

| TYPICAL WELDING PARAMETERS OF MILD & LOW ALLOY TIG, MIG AND SMAW | | | | | |
|--|------------------|-------------|-------------|--------------|--|
| Process | Diameter of Wire | | Voltage (V) | Amperage (A) | Shielding Gas |
| | Inches | Millimeters | | | |
| TIG (GTAW) | 0.035 | 0.9 | 12-Oct | 50 - 70 | 100% Argon |
| | 0.045 | 1.2 | 12-Oct | 70 - 100 | |
| | 1/16" | 1.6 | 15-Dec | 100 - 125 | |
| | 3/32" | 2.4 | 15 - 20 | 125 - 175 | |
| | 1/8" | 3.2 | 15 - 20 | 175 - 250 | |
| MIG (GMAW) SPRAY TRANSFER | 0.035 | 0.9 | 28 - 32 | 165 - 200 | 98% Argon + 2% Oxygen or 75% Argon + 25% CO2 |
| | 0.045 | 1.2 | 30 - 34 | 180 - 220 | |
| | 1/16" | 1.6 | 30 - 34 | 230 - 260 | |
| MIG (GMAW) SHORT CIRCUITING TRANSFER | 0.035 | 0.9 | 22 - 25 | 100 - 140 | 100% CO2 |
| | 0.045 | 1.2 | 23 - 26 | 120 - 150 | 75% Argon + 25% CO2 |

| TYPICAL WELDING PARAMETERS OF MILD STEEL & LOW ALLOY SMAW (ELECTRODES) | | | | |
|--|-------------|-------------|--------------|---------------------|
| Diameter of Rod | | Voltage (V) | Amperage (A) | |
| Inches | Millimeters | | Flat | Vertical & Overhead |
| 3/32" | 2.4 | 21-25 | 65-80 | 65-75 |
| 1/8" | 3.2 | 21-25 | 90-110 | 80-95 |
| 5/32" | 4.0 | 21-26 | 135-160 | 120-140 |
| 3/16" | 4.8 | 22-26 | 160-210 | 140-160 |

| TYPICAL WELDING PARAMETERS OF MILD & LOW ALLOY STEEL FCAW (FLUX CORED) | | | | | | | |
|--|-------------|-------------|--------------|---------------|--------------|-------------|--------------|
| Diameter of Wire | | FLAT | | VERTICAL - UP | | OVERHEAD | |
| Inches | Millimeters | Voltage (V) | Amperage (A) | Voltage (V) | Amperage (A) | Voltage (V) | Amperage (A) |
| 0.035 | 0.9 | 20-30 | 130-250 | 16-23 | 90-180 | 20-28 | 130-240 |
| 0.045 | 1.14 | 23-30 | 150-280 | 22-26 | 150-250 | 24-29 | 150-250 |
| 16-Jan | 1.6 | 25-34 | 180-400 | 21-27 | 180-300 | 24-30 | 180-310 |



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