

960SG

Typical Weld Metal Properties

Tensile Strength: 90,000-100,000 psi

Recommended Parameters

SHIELDING GASES:

GMAW/GTAW

100% Ar or 75-25% Ar/25-75% He.

<u>Diameter</u>	<u>Process</u>	<u>Amperage</u>	<u>Voltage</u>
.035"	Spray Arc	190-250	25--30
.035"	Short Arc	160-220	20--24
.045"	Spray Arc	180-260	25--30
.045"	Short Arc	180-230	20--24
.063"	Spray Arc	200-400	26--32
.063"	TIG	130-200	10--16
3/32"	TIG	140-220	10--16
1/8"	TIG	150-240	10--16
5/32"	TIG	160-265	10--16
3/16"	TIG	170-280	11--18