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## THE HARRIS PRODUCTS GROUP

# RECOMMENDED WELDING PARAMETERS FOR MAINTENANCE & REPAIR ALLOYS GTAW (TIG)

**GTAW (TIG)** - For manual AC TIG welding, Argon is generally preferred because the arc has good stability. On welding heavier aluminum sections, the addition of Helium may be considered, and arc penetration will increase significantly; however, gas flow rates must be increased when Helium is added.

Filler Diameter	Direct Current (Amps, Straight Polarity, DCEN)	Direct Current (Amps, Reverse Polarity, DCEP)	Alternating Current (Amps, Unbalanced Wave)	Alternating Current (Amps, Balanced Wave)	Gas Cup
.010"	up to 15	-	up to 15	up to 15	1/4"
.020"	5 - 20	-	5 - 15	10 - 20	1/4"
.040"	15 - 80	-	10 - 60	20 - 30	3/8"
1/16"	70 - 150	10 - 20	50 - 100	30 - 80	3/8"
3/32"	150 - 250	15 - 30	100 - 160	60 - 130	1/2"
1/8"	250 - 400	25 - 40	150 - 210	100 - 180	1/2"
5/32"	400 - 500	40 - 55	200 - 275	160 - 240	1/2"
3/16"	500 - 750	55 - 80	250 - 350	190 - 300	5/8"