



Tungsten Electrodes

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

WASHINGTON ALLOY'S
 Quality Management System is
 Certified to ISO 9001:2008
 Cert # 05-R0925



Typical Current Ranges for Tungsten Electrodes

TIG Welding Electrode Diameter inches (mm)	Current Ranges for Tungsten Electrodes – (Argon Shielding Gas)							
	DCEN, A	DCEP, A	High-Frequency Unbalanced AC, A			High-Frequency Balanced AC, A		
	EWP EWTh-1 EWTh-2 EWTh-3	EWP EWTh-1 EWTh-2 EWTh-3	EWP	EWTh-1 EWTh-2 EWZr	EWTh-3	EWP	EWTh-1 EWTh-2 EWZr	EWTh-3
0.010 (0.26)	up to 15	—	up to 15	up to 15	—	up to 15	up to 15	—
0.020 (0.51)	5-20	—	5-15	5-20	—	10-20	5-20	10-20
0.040 (1.02)	15-80	—	10-60	15-80	10-80	20-30	20-60	20-60
1/16 (1.59)	70-150	10-20	50-100	70-150	50-150	30-80	60-120	30-120
3/32 (2.38)	150-250	15-30	100-160	140-235	100-235	60-130	100-180	60-180
1/8 (3.18)	250-400	25-40	150-210	225-325	150-325	100-180	160-250	100-250
5/32 (3.97)	400-500	40-55	200-275	300-400	200-400	160-240	200-320	160-320
3/16 (4.76)	500-750	55-80	250-350	400-500	250-500	190-300	290-390	190-390
1/4 (6.35)	750-1000	80-125	325-450	500-630	325-630	250-400	340-525	250-525

Procedures current may vary with change in position, base metals, filler metals, shielding gas, equipment and other changes

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