

930SG

Typical Weld Metal Properties

AWS Spec

Tensile Strength: 110,000-120,000 psi

Hardness: as welded 250 Brinell

Elongation: 26%-30%

Recommended Parameters

GMAW (DCEP – Electrode+) 98% Ar / 2% O₂

Wire Diameter	Voltage	Amperage
0.023"	14-19	30-85
0.030"	15-20	45-125
0.035"	16-22	60-150
0.045"	17-22	90-210

GTAW (DCEN – Electrode-)

Material	2% Thoriated	Filler Wire Size	Amperage	Argon (CFH)
1/16"	1/16"	1/16"	80-120	20
3/32"	1/16"	1/16"	100-130	20
1/8"	3/32"	1/16"	120-150	20
3/16"	3/32"	3/32"	150-250	25
1/4"	1/8"	1/8"	200-350	25