

Quantum Arc™ 6

Diameter Inches (mm)		Transfer Mode	Amps	Volts	Wire-Feed Speed in/min (m/min)		Deposition Rate lbs/hr (kg/hr)		Contact Tip to Work Distance Inches (mm)
0.035	(0.9)	Short-Circuit	70	17.0	95	(2.4)	1.3	(0.6)	1/4 (6)
0.035	(0.9)	Short-Circuit	85	18.5	130	(3.3)	1.7	(0.8)	1/4 (6)
0.035	(0.9)	Short-Circuit	100	18.5	150	(3.8)	2.0	(0.9)	1/4 (6)
0.035	(0.9)	Short-Circuit	115	19.5	190	(4.8)	2.5	(1.1)	1/4 (6)
0.035	(0.9)	Short-Circuit	145	20.5	225	(5.7)	3.3	(1.5)	3/8 (10)
0.035	(0.9)	Short-Circuit	155	20.5	265	(6.7)	3.5	(1.6)	3/8 (10)
0.035	(0.9)	Spray	165	23.5	330	(8.4)	5.3	(2.4)	5/8 (16)
0.035	(0.9)	Spray	185	24.5	370	(9.4)	5.9	(2.7)	5/8 (16)
0.035	(0.9)	Spray	205	24.5	410	(10.4)	6.5	(2.9)	3/4 (19)
0.035	(0.9)	Spray	235	25.5	465	(11.8)	7.3	(3.3)	3/4 (19)
0.045	(1.2)	Spray	175	23.5	175	(4.4)	4.7	(2.1)	5/8 (16)
0.045	(1.2)	Spray	195	24.5	200	(5.1)	5.3	(2.4)	5/8 (16)
0.045	(1.2)	Spray	215	25.5	230	(5.8)	4.6	(2.1)	3/4 (19)
0.045	(1.2)	Spray	260	27.0	310	(7.9)	8.1	(3.7)	3/4 (19)
0.045	(1.2)	Spray	325	27.0	425	(10.8)	11.1	(5.0)	3/4 (19)
0.045	(1.2)	Spray	350	28.0	475	(12.1)	12.5	(5.6)	3/4 (19)
0.052	(1.4)	Spray	290	27.0	280	(7.1)	9.8	(4.4)	3/4 (19)
0.052	(1.4)	Spray	325	27.0	330	(8.4)	11.6	(5.2)	3/4 (19)
0.052	(1.4)	Spray	390	29.0	420	(10.7)	14.8	(6.7)	3/4 (19)
1/16	(1.6)	Spray	350	27.0	260	(6.6)	13.3	(6.0)	3/4 (19)
1/16	(1.6)	Spray	400	29.0	300	(7.6)	15.4	(7.0)	3/4 (19)

Note: Short circuit transfer shielding gas is 100% CO₂ or 75% Ar/25% CO₂ at 20-35 cfh (9-17 l/min)

Note: Spray transfer shielding gas is 90% Ar/10% CO₂ at 35-50 cfh (17-24 l/min)

- **Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded.**
- **For out of position welding, short circuit or pulsed spray transfer modes must be used.**