



PROFESSIONAL PRODUCTS...
SUPERIOR RESULTS™

THE HARRIS PRODUCTS GROUP
RECOMMENDED WELDING PARAMETERS FOR
COPPER WELDING ALLOYS GTAW (TIG)

Alloy	Material Thickness	Filler Diameter	Welding Current, (Amps DC)	Welding Current, (Amps AC)	Gas Cup	Argon, cfh	Tungsten
Aluminum Bronze A2	1/16"	1/16"	80-120	80-120	3/8" - 1/2"	15	1/16"
	3/32" - 1/8"	3/32"	145 - 205	145 - 195	7/16" - 1/2"	15	3/32"
	3/16"	3/32" - 1/8"	300 - 350	255 - 300	7/16" - 1/2"	20	1/8"
Deoxidized Copper	1/2"	1/8"	515 - 640	340 - 485	1/2"	25	3/16"
	1/16"	1/16"	70 - 150	70 - 150	3/8" - 1/2"	15	1/16"
	3/32" - 1/8"	3/32"	150 - 200	140 - 230	7/16" - 1/2"	15	3/32"
Phos Bronze	3/16" - 1/2"	3/32" - 1/8"	230 - 400	255 - 320	7/16" - 1/2"	20	1/8"
	1/16"	1/16"	100 - 120	100 - 120	3/8" - 1/2"	15	1/16"
	3/32" - 1/8"	3/32"	185 - 205	165 - 195	7/16" - 1/2"	15	3/32"
Silicon Bronze	3/16"	3/32" - 1/8"	300 - 350	255 - 300	7/16" - 1/2"	20	1/8"
	1/2"	1/8"	615 - 640	440 - 185	1/2"	25	3/16"
	1/16"	1/16"	70 - 150	70 - 150	3/8" - 1/2"	15	1/16"
Silicon Bronze	3/32" - 1/8"	3/32"	150 - 200	140 - 230	7/16" - 1/2"	15	3/32"
	3/16" - 1/2"	3/32" - 1/8"	230 - 400	225 - 320	7/16" - 1/2"	20	1/8"