TYPICAL WELDING PARAMETERS FOR NICKEL ALLOY 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 NICKEL ALLOY BARE WIRE					
Process	Diameter of Wire		Voltage (V)	Amperage (A)	Shielding Gas
	Inches	Millimeters			
TIG (GTAW)	0.035	0.9	12 - 15	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 - 190	75% Argon 25% Helium
	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 OF NICKEL ALLOY FCAW						
Diameter of Wire		Voltage (V)	Amperage (A)	Wire Feed Speed (ipm)	Extension in (mm)	Shielding Gas
Inches	Millimeters					
0.045	1.2	25-26	150-200	290-400	1/2 (12)	75% Ar-25% CO_2 or 100% CO_2
1/16"	1.6	26-27	200-250	190-275	1/2 (12)	