



PROFESSIONAL PRODUCTS...
SUPERIOR RESULTS™

THE HARRIS PRODUCTS GROUP RECOMMENDED WELDING PARAMETERS FOR STAINLESS STEEL GMAW (MIG)

GMAW (MIG), Short Circuit Transfer: 90% Helium + 7.5% Argon + 2.5% CO₂ has no effect on corrosion resistance; provides small heat-affected zone; no undercutting; and minimum distortion.

WIRE SIZE	WELDING CURRENT (AMPS)	ARC VOLTAGE	WIRE FEED SPEED, IPM
.030"	60-125	17-22	150-430
.035"	75-160	17-22	120-400
.045"	100-200	17-22	100-240

GMAW (MIG), Spray Transfer: 99% Argon - 1% Oxygen is predominantly used. This mixture improves arc stability; produces more fluid and controllable weld puddle with good bead contour. Undercutting is minimized on heavier sections. 98% Argon - 2% Oxygen provides better arc stability and welding speed than the 1% Oxygen mixture for thinner stainless steel materials.

WIRE SIZE	WELDING CURRENT (AMPS)	ARC VOLTAGE	WIRE FEED SPEED, IPM
.030"	160-225	24-28	440-650
.035"	180-300	24-29	430-500
.045"	200-450	24-30	220-400
1/16"	220-500	24-32	110-210
3/32"	250-600	24-32	50-80