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Changing Polarity

SPOT-ON™ Control
Automatic Polarity
for Solid Wire

SPOT-ON™ Control
Automatic Polarity
for Flux-Cored Wire



Read and follow
all labels and the
Owner's Manual
carefully.



Multimatic™ 215

Steel Wire Welding (MIG/Flux-Cored) Parameters

				SPOT-ON™ Control										SPOT-ON™ Control									
Wire	Shielding Gas	Wire Type	Wire Size	1/8" (3.2mm)	3/16" (4.8mm)	1/4" (6.3mm)	5/16" (7.9mm)	3/8" (9.5mm)	1/2" (12.7mm)	5/8" (15.9mm)	3/4" (19.1mm)	1" (25.4mm)	1 1/4" (31.8mm)	1/8" (3.2mm)	3/16" (4.8mm)	1/4" (6.3mm)	5/16" (7.9mm)	3/8" (9.5mm)	1/2" (12.7mm)	5/8" (15.9mm)	3/4" (19.1mm)	1" (25.4mm)	1 1/4" (31.8mm)
Steel	MIG	ER70S-6	0.035"	10-15	15-20	20-25	25-30	30-35	35-40	40-45	45-50	50-55	55-60	10-15	15-20	20-25	25-30	30-35	35-40	40-45	45-50	50-55	55-60
			0.045"	10-15	15-20	20-25	25-30	30-35	35-40	40-45	45-50	50-55	55-60	10-15	15-20	20-25	25-30	30-35	35-40	40-45	45-50	50-55	55-60
Aluminum	MIG	ER4043	0.035"	10-15	15-20	20-25	25-30	30-35	35-40	40-45	45-50	50-55	55-60	10-15	15-20	20-25	25-30	30-35	35-40	40-45	45-50	50-55	55-60
			0.045"	10-15	15-20	20-25	25-30	30-35	35-40	40-45	45-50	50-55	55-60	10-15	15-20	20-25	25-30	30-35	35-40	40-45	45-50	50-55	55-60

Aluminum Wire Welding (MIG) Parameters

				SPOT-ON™ Control										SPOT-ON™ Control									
Wire	Shielding Gas	Wire Type	Wire Size	1/8" (3.2mm)	3/16" (4.8mm)	1/4" (6.3mm)	5/16" (7.9mm)	3/8" (9.5mm)	1/2" (12.7mm)	5/8" (15.9mm)	3/4" (19.1mm)	1" (25.4mm)	1 1/4" (31.8mm)	1/8" (3.2mm)	3/16" (4.8mm)	1/4" (6.3mm)	5/16" (7.9mm)	3/8" (9.5mm)	1/2" (12.7mm)	5/8" (15.9mm)	3/4" (19.1mm)	1" (25.4mm)	1 1/4" (31.8mm)
Aluminum	MIG	ER4043	0.035"	10-15	15-20	20-25	25-30	30-35	35-40	40-45	45-50	50-55	55-60	10-15	15-20	20-25	25-30	30-35	35-40	40-45	45-50	50-55	55-60
			0.045"	10-15	15-20	20-25	25-30	30-35	35-40	40-45	45-50	50-55	55-60	10-15	15-20	20-25	25-30	30-35	35-40	40-45	45-50	50-55	55-60

TIG Welding Parameters

				SPOT-ON™ Control										SPOT-ON™ Control									
Wire	Shielding Gas	Wire Type	Wire Size	1/8" (3.2mm)	3/16" (4.8mm)	1/4" (6.3mm)	5/16" (7.9mm)	3/8" (9.5mm)	1/2" (12.7mm)	5/8" (15.9mm)	3/4" (19.1mm)	1" (25.4mm)	1 1/4" (31.8mm)	1/8" (3.2mm)	3/16" (4.8mm)	1/4" (6.3mm)	5/16" (7.9mm)	3/8" (9.5mm)	1/2" (12.7mm)	5/8" (15.9mm)	3/4" (19.1mm)	1" (25.4mm)	1 1/4" (31.8mm)
Steel	TIG	ER70S-6	0.035"	10-15	15-20	20-25	25-30	30-35	35-40	40-45	45-50	50-55	55-60	10-15	15-20	20-25	25-30	30-35	35-40	40-45	45-50	50-55	55-60
			0.045"	10-15	15-20	20-25	25-30	30-35	35-40	40-45	45-50	50-55	55-60	10-15	15-20	20-25	25-30	30-35	35-40	40-45	45-50	50-55	55-60

Stick Welding Parameters

				SPOT-ON™ Control										SPOT-ON™ Control									
Wire	Shielding Gas	Wire Type	Wire Size	1/8" (3.2mm)	3/16" (4.8mm)	1/4" (6.3mm)	5/16" (7.9mm)	3/8" (9.5mm)	1/2" (12.7mm)	5/8" (15.9mm)	3/4" (19.1mm)	1" (25.4mm)	1 1/4" (31.8mm)	1/8" (3.2mm)	3/16" (4.8mm)	1/4" (6.3mm)	5/16" (7.9mm)	3/8" (9.5mm)	1/2" (12.7mm)	5/8" (15.9mm)	3/4" (19.1mm)	1" (25.4mm)	1 1/4" (31.8mm)
Steel	Stick	E7018	0.035"	10-15	15-20	20-25	25-30	30-35	35-40	40-45	45-50	50-55	55-60	10-15	15-20	20-25	25-30	30-35	35-40	40-45	45-50	50-55	55-60
			0.045"	10-15	15-20	20-25	25-30	30-35	35-40	40-45	45-50	50-55	55-60	10-15	15-20	20-25	25-30	30-35	35-40	40-45	45-50	50-55	55-60

NOTE: Settings are approximate. Adjust as required.
Always use proper technique.

WARNING: Always wear full personal protective equipment (PPE) when welding. See Owner's Manual for details on PPE requirements.

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Miller Welding Guide

Chao Zhang

A red circular graphic with a gradient, appearing as a semi-circle or a partial circle, located to the right of the author's name.

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