

Typical Weld Metal Properties

Tensile Strength:	up to 100,000 psi
Elongation:	22%-32%
Hardness:	as welded 110 Brinell

GMAW Recommended Parameters

DCEP Spray Transfer

Wire Diameter	Wire Speed (imp)	Amps	Volts	Argon (cfh)
0.023"	460-580	60-120	21-22	20-25
0.030"	450-525	130-160	21-24	20-30
0.035"	385-455	155-190	23-25	25-30
0.045"	275-310	210-235	26-28	30-35
1/16	150-240	250-310	27-31	35-40

GTAW Recommended Parameters;

DCEN with EWTh-2 truncated conical tip

Filler Wire Size	Tungsten	Amps	Volts	Gas Cup Size	Argon (cfh)	Base thickness
1/16"	1/16"	80-170	12	3/8"-1/2"	20	1/16-1/8"
3/32"	3/32"	140-275	12	3/8"-1/2"	20	1/8- 3/16"
1/8"	1/8"	200-375	12	1/2"	25	1/4-3/8"
1/8-5/32"	3/16"	260-475	12	1/2-3/4"	30	3/8-1/2"

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.