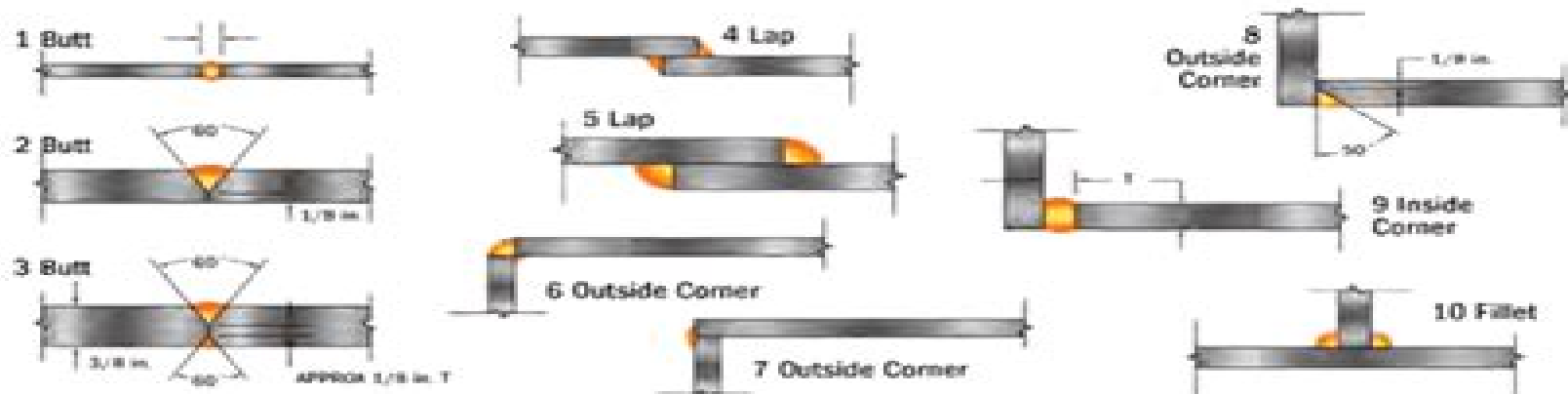


Work	Weld		Tungsten Electrode Diameter	Filler Rod	Current (Flat Welding)		Gas			Speed	Remarks
Thickness (in.)	Type	Number		(If Any) Diameter	Type	Amperes □	Type	Flow CFH	PSI	Inches Per Minute	
Stainless Steel			Manual Welding			Direct Current Electrode Negative (DCEN)					
1/16	butt	1	1/16	1/16	DC	▲ 80 - 100	Argon	1.1	20	12	
	lap	4,5	1/16	1/16	DC	▲ 100 - 120	Argon	1.1	20	10	
	corner	6,7,9	1/16	1/16	DC	▲ 80 - 100	Argon	1.1	20	12	
	fillet	10	1/16	1/16	DC	▲ 90 - 100	Argon	1.1	20	10	
3/32	butt	1	1/16	1/16 or 3/32	DC	▲ 100 - 120	Argon	1.1	20	12	
	lap	4,5	1/16	1/16 or 3/32	DC	▲ 110 - 130	Argon	1.1	20	10	
	corner	6,7,9	1/16	1/16 or 3/32	DC	▲ 100 - 120	Argon	1.1	20	12	
	fillet	10	1/16	1/16 or 3/32	DC	▲ 110 - 160	Argon	1.1	20	10	
1/8	butt	1	1/16	3/32	DC	▲ 120 - 140	Argon	1.1	20	12	
	lap	4,5	1/16	3/32	DC	▲ 130 - 150	Argon	1.1	20	10	
	corner	6,7,9	1/16	3/32	DC	▲ 120 - 140	Argon	1.1	20	12	
	fillet	10	1/16	3/32	DC	▲ 130 - 150	Argon	1.1	20	10	
3/16	butt	1	3/32	1/8	DC	▲ 200 - 250	Argon	1.3	20	10	
	lap	5	3/32 or 1/8	1/8	DC	□ 225 - 275	Argon	1.3	20	8	
	corner	6,7,9	3/32	1/8	DC	▲ 200 - 250	Argon	1.3	20	10	
	fillet	10	3/32 or 1/8	1/8	DC	□ 225 - 275	Argon	1.3	20	8	
1/4	butt	1,2	1/8	3/16	DC	□ 275 - 350	Argon	1.3	20	5	one or two passes
	lap	5	1/8	3/16	DC	□ 300 - 375	Argon	1.3	20	5	one or two passes
	corner	6,7,8	1/8	3/16	DC	□ 275 - 350	Argon	1.3	20	5	one pass
	fillet	10	1/8	3/16	DC	□ 300 - 375	Argon	1.3	20	5	
1/2	butt	2,3	1/8 or 3/16	1/4	DC	□ 350 - 450	Argon	1.3	20	4	two or three passes
	lap	5	1/8 or 3/16	1/4	DC	□ 375 - 475	Argon	1.5	20	4	three passes
	corner	8	1/8 or 3/16	1/4	DC	□ 375 - 475	Argon	1.5	20	4	three passes
	fillet	10	1/8 or 3/16	1/4	DC	□ 375 - 475	Argon	1.5	20	4	three passes

In TIG welding of stainless steel, welding rods having the AWS prefixes of E or ER can be used as filler rods. However, only bare uncoated rods should be used. Stainless steel can be welded using AC high-frequency stabilized current, however for Direct Current Electrode Negative (DCEN) current recommendations must be increased 25%. Light gauge metal less than 1/16 in. thick should always be welded with Direct Current Electrode Negative (DCEN) using Argon gas. Follow the normal precautions for welding stainless such as clean surfaces and dry electrodes. Use only stainless steel tools and brushes. Carefully remove soap from welds after pressure testing, and keep stainless from coming into contact with other metals.

- Notes:
- ◊ Reduce current 10 to 20% for vertical and overhead welds.
 - ▲ Ceramic cup should be used for currents up to 250 amps.
 - Water-cooled cup should be used for currents above 250 amps.
 - Welding speed for multiple passes cannot be accurately predicted.



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