

THE PROPER SELECTION AND PREPARATION OF TUNGSTEN ELECTRODES FOR ARC WELDING

BASE METAL TYPE	THICKNESS RANGE	DESIRED RESULTS	WELDING CURRENT	ELECTRODE TYPE	COLOR TIPS	SHIELD GAS	TUNGSTEN PERFORMANCE CHARACTERISTICS
Aluminum Alloys and Magnesium Alloys	All	General Purpose	ACHP	Pure (EW-P)	Green(WP)	Argon	Balls easily, low cost, tends to spit at higher currents, used for non-critical welds only.
				2% Thoriated (EW-Th2)	Red(WC20)	75 Argon 25 Helium	Higher current range and stability, better arc starts, with lower tendency to spit, medium erosion.
	Only thin sections	Control penetration	DCRP	2% Ceriated (EW-Ce2)	Gray(WC20)	Argon Helium	Lowest erosion rate, widest current range, AC or DC, no spitting, best arc starts and stability.
	Only thick sections	Increase penetration or travel speed	DCSP	2% Thoriated (EW-Th2)	Red(WL20)	75 Argon 25 Helium	Best stability at medium currents, good arc starts, medium tendency to spit, medium erosion rate.
				2% Ceriated (EW-Ce2)	Gray(WC20)	Helium	Low erosion rate, wide current range, AC or DC, no spitting, consistent arc starts, good stability.
Copper Alloys, Cu-Ni Alloys and Nickel Alloys	All	General Purpose	DCSP	2% Thoriated (EW-Th2)	Red(WL20)	75 Argon 25 Helium	Best stability at medium currents, good arc starts, medium tendency to spit, medium erosion rate.
				2% Ceriated (EW-Ce2)	Gray(WC20)	75 Argon 25 Helium	Low erosion rate, wide current range, AC or DC, no spitting, consistent arc starts, good stability.
	Only thick sections	Increase penetration or travel speed	DCSP	2% Ceriated (EW-Ce2)	Gray(WC20)	75 Argon 25 Helium	Low erosion rate, wide current range, AC or DC, no spitting, consistent arc starts, good stability.
Mild Steels, Carbon Steels, Alloy Steels, Stainless Steels and Titanium Alloys	All	General Purpose	DCSP	2% Thoriated (EW-Th2)	Red(WC20)	75 Argon 25 Helium	Best stability at medium currents, good arc starts, medium tendency to spit, medium erosion rate.
				2% Ceriated (EW-Ce2)	Gray(WC20)	75 Argon 25 Helium	Low erosion rate, wide current range, AC or DC, no spitting, consistent arc starts, good stability.
				2% Lanthanated (EWG-La2)	Blue(WL20)	75 Argon 25 Helium	Lowest erosion rate, highest current range on DC, no spitting, best DC arc starts and stability.
	Only thick sections	Increase penetration or travel speed	DCSP	2% Ceriated (EW-Ce2)	Gray(WC20)	75 Argon 25 Helium	Low erosion rate, wide current range, no spitting, consistent arc starts, good stability.
				1.5% Lanthanated (EWG-La2)	Gold(WL13)	Helium	Lowest erosion rate, highest current range, no spitting, best DC arc starts and stability.

Tig Welding Guide Chart

Liyong Dong

A red circular graphic with a gradient, appearing as a semi-circle or a partial circle, located to the right of the author's name.

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Welder's Handbook Richard Finch, 2007-02-21 A newly updated state of the art guide to MIG and TIG arc welding technology Written by a noted authority in the field this revised edition of HP s bestselling automotive book for over 20 years is a detailed instructional manual on the theory technique equipment and proper procedures of metal inert gas MIG and tungsten inert gas TIG welding

Welding Terminology: A Guide to MIG, TIG, Stick, Gas, and Spot Welding Terms Chetan Singh, Welding Terminology A Guide to MIG TIG Stick Gas and Spot Welding Terms serves as your definitive guide to understanding the language of the welding industry with clarity and accuracy From experienced welders to engineering professionals inspectors and project managers this welding book empowers individuals at every level to communicate effectively and ensure successful welding projects Here s why it s important to understand welding terms Clarity and Precision Learn the complex processes materials and techniques of welding with confidence Clear communication reduces misunderstandings and errors and lays the foundation for successful projects Safety First Learn how proper terminology increases safety by reducing the risk of accidents and injuries by providing important information about welding procedures hazards and safety precautions Quality Assurance Discover how accurate terminology is integral to quality control and assurance processes ensuring welds meet industry standards and project requirements Compliance Made Easy Effortlessly navigates regulatory standards and codes with a solid understanding of welding terminology ensuring compliance and legal compliance in every project Education and Training Whether you are a student or a seasoned professional this guide lays the foundation for success in welding education and training programs preparing you for a prosperous career Enhanced Collaboration Facilitating seamless collaboration between stakeholders from welders to engineers and project managers with clear communication through welding terminology Documentation Excellence From welding procedure specifications WPS to inspection reports and project plans learn how consistent use of the terminology ensures accurate and reliable documentation Welding Terminology A Guide to MIG TIG Stick Gas and Spot Welding Terms is your indispensable companion to unlocking the full potential of welding projects Empower yourself with the language of welding

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Occupations Oklahoma. State Dept. of Vocational and Technical Education. Curriculum and Instructional Materials Center,1974 Metals Abstracts Index ,1996 Metal Progress ,1985-06 Sheet Metal Industries ,1985 *The Tube & Pipe Quarterly* ,1995 *Heating, Piping, and Air Conditioning* ,1963 Vols for May 1929 Dec 1958 include the Journal of the American Society of Heating and Air Conditioning Engineers called in 1929 54 American Society of Heating and Ventilating Engineers in Journal section **Basic Metallurgy and Metalworking of Aluminum** Kaiser Aluminum and Chemical Sales, inc,1968 *Walford's Guide to Reference Material: Science and technology* Albert John Walford,Library Association,1996

WAVAI Curriculum Guide for Instruction in Wisconsin High Schools ,1981 Smithells Metals Reference Book Colin James Smithells,G. B. Brook,1992 A reference book on metals which includes information on isotopes crystallography crystal chemistry gas metal systems electron emission magnetic properties heat treatment corrosion control and superplasticity

The Science and Practice of Welding: Volume 1 A. C. Davies,1993-02-11 The Science and Practice of Welding now in its tenth edition and published in two volumes is an introduction to the theory and practice of welding processes and their applications Volume I Welding Science and Technology explains the basics principles of physics chemistry and metallurgy as applied to welding The section electrical principles includes a simple description of the silicone diode and resistor the production and use of square wave and one knob stepless control of welding current There is a comprehensive section on non

destructive testing NDR and destructive testing of welds and crack tip opening displacement testing The text has been brought completely up to date and now includes a new chapter devoted to the inverter power unit Duplex stainless steel has been included in the list of material described

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