

4043

Typical Weld Metal Properties

Tensile Strength: 44,000 psi
Elongation: 17%
Yield Strength: 40,000 psi

Recommended Parameters

GMAW (DCEP – Electrode+) Spray

Size	Voltage	Amperage	Wire Feed (IPM)
.030	15-24	60-175	25-45
.035	15-27	70-185	25-40
3/64	20-29	125-260	24-35
1/16	24-30	170-300	28-38
3/32	26-31	275-400	14-20

GTAW (DCEN – Electrode-)

Filler Wire Size	Tungsten Dia	Voltage	Amperage	Argon (CFH)
1/16	1/16	15	60-80	20
3/32	3/32	15	125-160	20
1/8	1/8	15	190-220	20
5/32	5/32	15	200-300	25
3/16	3/16	15-20	330-380	25