



**NUMBER OF POUNDS PER ARC
WELDING HOUR**
For Gas Metal Arc (mig)

U.S. ALLOY CO.
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7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com

Quality Management System
in accordance with
ISO 9001:2000
Cert # 05-R0925



To find out approximate number of pounds per arc welding hour depending on the following wire types, do the appropriate calculation using the wire speed.

SOLID MILD STEEL WIRE

Number of inches per minute X factor = number of pounds per hour:

| Wire diameter | | Factor | | |
|----------------------|----------|---------------|---|--------|
| .030" | "/ min x | .012 | = | #/hour |
| .035" | "/ min x | .017 | = | #/hour |
| .045" | "/ min x | .027 | = | #/hour |
| .052" | "/ min x | .035 | = | #/hour |
| .062" | "/ min x | .052 | = | #/hour |

Example: .035", 600"/min: 600 x .017 = 10.2#/hr

Alloy Factors for others :

| | |
|-------------------|---------------|
| Magnesium | x .231 |
| Aluminum = | x .346 |
| Copper | x 1.14 |
| Stainless | x 1.02 |
| Nickels | x 1.14 |
| Titanium | x .60 |

Example for Aluminum : .035", 600"/min: 600 x .017 = 10.2 x .346 = 3.529 #/hour

TUBULAR MILD STEEL WIRE

Number of inches per minute ÷ factor = number of pounds per hour:

| Wire diameter | | Factor | | |
|----------------------|----------|---------------|---|--------|
| .045" | "/ min ÷ | 46 | = | #/hour |
| .052" | "/ min ÷ | 33 | = | #/hour |
| .062" | "/ min ÷ | 22 | = | #/hour |
| 5/64" | "/ min ÷ | 20 | = | #/hour |
| .093" | "/ min ÷ | 13 | = | #/hour |

Example: 1/16" flux cored wire @ 200"/min: 200 ÷ 22 = 9.01/hour
.045" flux cored wire @ 275"/min: 275 ÷ 46 = 5.98/hour

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