

# R-Tech MIG180 Mig Welder



## WELDING SETTINGS CARBON STEEL - 0.6MM WIRE DIAMETER

INFO	JOINT	MATERIAL	MATERIAL	WIRE	FILLER	GAS	VOLTAGE	VOLTAGE	WIRE SPEED	WIRE SPEED	POWER
SYMBOL	TYPE	THICKENSS	TYPE	DIA	TYPE	TYPE / MIX	DIAL	SETTING	DIAL	SETTING	AMPS
	FILLET	1.0	CARBON STEEL	0.6	A18	ARGON +5%CO2		2.5		7	63
	FILLET	2.0	CARBON STEEL	0.6	A18	ARGON +5%CO2		3.5		8.5	84
	FILLET	3.0	CARBON STEEL	0.6	A18	ARGON +5%CO2		5		10	97
	LAP JOINT	1.0	CARBON STEEL	0.6	A18	ARGON +5%CO2		2.5		7	63
	LAP JOINT	2.0	CARBON STEEL	0.6	A18	ARGON +5%CO2		3.5		8.5	84
	LAP JOINT	3.0	CARBON STEEL	0.6	A18	ARGON +5%CO2		5		10	97
	BUTT WELD	1.0	CARBON STEEL	0.6	A18	ARGON +5%CO2		1		4	56
	BUTT WELD	2.0	CARBON STEEL	0.6	A18	ARGON +5%CO2		3.5		8.5	84
	BUTT WELD	3.0	CARBON STEEL	0.6	A18	ARGON +5%CO2		5		10	97
	OPEN CORNER	1.0	CARBON STEEL	0.6	A18	ARGON +5%CO2		1		4	56
	OPEN CORNER	2.0	CARBON STEEL	0.6	A18	ARGON +5%CO2		3.5		8.5	84
	OPEN CORNER	3.0	CARBON STEEL	0.6	A18	ARGON +5%CO2		5		10	97

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## WELDING SETTINGS CARBON STEEL - 0.8MM WIRE DIAMETER

INFO	JOINT	MATERIAL	MATERIAL	WIRE	FILLER	GAS	VOLTAGE	VOLTAGE	WIRE SPEED	WIRE SPEED	POWER
SYMBOL	TYPE	THICKENSS	TYPE	DIA	TYPE	TYPE / MIX	DIAL	SETTING	DIAL	SETTING	AMPS
	FILLET	1.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		1.5		2	54
	FILLET	2.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		3		4	88
	FILLET	3.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		3.5		5.5	130
	FILLET	4.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		5.5		7	150
	FILLET	5.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		8		8	162
	FILLET	6.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		9		10	180
	LAP JOINT	1.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		1.5		2	54
	LAP JOINT	2.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		3		4	88
	LAP JOINT	3.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		3.5		5.5	130
	LAP JOINT	4.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		5.5		7	150
	LAP JOINT	5.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		8		8	162
	LAP JOINT	6.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		9		10	180
	BUTT WELD	1.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		1		1.5	49
	BUTT WELD	2.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		2		3	74
	BUTT WELD	3.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		3.5		5.5	130
	BUTT WELD	4.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		5.5		7	150
	BUTT WELD	5.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		8		8	162
	BUTT WELD	6.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		9		10	180
	OPEN CORNER	1.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		1		1.5	49
	OPEN CORNER	2.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		2		3	74
	OPEN CORNER	3.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		3.5		5.5	130
	OPEN CORNER	4.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		5.5		7	150
	OPEN CORNER	5.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		8		8	162
	OPEN CORNER	6.0	CARBON STEEL	0.8	A18	ARGON +5%CO2		9		10	180