

Wire Speed	
Setting	m/min
2	1.4
2.25	1.7
2.5	2.0
2.75	2.3
3	2.6
3.25	2.9
3.5	3.2
3.75	3.5
4	3.8
4.25	4.1
4.5	4.4
4.75	4.8
5	5.1
5.25	5.4
5.5	5.7
5.75	6.0
6	6.3
6.25	6.6
6.5	6.9
6.75	7.2
7	7.5
7.25	7.9
7.5	8.2
7.75	8.5
8	8.8
8.25	9.1
8.5	9.4
8.75	9.7
9	10.0
9.25	10.3
9.5	10.6
9.75	11.0
10	11.3

Volts	
Setting	volts
1	11.6
1.25	11.9
1.5	12.2
1.75	12.6
2	12.9
2.25	13.2
2.5	13.5
2.75	13.8
3	14.2
3.25	14.5
3.5	14.8
3.75	15.1
4	15.4
4.25	15.8
4.5	16.1
4.75	16.4
5	16.7
5.25	17.1
5.5	17.4
5.75	17.7
6	18.0
6.25	18.3
6.5	18.7
6.75	19.0
7	19.3
7.25	19.6
7.5	19.9
7.75	20.3
8	20.6
8.25	20.9
8.5	21.2
8.75	21.6
9	21.9
9.25	22.2
9.5	22.5
9.75	22.8
10	23.2