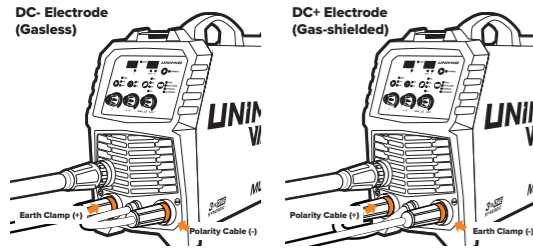


# VIPER MULTI 165

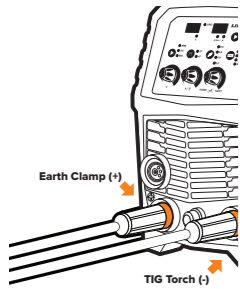
# Welding Setup Guide

# UNIMIG

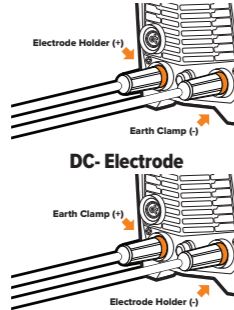
## Polarity: MIG



## Polarity: TIG



## Polarity: Stick



Please refer to electrode packaging for correct polarity settings.

## Manual MIG Setup Guide

Material Type	Wire Type	Wire Size	Drive Roller	Polarity	Shielding Gas	Gas Flow Rate	Material Thickness	1mm	2mm	3mm	4mm	6mm	8mm
								Voltage (V)	Wire Speed (m/min)	Voltage (V)	Wire Speed (m/min)	Voltage (V)	Wire Speed (m/min)
Steel	ER70S-6	0.8mm	V Groove	DCEP+	Argon 5/2	8-12L/min	Voltage (V)	14.4	15.5	17.6	18.4	19.7	21.7
							Wire Speed (m/min)	3.9	4.3	6.1	7.1	9.6	11.9
	ER70S-6	0.9mm	V Groove	DCEP+	Argon 5/2	8-12L/min	Voltage (V)	15.5	17	18	18.8	20.7	22
							Wire Speed (m/min)	4.4	5	6.3	7	9.1	9.6
	E71T-11	0.8mm	F Groove (Knurled)	DCEN-	/	/	Voltage (V)	14	15	15.8	16.5	17.7	18.4
							Wire Speed (m/min)	4	4.6	5.2	5.3	7	7.4
E71T-11	0.9mm	F Groove (Knurled)	DCEN-	/	/	Voltage (V)	/	15.3	16	16.8	18.1	19	
						Wire Speed (m/min)	/	4.7	5.5	5.8	7.3	7.8	
Stainless Steel	316LSi	0.8mm	V Groove	DCEP+	Argon CO <sup>2</sup> 98/2	8-12L/min	Voltage (V)	14.5	15.4	18.1	18.9	20.8	21.8
							Wire Speed (m/min)	4	4.4	7	9.8	9.9	12.9
	316LSi	0.9mm	V Groove	DCEP+	Argon CO <sup>2</sup> 98/2	8-12L/min	Voltage (V)	15.8	17.4	19	19.8	21	22
							Wire Speed (m/min)	4.5	5.2	7.1	8	9.7	11.7
Aluminium	5356	1.0mm	U Groove	DCEP+	Pure Argon	8-12L/min	Voltage (V)	/	/	15.7	16.7	17.6	20.4
							Wire Speed (m/min)	/	/	9.7	10.2	11.4	13.9

## TIG Setup Guide (Pure Argon Gas / DC- Polarity)

Tungsten Diameter	Filler Rod	Material	1.6mm	3.2mm	4.8mm	6.0mm
1.6mm	1.6mm	Steel	60-90A	80-115A	/	/
		Stainless	40-70A	65-110A	/	/
2.4mm	2.4mm	Steel	/	/	115-165A	/
		Stainless	/	/	100-150A	/
3.2mm	2.4mm	Steel	/	/	/	160-200A
		Stainless	/	/	/	135-180A

## Stick Setup Guide

Material Type	Electrode Type	Electrode Thickness	2.5mm	3.2mm	4.0mm
Steel	HYPERARC™ GP 6013	Amperage Range (A)	50-90A	90-130A	110-170A
		Polarity	DCEP+		
Steel	HYPERARC™ 16TC	Amperage Range (A)	50-90A	80-130A	110-180A
		Polarity	DCEP+		
Stainless Steel	HYPERARC™ 316L	Amperage Range (A)	50-90A	70-110A	100-150A
		Polarity	DCEP+		

## Synergic MIG Setup Guide

Material Type	Wire Type	Wire Size	Drive Roller	Polarity	Shielding Gas	Gas Flow Rate	Material Thickness	1mm	2mm	3mm	4mm	6mm	8mm
								Amp	Amp	Amp	Amp	Amp	Amp
Steel	ER70S-6	0.8mm	V Groove	DCEP+	Argon 5/2	8-12L/min	Amp	70	80	95	110	130	155
							Amp	95	100	110	125	140	165
	E71T-11	0.8mm	F Groove (Knurled)	DCEN-	/	/	Amp	90	95	100	110	130	135
							Amp	/	125	130	135	145	155
Stainless Steel	316LSi	0.8mm	V Groove	DCEP+	Argon CO <sup>2</sup> 98/2	8-12L/min	Amp	55	65	80	95	125	150
							Amp	60	80	95	110	130	155
Aluminium	5356	1.0mm	U Groove	DCEP+	Pure Argon	8-12L/min	Amp	/	/	110	115	125	140

This setup information is intended to act as a guide only. Individual results may vary depending on technique, skill and material. Please refer to the operating manual for further instructions.