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| Material Thickness | Wirefeed Speed (IPM) | Voltage |
| 22 ga (.0312) | 90 - 100 | 16 – 17 |
| 20 ga (.0375) | 105 - 115 | 17 – 18 |
| 18 ga (.050) | 140 – 160 | 18 – 19 |
| 16 ga (.0625) | 180 - 220 | 19 – 20 |
| 14 ga (.078) | 240 - 260 | 20 – 21 |
| 1/8” (.125) | 280 - 300 | 21 – 22 |
| 3/16” (.1875) | 320 - 340 | 21 – 22 |
| ¼” (.250) | 360 - 380 | 23 – 24 |
| 5/16” (.3125) | 400 - 420 | 23 – 24 |
| 3/8” (.375) | 420 - 520 | 24 - 25 |