

## ArcSet parameter sheet

ArcSet gives starting reference numbers to help you set your machine. It is not a qualified or stamped Welding Procedure Specification, not a Procedure Qualification Record, and not approval to weld on code work. Always follow your shop's qualified WPS, your engineer, and your Certified Welding Inspector for any job that requires one.

| Field              | Value                                             |
|--------------------|---------------------------------------------------|
| Timestamp          | 2026-07-09T15:05:25.918125                        |
| Process            | SMAW                                              |
| Electrode          | 7018                                              |
| Diameter           | 1/8 in                                            |
| Material           | Carbon steel                                      |
| Thickness          | 1/8 in                                            |
| Position           | 1G                                                |
| Amp min            | 100                                               |
| Amp max            | 150                                               |
| Start amps         | 130                                               |
| Start volts        | null                                              |
| Wire feed start    | null                                              |
| Polarity           | DCEP                                              |
| Gas                |                                                   |
| Gas flow (CFH)     | null                                              |
| Travel speed (ipm) | 5.8                                               |
| Heat input (kJ/in) | null                                              |
| Job id             | STICK-CHEAT-SHEET                                 |
| Joint note         | 7018 1/8 in rod on 1/8 in carbon steel, flat      |
| Measured amps      | null                                              |
| Measured volts     | null                                              |
| Photo              |                                                   |
| Header             | Reference parameters, not a qualified WPS or PQR. |

## **Reference parameters, not a qualified WPS or PQR.**

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### **Source notes**

- AWS A5.1 low-hydrogen class with public manufacturer starting ranges restated as reference bands.
- Public 7018 1/8 in low-hydrogen rod ranges restated as a starting reference.