

TYPICAL WELDING PARAMETERS FOR STAINLESS STEEL WIRES

GMAW (SHORT CIRCUITING MODE)

WIRE DIA.	AMPERAGE	VOLTAGE	WIRE SPEED, IN./MIN.	JOINT THICKNESS IN.	GAS CHOICES
.030"	55-125	19-24	120-280	1/16-1/8	90He/7.5Ar/2.5Co2 90He/7.5Ar/2.5Co2 69Ar/30He/1Co2 95Ar/3CO2/2N2
.035	85-130	19-22	120-350	1/16-1/8	90He/7.5Ar/2.5Co2 90He/7.5Ar/2.5Co2 69Ar/30He/1Co2 95Ar/3CO2/2N2
.045	100-185	19-22	100-275	1/8-1/4	75Ar/25He 90He/7.5Ar/2.5Co2 69Ar/30He/1Co2 95Ar/3CO2/2N2

GMAW (SPRAY TRANSFER MODE)

.035"	145-200	25-29	225-350	3/8 and UP	Ar 2% to 5%CO2 Ar -1% to 8%O2 95Ar3%CO2-2%N2
.045"	190-250	24-30	200-350		
.062"	220-300	26-32	210-330		

GMAW (PULSED CURRENT MODE)

.035" peak	120-150 250-300	18-20	175-225	1/8-3/4	75Ar/25He, Ar or 69Ar/30He/1Co2
.045" peak	120-150 250-300	18-20	175-225	1/8-3/4	75Ar/25He, Ar or 69Ar/30He/1Co2

GTAW (TIG)

JOINT THICKNESS IN.	TUNGSTEN ELECTRODE DIA. IN.	FILLER WIRE DIA. IN.	AMPERAGE	VOLTAGE	GAS
.030 to 1/16	1/16	1/16	35-90	10-14	100Ar
1/16 to 1/8	1/16 to 3/32	1/16 or 3/32	90-150	12-16	100Ar
1/8 to 1/4	3/32 or 1/8	3/32 or 1/8	150-150	10-18	100Ar
1/4 and up	3/32 or 1/8	3/32 or 1/8	95-220	10-18	100Ar

SAW (SUBMERGED ARC) DCEP

WIRE DIA.	AMPERAGE	VOLTAGE	FLUX
1/16"	150-300	24-30	RECORD IN or IND24
5/64"	180-350	21-32	RECORD IN or IND24
3/32"	275-350	25-32	RECORD IN or IND24
1/8"	350-450	28-32	RECORD IN or IND24
5/32"	400-600	28-34	RECORD IN or IND24

10/27/09

The contents of this publication are presented for informational purposes only, and while every effort has been made to ensure their accuracy, they are not to be construed as warranties or guarantees, express or implied, regarding the products or services described herein or their use or applicability. We reserve the right to modify or improve the designs or specifications of such products at any time without notice.

Office and Corporate Warehouse
630 Axminister Drive
Fenton, MO 63026 • 636-349-6000 • 800-776-3300
Fax 636-349-2240

