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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" (6.4mm)	5/16" (8.0mm)	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" (6.4mm)	5/16" (8.0mm)	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" (6.4mm)	5/16" (8.0mm)	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" (6.4mm)	5/16" (8.0mm)	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" (6.4mm)	5/16" (8.0mm)	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" (6.4mm)	5/16" (8.0mm)	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" (6.4mm)	5/16" (8.0mm)	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" (6.4mm)	5/16" (8.0mm)	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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DP Hallahan



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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 Economics and Cost Analysis for Operations and Project Managers - 3rd Edition

Mahmoud Al-Odeh, Ph.D., **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

Economic and Cost Analysis For Operations and Project Managers - 2nd Edition Mahmoud A. Al-Odeh, 2020-08-14

How To Weld Todd Bridgum, 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 Bridgum 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.

Machine Design, 1974 **Platers' Guide**, 1922 **Contractors & Engineers Magazine**, 1969 *The Farm Welding Handbook*, Richard Finch, **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 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.

American Machinist, 1917 **The Brass World and Platers Guide**, 1922 **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

Progress in Metal Additive Manufacturing and Metallurgy Robert Pederson, 2020-12-03 The advent of additive manufacturing AM processes applied to the fabrication of structural components creates the need for design methodologies supporting structural optimization approaches that take into account the specific characteristics of the process While AM processes enable unprecedented geometrical design freedom which can result in significant reductions of component weight on the other hand they have implications in the fatigue and fracture strength due to residual stresses and microstructural features This is linked to stress concentration effects and anisotropy that still warrant further research This Special Issue of Applied Sciences brings together papers investigating the features of AM processes relevant to the mechanical behavior of AM structural components particularly but not exclusively from the viewpoints of fatigue and fracture behavior Although the focus of the issue is on AM problems related to fatigue and fracture articles dealing with other manufacturing processes with related problems are also be included

National Safety News
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