



Quality Management System  
in accordance with  
**ISO 9001:2000**  
Cert # 05-R0925

# NICKEL Welding Parameters

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### TYPICAL GMAW WELDING PROCEDURES; DCEP Spray Arc

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stick-out	Argon (cfh)
0.030	550-750	175-250	26-32	3/8-1/2"	30-40
0.035	425-575	175-300	26-32	3/8-1/2"	30-40
0.045	250-350	200-310	26-32	3/8-1/2"	35-50
0.062	125-200	250-330	27-33	1/2"-5/8"	35-50

### TYPICAL GMAW WELDING PROCEDURES; DCEP Short Circuit (cfh)

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stick-out	75Ar/25He
0.035	150-200	90-110	19-21	3/8-1/2"	35-45
0.045	175-225	100-140	22-24	3/8-1/2"	40-50

### TYPICAL GTAW WELDING PROCEDURES; DCEN with EWTh-2 truncated conical tip

Filler Wire Size	Tungsten	Amps	Volts	Gas Cup Size	Argon (cfh)	Base thickness
1/16"	1/16"	80-150	12	1/2"	20	1/16-1/8"
3/32"	3/32"	150-250	12	3/4"	25	1/8- 3/16"
1/8"	1/8"	200-375	12	5/8"	30	1/4-1/2"

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.



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