

Mild & Low Alloy Steel Flux Cored Welding Parameters

Typical Welding Parameters of Mild & Low Alloy Steel FCAW (FLUX CORED)							
Diameter of Wire		FLAT		VERTICAL-UP		OVERHEAD	
Inches	Millimeters	Voltage (V)	Amperage (A)	Voltage (V)	Amperage (A)	Voltage (V)	Amperage (A)
.035	0.9	20-30	130-250	16-23	90-180	20-28	130-240
.045	1.14	23-30	150-280	22-26	150-250	24-29	150-250
1/16	1.6	25-34	180-400	21-27	180-300	24-30	180-310

AWS CLASSIFICATION OF FLUX CORED WIRE

AWS A5.20

