

Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	75,000-80,000 psi
Elongation:	22%-29%
Hardness:	150 Brinell

Recommended Parameters

GMAW (DC Reverse Polarity) Electrode Positive Spray Transfer

Wire Diameter	Voltage	Amperage	Wire Feed IPM
0.023"	23-27	85-170	360-620
0.030"	24-28	135-230	390-670
0.035"	24-28	165-300	360-520
0.045"	24-30	200-375	210-360
1/16"	24-32	275-500	75-125

GTAW (DCSP) 2% Thoriated Tungsten Electrode Negative

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