

# 910SG

## Typical Weld Metal Properties

AWS Spec

Tensile Strength: 105,000-115,000 psi

Hardness: 250 Brinell

## Recommended Parameters

GMAW (DCEP - Electrode+) 100 % CO<sub>2</sub>, or a 75-25% Argon/CO<sub>2</sub> Mixture For Solid Wire, 98 % Argon / 2%CO<sub>2</sub> Mixture For Spray Transfer

Wire Diameter	Voltage	Amperage	Wire Feed IPM
0.035"	22-25	100-140	320-510
0.045"	23-26	120-150	170-550
0.035" (Spray)	28-32	160-200	320-510
0.045" (Spray)	30-34	280-220	170-550

GTAW (DCSP) 2% Thoriated Tungsten Electrode Negative

Tungsten Dia.	Filler Wire Size	Amperage	Argon (CFH)
1/16"	1/16"	100-160	20
3/32"	3/32"	120-250	20
1/8"	1/8"	150-300	25