PWS MIG Welding Settings App — Quick Start

What this tool does

Generates baseline **starting ranges** for MIG welding based on your selections:

- Voltage range
- Wire feed speed range
- Estimated amps range
- Gas flow range
- Stickout + technique notes
- Quick fixes

Before you start

- Clean the metal (remove paint, oil, heavy scale at the weld area).
- Confirm polarity (DCEP for most solid wire MIG; flux core varies—verify).
- Confirm gas type and flow (protect the arc from wind).

Step-by-step

1. **Material:** Choose Mild Steel / Stainless / Aluminum
2. **Thickness:** Select the closest thickness to your job
3. **Wire type:** Solid / Flux core / Stainless filler / Aluminum filler
4. **Wire diameter:** Match what's loaded in the machine
5. **Gas:** Match what's on your regulator

6. **Position:** Flat / Horizontal / Vertical / Overhead

7. Review the outputs and run a **test bead**

8. Adjust 0.5V or small WFS steps until the bead is correct

How to fine-tune (fast rules)

- **Too cold (high bead, poor fusion):** increase voltage slightly, increase WFS slightly, slow travel

- **Too hot (undercut, burn-through):** reduce voltage slightly, reduce WFS slightly, speed travel

- **Spatter:** check stickout, polarity, gas, and grounding

- **Porosity:** increase gas flow, shield from wind, remove contaminants

Important note

This is a baseline tool. Always confirm on test coupons and follow your job requirements.