

Typical Operating Procedures

Diameter, Polarity Shielding Gas	CTWD mm(in)	Wire Feed Speed m/min (in/min)	Voltage (volts)	Approx. Current (amps)	Melt-Off Rate kg/hr (lb/hr)
1.2mm (0.045in), DC +					
100% CO ₂ Gas	20 (3/4)	5.8 (230)	18.5	150	2.9 (6.4)
		9.0 (350)	25	200	4.5 (9.9)
		14.5 (570)	31	280	7.3 (16.1)
Mixed Gas (Ar + CO ₂)	20 (3/4)	3.7 (145)	17.5	150	1.9 (4.2)
		6.2 (244)	24	200	3.1 (6.8)
		11.2 (440)	30	280	5.6 (12.3)
1.4mm (0.052in), DC +					
100% CO ₂ Gas	20 (3/4)	8.8 (346)	29	250	6.1 (13.4)
		12.0 (472)	34	300	8.3 (18.3)
		14.6 (575)	36	340	10.1 (22.2)
Mixed Gas (Ar + CO ₂)	20 (3/4)	6.6 (260)	28	250	4.6 (10.1)
		8.7 (343)	32	300	6.0 (13.2)
		9.5 (374)	35	340	6.6 (14.5)
1.6mm (1/16in), DC +					
100% CO ₂ Gas	20 (3/4)	8.6 (339)	34	320	7.8 (17.2)
		9.4 (370)	37	340	8.5 (18.7)
		11.7 (460)	43	390	10.6 (23.3)
Mixed Gas (Ar + CO ₂)	20 (3/4)	6.2 (244)	30	320	5.6 (12.3)
		6.6 (260)	34	340	6.0 (13.2)
		8.2 (322)	38	390	7.4 (16.3)

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AWS A5.18/A5.18:2021, Specification for Carbon Steel Electrodes and Rods for Gas Shielded Arc Welding American Welding Society,2021-07-07 **AWS A5.18/A5.18M: 2001, Specification for Carbon Steel Electrodes and Rods for Gas Shielded Arc Welding** ANSI.,American Welding Society,1999 **AWS A5. 18/A5. 18M-2001, Specification for Carbon Steel Electrodes and Rods for Gas Shielded Arc Welding** American National Standards Institute,American Welding Society,2001-01-01 **ANSI/AWS A5.1-91, Specification for Carbon Steel Electrodes for Shielded Metal Arc Welding** ANSI.,American Welding Society,1991 **Specification for Covered Carbon Steel Arc Welding Electrodes** American Welding Society. Committee on Filler Metal,1982 **AWS A5.34/A5.34M:2020, Specification for Nickel-Alloy Flux Cored and Metal Cored Welding Electrodes** American Welding Society,2020-10 **ANSI/AWS A5. 17/A5. 17M-97, Specification for Carbon Steel Electrodes and Fluxes for Submerged Arc Welding** American Welding Society,American Welding Society. Committee on Filler Metal,Woodhead Publishing, Limited,American Welding Society. Technical Activities Committee,1997-12-01

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