



PROFESSIONAL PRODUCTS...
SUPERIOR RESULTS™

THE HARRIS PRODUCTS GROUP RECOMMENDED WELDING PARAMETERS FOR MILD STEEL/LOW ALLOY GTAW (TIG)

GTAW (TIG)

Welding is normally done with DC Straight Polarity (AC is sometimes used). Argon shielding is most commonly used but for deeper penetration, especially on thick plate, argon/helium mixes can be used.

MATERIAL THICKNESS	FILLER DIA.	WELDING CURRENT (AMPS)	GAS CUP	ARGON, cfh	TUNGSTEN DIAMETER
1/16"	1/16"	100 - 140	3/8"	20	1/16"
3/32"	1/6"	100 - 160	3/8"	20	1/16"
1/8"	1/6"	125 - 200	7/16"	20	3/32"
3/16"	3/32"	150 - 250	7/16"	25	3/32"
1/4"	1/8"	150 - 250	1/2"	25	1/8"
3/8"	1/8"	150 - 275	1/2"	25	1/8"
1/2"	1/8"	150 - 300	1/2"	25	1/8"