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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	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)
Steel	Argon	E70T-5	0.035	10	16	12	19	8	13	6	10	4	7	10	16	12	19	8	13	6	10	4	7
			0.045	12	20	14	23	10	16	8	13	6	10	12	20	14	23	10	16	8	13	6	10
			0.060	14	23	16	27	12	20	10	16	8	13	14	23	16	27	12	20	10	16	8	13
			0.075	16	26	18	30	14	23	12	20	10	16	16	26	18	30	14	23	12	20	10	16
Aluminum	Argon	E70T-5	0.035	10	16	12	19	8	13	6	10	4	7	10	16	12	19	8	13	6	10	4	7
			0.045	12	20	14	23	10	16	8	13	6	10	12	20	14	23	10	16	8	13	6	10
			0.060	14	23	16	27	12	20	10	16	8	13	14	23	16	27	12	20	10	16	8	13
			0.075	16	26	18	30	14	23	12	20	10	16	16	26	18	30	14	23	12	20	10	16

## Aluminum Wire Welding (MIG) Parameters

				SPOT-ON™ Control										SPOT-ON™ Control									
Wire	Shielding Gas	Wire Type	Wire Size	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)
Aluminum	Argon	E70T-5	0.035	10	16	12	19	8	13	6	10	4	7	10	16	12	19	8	13	6	10	4	7
			0.045	12	20	14	23	10	16	8	13	6	10	12	20	14	23	10	16	8	13	6	10
			0.060	14	23	16	27	12	20	10	16	8	13	14	23	16	27	12	20	10	16	8	13
			0.075	16	26	18	30	14	23	12	20	10	16	16	26	18	30	14	23	12	20	10	16

## TIG Welding Parameters

				SPOT-ON™ Control										SPOT-ON™ Control									
Wire	Shielding Gas	Wire Type	Wire Size	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)
Steel	Argon	E70T-5	0.035	10	16	12	19	8	13	6	10	4	7	10	16	12	19	8	13	6	10	4	7
			0.045	12	20	14	23	10	16	8	13	6	10	12	20	14	23	10	16	8	13	6	10
			0.060	14	23	16	27	12	20	10	16	8	13	14	23	16	27	12	20	10	16	8	13
			0.075	16	26	18	30	14	23	12	20	10	16	16	26	18	30	14	23	12	20	10	16

## Stick Welding Parameters

				SPOT-ON™ Control										SPOT-ON™ Control									
Wire	Shielding Gas	Wire Type	Wire Size	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)	Wire Speed (in/min)	Wire Speed (mm/min)
Steel	Argon	E70T-5	0.035	10	16	12	19	8	13	6	10	4	7	10	16	12	19	8	13	6	10	4	7
			0.045	12	20	14	23	10	16	8	13	6	10	12	20	14	23	10	16	8	13	6	10
			0.060	14	23	16	27	12	20	10	16	8	13	14	23	16	27	12	20	10	16	8	13
			0.075	16	26	18	30	14	23	12	20	10	16	16	26	18	30	14	23	12	20	10	16

NOTE: Settings are approximate. Adjust as required.  
Welding is recommended.

WARNING: Always wear full personal protective equipment when welding. See Owner's Manual for details.  
Welding is recommended.

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# Miller Welding Guide

**S Ben Porath**



## Miller Welding Guide:

A Practical Guide to Welding Solutions Robert W. Messler, Jr., 2019-04-29 As critically important as welding is to a wide spectrum of manufacturing construction and repair it is not without its problems Those dependent on welding know only too well how easy it is to find information on the host of available processes and on the essential metallurgy that can enable success but how frustratingly difficult it can be to find guidance on solving problems that sooner or later arise with welding welds or weldments Here for the first time is the book those that practice and or depend upon welding have needed and awaited A Practical Guide to Welding Solutions addresses the numerous technical and material specific issues that can interfere with success Renowned industrial and academic welding expert and prolific author and speaker Robert W Messler Jr guides readers to the solutions they seek with a well organized search based on how a problem manifests itself i e as distortion defect or appearance where it appears i e in the fusion zone heat affected zone or base metal or it certain materials or situations

**The Miller's, Millwright's and Engineer's Guide** Henry Pallett, 1866

**The Beginner's Guide to Blacksmithing** Lorelei Sims, 2022-08-16 The Beginner's Guide to Blacksmithing is an introduction to working with fire and metals that offers all the information and instruction you need to make a foray into this age old craft that is gaining in popularity with today's modern DIYers

**Advanced Welding and Deforming** Kapil Gupta, J. Paulo Davim, 2021-04-17 Advanced Welding and Deforming explains the background theory working principles technical specifications and latest developments on a wide range of advanced welding joining and deforming techniques The book's subject matter covers manufacturing with chapters specifically addressing remanufacturing and 3D printing applications Drawing on experts in both academia and industry coverage addresses theoretical developments as well as practical improvements from R D By presenting over 35 important processes from plasma arc welding to nano joining and hybrid friction stir welding this is the most complete guide to this field available This unique guide will allow readers to compare the characteristics of different processes understand how they work and create parameters for their effective implementation As part of a 4 volume set entitled Handbooks in Advanced Manufacturing this series also includes volumes on Advanced Machining and Finishing Additive Manufacturing and Surface Treatment and Sustainable Manufacturing Processes Provides theory operational parameters and the latest developments in over 35 different processes Addresses new welding technologies such as additive manufacturing using wire and arc as well as the latest developments in more traditional applications Introduces basic concepts in welding joining and deformation in three introductory chapters thus helping readers with a range of backgrounds engage with the subject matter

**Machine Design**, 1974

Economics and Cost Analysis for Operations and Project Managers - 3rd Edition Mahmoud Al-Odeh, Ph.D., *Economic and Cost Analysis For Operations and Project Managers - 2nd Edition* Mahmoud A. Al-Odeh, 2020-08-14

*How To Weld* Todd Bridigum, 2008-08-25 Welding is a skill that any do it yourself enthusiast needs in his or her arsenal How to Weld is the perfect introduction for newbies and an excellent refresher

for veteran welders a work so comprehensive that most readers won't need any further instruction In *How to Weld* a bestselling installment in the Motorbooks Workshop series AWS certified welding instructor Todd Bridigum thoroughly describes process and art of fusing metals including Tools and equipment commonly used Types of metals and their weldability Welding techniques Shop and site safety Types of joints In addition all popular types of welding variants are covered including gas welding shielded metal arc or stick welding gas metal arc welding MIG gas tungsten arc welding TIG brazing soldering and even metal cutting Each skills section concludes with a series of exercises each illustrated with captioned sequential color photography to fully explain and detail the techniques learned Mechanics automotive enthusiasts farmers metalworkers and other DIYers who can't bond metal can't make repairs and they can't create in short they can't do much of anything except bolt together pre-made parts With this thorough and completely illustrated all color tutorial by an experienced college level instructor readers can get on the path fabricating and fixing metals on their own *How To Weld* is the only book about welding they'll ever need The Motorbooks Workshop series covers topics that engage and interest auto and motorcycle enthusiasts Written by subject matter experts and illustrated with step by step and how it's done reference images Motorbooks Workshop is the ultimate resource for how to know how Platers' Guide, 1922 Contractors & Engineers Magazine, 1969 Regional Industrial Buying Guide, 2005 **The Farm Welding Handbook** Richard Finch, *American Machinist*, 1917 Thermal Energy Yatish T. Shah, 2018-01-12 The book details sources of thermal energy methods of capture and applications It describes the basics of thermal energy including measuring thermal energy laws of thermodynamics that govern its use and transformation modes of thermal energy conventional processes devices and materials and the methods by which it is transferred It covers 8 sources of thermal energy combustion fusion solar fission nuclear geothermal microwave plasma waste heat and thermal energy storage In each case the methods of production and capture and its uses are described in detail It also discusses novel processes and devices used to improve transfer and transformation processes **Catalog of Copyright Entries. Third Series** Library of Congress. Copyright Office, 1971 **The American Blacksmith**, 1914 *The Brass World and Platers Guide*, 1922 **American Machinist & Automated Manufacturing**, 1924 **Oil and Gas Pipelines** R. Winston Revie, 2015-04-01 A comprehensive and detailed reference guide on the integrity and safety of oil and gas pipelines both onshore and offshore Covers a wide variety of topics including design pipe manufacture pipeline welding human factors residual stresses mechanical damage fracture and corrosion protection inspection and monitoring pipeline cleaning direct assessment repair risk management and abandonment Links modern and vintage practices to help integrity engineers better understand their system and apply up to date technology to older infrastructure Includes case histories with examples of solutions to complex problems related to pipeline integrity Includes chapters on stress based and strain based design the latter being a novel type of design that has only recently been investigated by designer firms and regulators Provides information to help those who are responsible to

establish procedures for ensuring pipeline integrity and safety      **Heat Treater's Guide** Harry Chandler, 1996-01-01 The material is contained in more than 500 datasheet articles each devoted exclusively to one particular alloy a proven format first used in the complementary guide for irons and steels For even more convenience the datasheets are arranged by alloy groups nickel aluminum copper magnesium titanium zinc and superalloys The book provides very worthwhile and practical information in such areas as compositions trade names common names specifications both U S and foreign available products forms typical applications and properties mechanical fabricating and selected others This comprehensive resource also covers the more uncommon alloys by groups in the same datasheet format Included are refractory metals and alloys molybdenum tungsten niobium tantalum beryllium copper alloys cast and P M titanium parts P M aluminum parts lead and lead alloys tin rich alloys and sintering copper base materials copper tin bronze brass nickel silvers

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