

Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	180,000 psi
Yield Strength:	85,000 psi
Elongation:	35%

Recommended Parameters

GMAW (DCEP – Electrode +) 99% Argon / 1% CO₂ Mixture or 97% Argon / 3% CO₂ Mixture

Wire Diameter	Voltage	Amperage	Wire Feed IPM
0.030"	24-28	140-180	150-430
0.035"	26-29	160-210	120-400
0.045"	28-32	180-250	100-240
1/16"	29-33	200-280	

GTAW (DCEN – Electrode -) 100% Ar 2% Thoriated, 2% Ceriated or Lanthanum Tungsten Electrode

Wire Diameter	Voltage	Amperage
0.035"	12-15	60-90
0.045"	13-16	80-110
1/16"	14-18	90-130
3/32"	15-20	120-175
1/8"	15-20	150-220