

## Guide for basic Welding on Steel

Base Metal Thickness	SOLID Mig wire			CORED Mig Wire			Stick Electrode		
	.023"	.030"	.035"	.030"	.035"	.045"	1/16"	3/32"	1/8"
.031 (22 GAUGE)	■	■		■					
.037 (20 GAUGE)	■	■		■	■				
.050 (18 GAUGE)		■	■	■	■	■			
.063 (16 GAUGE)		■	■	■	■	■	■		
.078 (14 GAUGE)			■	■	■	■	■	■	
.125 (11 GAUGE)			■		■	■	■	■	■
.188 (7 GAUGE)			■		■	■	■	■	■
.250 (3 GAUGE)			■			■	■	■	■

Basic Short Circuit Parameters for Steel using CO<sub>2</sub> or 75% Ar / 25% CO<sub>2</sub>

Wire Diameter	Amps	WFS
.023	30-80	100-375
.030	40-140	85-325
.035	50-180	80-400
.045	75-250	75-275