suggested settings. Additional adjustments may be required.)

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")		3/16" (.19")		1/4" (.25")		5/16" (.31")		
					Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	
Steel	100% Nitrogen	Spot	—	A3	210	—	270	—	330	—	420	—	660	—	850	—	1,360	—	1,990	—	—	—	
		Autogenous	—	A4	310	—	390	—	470	—	620	—	750	—	970	—	1,480	—	1,940*	—	2,000*	—	
		Wire ER70S-6	.045"	A5	520	15	600	15	720	15	920	15	1,300	15	1,550	15	2,000	10	2,000*	5	—	—	
			1/16"	A6	—	—	800	15	980	15	1,170	15	1,600	15	1,860	12	1,950*	8	—	—	—	—	
		Cleaning	—	C0	Low (Default Setting: 800 W, 15 mm)																		
			—	C1	Medium (Default Setting: 900 W, 15 mm)																		
—	C2		High (Default Setting: 1,000 W, 15 mm)																				
Stainless Steel	100% Nitrogen	Spot	—	A0	210	—	270	—	340	—	430	—	700	—	780	—	1,150	—	1,750	—	—	—	
		Autogenous	—	A1	310	—	390	—	470	—	620	—	800	—	970	—	1,480	—	1,940*	—	2,000*	—	
		Wire 308L	.045"	A2	480	15	540	15	640	15	820	15	1,360	15	1,660	15	2,000	10	2,000*	5	—	—	
			1/16"	A8	—	—	800	15	980	15	1,170	15	1,600	15	1,860	12	1,900*	8	—	—	—	—	
		Cleaning	—	C0	Low (Default Setting: 800 W, 15 mm)																		
			—	C1	Medium (Default Setting: 900 W, 15 mm)																		
—	C2		High (Default Setting: 1,000 W, 15 mm)																				

\*Wobble Frequency set at -25. Note: Recommended retract for .045" wire is 0.45" and 1/16" wire is 0.65".

## 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")		3/16" (.19")		1/4" (.25")		5/16" (.31")			
					Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS	Power	WFS		
Aluminum 6XXX	100% Argon	Spot	—	F3	—	—	300*	—	400	—	480	—	600	—	950	—	1,500	—	—	—	—	—		
		Autogenous	—	F4	—	—	300	—	400	—	480	—	600	—	900	—	1,400	—	—	—	—	—		
		Wire 5356	.047"	F5	—	—	500	20	600	20	750	20	900	20	1,700	20	2,000**	8	—	—	—	—		
			1/16"	F6	—	—	—	—	650	20	750	20	1,050	20	1,500	20	—	—	—	—	—	—		
		Cleaning	—	H0	Low (Default Setting: 1,200 W, 15 mm)																			
			—	H1	Medium (Default Setting: 1,300 W, 15 mm)																			
—	H2		High (Default Setting: 1,400 W, 15 mm)																					
Aluminum 5XXX	100% Argon	Spot	—	F0	—	—	300*	—	380	—	450	—	550	—	900	—	1,600	—	—	—	—	—		
		Autogenous	—	F1	—	—	300	—	400	—	450	—	600	—	900	—	1,350*	—	1,750*	—	—	—		
		Wire 5356	.047"	F2	—	—	500	20	600	20	750	20	900	20	1,650	20	2,000	10	2,000**	8	—	—		
			1/16"	F7	—	—	—	—	620	20	750	20	950	20	1,400	20	2,000	8	—	—	—	—		
		Cleaning	—	H0	Low (Default Setting: 1,200 W, 15 mm)																			
			—	H1	Medium (Default Setting: 1,300 W, 15 mm)																			
—	H2		High (Default Setting: 1,400 W, 15 mm)																					

\*Wobble Frequency set at -25. \*\*Wobble Length set at -2. Note: Recommended retract for .047" wire is 0.45" and 1/16" wire is 0.65".

### Aluminum Wire

