

645

## Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	100,000-110,000 psi
Hardness:	200 Brinell
Elongation:	21%-31%

## Recommended Parameters

GMAW (DCEP – Electrode +)

Wire Diameter	Voltage	Amperage
0.035"	20-26	100-200
0.045"	22-28	100-250
1/16"	29-32	250-400
3/32"	32-34	350-500

GTAW (DCEN – Electrode -)

Filler Wire Size	Voltage	Amperage
1/16"		70-120
3/32"		120-160
1/8"		170-230
5/32"		220-280
3/16"		280-330