

TYPICAL WELDING PARAMETERS FOR STAINLESS STEEL SMAW (ELECTRODES)				
Diameter of Rod		Voltage (V)	Amperage (A)	
Inches	Millimeters		Flat	Vertical & Overhead
3/32"	2.4	24-28	70-85	66-75
1/8"	3.2	26-30	85-110	80-90
5/32"	4.0	28-32	110-140	100-120
3/16"	4.8	28-32	120-160	110-130

TYPICAL WELDING PARAMETERS OF STAINLESS STEEL TIG, MIG AND SAW					
Process	Diameter of Wire		Voltage (V)	Amperage (A)	Shielding Gas
	Inches	Millimeters			
TIG (GTAW)	0.035	0.9	15-20	60 - 90	100% Argon
	0.045	1.2	13 - 16	80 - 110	
	1/16"	1.6	14 - 18	90 - 130	
	3/32"	2.4	15 - 20	120 - 175	
	1/8"	3.2	15 - 20	150 - 220	
MIG (GMAW)	0.035	0.9	26 - 29	150 - 180	98% Argon/ 2% Oxygen or 97% Argon / 3% CO2
	0.045	1.2	28 - 32	180 - 220	
	1/16"	1.6	29 - 33	200 - 250	
Sub-Arc (SAW)	3/32"	2.4	28 - 30	275 - 350	Suitable Flux
	1/8"	3.2	29 - 32	350 - 450	
	5/32"	4.0	30 - 33	400 - 550	

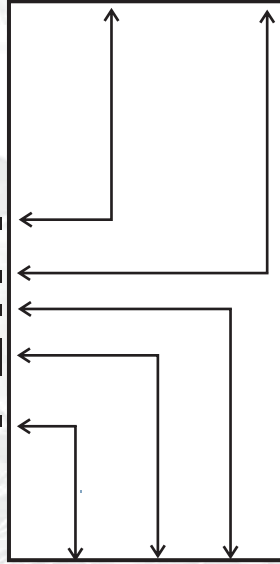
TYPICAL WELDING PARAMETERS FOR STAINLESS STEEL FLUX CORED

Diameter	0.35" 0.9mm					.045" 1.2mm					1/16" 1.6mm		
	100	120	140	170	130	165	190	220	170	210	250	300	
Amperage	23	23	25	26	25	26	28	30	25	27	28	29	
Voltage	265	315	405	530	227	341	445	567	154	193	243	321	
Wire Feed Speed in/min	2.9	3.4	4.6	5.7	4.25	6.14	8.08	10.24	5.34	6.89	8.57	11.43	
Deposition Rate lbs/hr	83.9	81.4	82.6	81.8	84	83	84	84	83	82.5	83	83	

AWS CLASSIFICATION OF FLUX CORED WIRE

AWS A5.22

E - XXX I X - X



DENOTES ELECTRODE

ALLOY COMPOSITION OF WELD DEPOSIT

TUBULAR / FLUX CORED

EXTERNAL SHIELDING GAS

- 1-CO2
- 3-NONE
- 4-75-80% Ar/Bal CO2
- 5-100% Ar

POSITION

- 0 - FLAT & HORIZONTAL
- 1 - ALL POSITION