

## Typical Weld Metal Properties

Tensile Strength: up to 96,000 psi

Elongation: up to 27%

## Recommended Parameters

Size	Polarity	Voltage	Amperage	Wire Feed	Preheat	Interpass	Shielding Gas
.045	DC(+)	24	200	300 in/min	20C/70F	150C/300F	75%Ar+25%CO2
.045	DC(+)	27	200	300 in/min	20C/70F	150C/300F	100%CO2
1/16	DC(+)	24	200	200 in/min	20C/70F	150C/300F	75%Ar+25%CO2
1/16	DC(+)	26	250	200in/min	20C/70F	150C/300F	100%CO2