

710

## Typical Weld Metal Properties

Tensile Strength: 190,000-200,000 psi

Yield Strength: 168,000-188,000

Hardness: Rockwell "C"

## GMAW Recommended Parameters

| DCEP Short Circuit |            | 98Ar/2% O <sub>2</sub> |          |              |                       |
|--------------------|------------|------------------------|----------|--------------|-----------------------|
| Wire Diameter      | Wire Speed | Voltage                | Amperage | Travel Speed | CO <sub>2</sub> (cfh) |
| 0.023"             | 80-350     | 14-19                  | 30-85    | 10-15        | 20-25                 |
| 0.030"             | 110-340    | 15-20                  | 45-130   | 12-24        | 20-25                 |
| 0.035"             | 100-520    | 16-25                  | 60-235   | 11-40        | 20-30                 |
| 0.045"             | 70-270     | 28-23                  | 90-290   | 12-22        | 25-35                 |

## 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"    | 100-160 | 12    | 3/8"         | 20          | 1/16-3/32"     |
| 1/16-3/32"       | 3/32"    | 120-250 | 12    | 3/8"         | 20          | 1/8- 3/16"     |
| 1/8"             | 1/8"     | 150-300 | 12    | 1/2"         | 25          | 1/4-1/2"       |

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