

# MIG Inverter Selection Guide

## Mild Steel (Solid Wire)



Material Type & Mode of Transfer	Material Thickness	Amperage Range	Voltage Range	Jasic Inverter Model													
				160C	200C	200CS	200PFC	202C	252C	352C	272S	352S	452S	500SYN	250P	350P	500P
				230V	230V	230V	110/230V	230V	230V	400V	230V	400V	400V	400V	230V	400V	400V
Mild Steel (Dip Transfer)	0.8mm	40A - 55A	15V - 16V														
	1.0mm	50A - 60A	15V - 16V														
	1.2mm	70A - 80A	16V - 17V														
	1.6mm	90A - 110A	17V - 18V														
	2.0mm	120A - 130A	17V - 18V														
	3.2mm	140A - 150A	18V - 19V														
	5.0mm	160A - 170A	18V - 19V														
	6.4mm	180A - 190A	21V - 22V														
	8.0mm	200A - 210A	21V - 22V														
9.5mm	220A - 250A	23V - 24V															
Mild Steel (Spray Transfer)	3.2mm	160A - 170A	23V - 24V														
	5.0mm	180A - 190A	24V - 25V														
	6.4mm	200A - 210A	24V - 26V														
	8.0mm	220A - 250A	25V - 27V														
	9.5mm	270A - 300A	26V - 28V														
	12.7mm +	315A +	29V +														

- All suggested settings are a guide only. Weld tests should be carried out to ensure they meet the required specifications.
- It is important to use the appropriate wire diameter and gas mixture for your application to ensure optimum welding performance.

# MIG Inverter Selection Guide

## Stainless Steel (Solid Wire)



Material Type & Mode of Transfer	Material Thickness	Amperage Range	Voltage Range	Jasic Inverter Model													
				160C	200C	200CS	200PFC	202C	252C	352C	272S	352S	452S	500SYN	250P	350P	500P
				230V	230V	230V	110/230V	230V	230V	400V	230V	400V	400V	400V	230V	400V	400V
Stainless Steel (Dip Transfer)	1.2mm	50A - 60A	19V - 20V														
	1.6mm	70A - 80A	19V - 20V														
	2.0mm	90A - 110A	20V - 21V														
	3.0mm	120A - 130A	20V - 21V														
	5.0mm	140A - 150A	20V - 21V														
	6.4mm	160A - 170A	20V - 21V														
	8.0mm	180A - 190A	21V - 22V														
Stainless Steel (Spray Transfer)	5.0mm	160A - 170A	23V - 24V														
	6.4mm	180A - 190A	24V - 25V														
	8.0mm	200A - 210A	24V - 25V														
	9.5mm	250A - 275A	25V - 26V														
	12.7mm +	300A +	27V +														

- All suggested settings are a guide only. Weld tests should be carried out to ensure they meet the required specifications.
- It is important to use the appropriate wire diameter and gas mixture for your application to ensure optimum welding performance.

# MIG Inverter Selection Guide

## Aluminium (Solid Wire)



Material Type & Mode of Transfer	Material Thickness	Amperage Range	Voltage Range	Jasic Inverter Model													
				160C	200C	200CS	200PFC	202C	252C	352C	272S	352S	452S	500SYN	250P	350P	500P
				230V	230V	230V	110/230V	230V	230V	400V	230V	400V	400V	400V	400V	230V	400V
Aluminium	3.2mm	110A - 130A	21V - 22V														
	5.0mm	140A - 150A	23V - 24V														
	6.4mm	180A - 210A	24V - 25V														
	8.0mm	200A - 230A	26V - 27V														
	9.5mm	220A - 250A	26V - 28V														
	12.7mm +	300A +	29V +														

- All suggested settings are a guide only. Weld tests should be carried out to ensure they meet the required specifications.
- It is important to use the appropriate wire diameter and gas mixture for your application to ensure optimum welding performance.