

880

Typical Weld Metal Properties

Tensile Strength: 70,000-80,000 psi
Elongation: 26%-30%
Hardness: 160 Brinell

Recommended Welding Parameters:

	Wire Diameter	Amperage*
GMAW (Direct current; electrode +Ve)	0.035"	160-180
75% Argon + 25% Helium or	0.045"	180-220
50% Argon + 50% Helium mixture	1/16"	210-250
GTAW (Direct current; electrode – Ve)		
Use 100% Argon		
2% Thoriated, 2% Ceriated or		
2% Lanthanum Tungsten Electrode		
Gas Flow: 30 – 40 CFH		
SMAW (Direct current; electrode +Ve)		
Voltage: 29-32		
Amperage	3/32"	300-350
	1/8"	400-550
	5/32"	500-650