

330 MIG

Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	84,000 psi
Yield Strength:	56,500 psi
Elongation:	29%

Recommended Parameters

GMAW (DCEP – Electrode +)

Wire Diameter	Voltage	Amperage	Wire Feed IPM
0.023"	14-19	30-85	180-400
0.030"	15-20	45-125	150-350
0.035"	16-22	60-150	120-330
0.045"	17-22	90-210	100-280

GTAW (DCEN – Electrode -) 100% Ar 2% Thoriated

Filler Wire Size	Tungsten	Voltage	Amperage	Argon (CFH)
1/16"	1/16"	10-12	80-150	20
3/32"	3/32"	15-18	150-250	20
1/8"	1/8"	16-20	200-375	25