



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

Stainless Steel Welding Parameters

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



TYPICAL GMAW WELDING PROCEDURES; DCEP Short Circuit (Tri-mix = 90%He+7.5%Ar+2.5%CO₂)

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stick-out	Tri-mix (cfh)
0.023	180-400	30-85	14-19	3/8-1/2"	20-25
0.030	150-350	45-125	15-20	3/8-1/2"	20-25
0.035	120-330	60-150	16-22	3/8-1/2"	20-30
0.045	100-280	90-210	17-22	3/8-1/2"	25-30
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<i>Spray</i> ⁽¹⁾ 98%Ar + 2%O ₂					
0.030	280-600	160-220	24-28	3/8-1/2"	⁽¹⁾ 25-35
0.035	250-470	170-295	23-29	1/2-3/4"	⁽¹⁾ 25-35
0.045	200-385	195-360	24-30	1/2-3/4"	⁽¹⁾ 30-35
1/16"	110-200	210-380	25-31	1/2-3/4"	⁽¹⁾ 35-40

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	3/8"	20	1/16-1/8"
3/32"	3/32"	150-250	12	3/8"	20	1/8- 3/16"
1/8"	1/8"	200-375	12	1/2"	25	1/4-1/2"

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

904L
Spray 70%Ar + 30%He 25-35(cfh)

	Amps	Volts
0.045	165-220	25-30



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