

Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	up to 96,000 psi
Elongation:	up to 26%
Charpy V-Notch at -20°F:	20 ft/lbs

Recommended Parameters

GMAW (DCEP - Electrode+) 100 % CO₂, or a 75-25% Argon/CO₂ Mixture For Solid Wire, 98 % Argon / 2% CO₂ Mixture For Spray Transfer

Wire Diameter	Voltage	Amperage	Wire Feed IPM
0.023"	14-19	30-85	360-620
0.030"	15-20	40-130	390-670
0.035"	16-25	60-235	360-520
0.045"	18-23	90-290	210-360
0.035" (Spray)	23-36	160-300	
0.045" (Spray)	23-29	170-375	
1/16" (Spray)	25-31	275-475	

GTAW (DCEN - Electrode -) 100% Ar 2% Thoriated, or 1.5% Lanthanum Tungsten Electrode

Material	Tungsten Dia.	Filler Wire Size	Amperage	Argon (CFH)
1/16"	1/16"	1/16"	100-140	20
3/32"	1/16"	1/16"	100-160	20
1/8"	3/32"	1/16"	125-200	20
3/16"	3/32"	3/32"	150-250	25
1/4"	1/8"	1/8"	150-250	25