

Approximate Parameters for GTAW of Aluminum Alloys for Flat-position Butt Joints, Lap Joints, and Horizontal Fillets

Material Thickness In. (mm)	Electrode Diameter In. (mm)	Electrode Angle*	Electrode Tip Diameter* In. (mm)	Arc Current, Amps	Arc Volts, Volts	Filler Wire Diameter In. (mm)	Travel Speed IPM (mm/sec.)	Cup Diameter In. (mm)	Gas Flow Rate CFW(l/min.)
1/8 (1.6)	1/8 (1.6)	Horiz.	1/8 (1.6)	60-80	15	1/8 (1.6)	10 (4.2)	1/8 (9.5)	20 (9.4)
1/4 (3.2)	1/4 (2.4)	Horiz.	1/4 (2.4)	125-160	15	1/4 (2.4)	10 (4.2)	1/4 (9.5)	20 (9.4)
3/8 (4.8)	1/4 (3.2)	Horiz.	1/4 (3.2)	190-220	15	1/4 (3.2)	10 (4.2)	3/8 (11.1)	20 (9.4)
1/2 (6.4)	1/4 (4.0)	Horiz.	1/4 (4.0)	200-300	15	1/4 (3.2)	10 (4.2)	1/2 (12.7)	25 (11.8)
5/8 (9.5)	1/4 (4.8)	Horiz.	1/4 (4.8)	330-380	15	1/4 (4.8)	8 (3.4)	5/8 (15.9)	25 (11.8)
3/4 (12.7)	1/4 (6.4)	Horiz.	1/4 (6.4)	400-450	25	1/4 (6.4)	8 (3.4)	3/4 (15.9)	25 (11.8)

*See Figure 1.

Notes: Electrodes should be EW2 or EWP used on AC power.

Shielding gas should be argon except for 1/4-inch (12.7-mm) plate, with which a helium/argon mixture can be used for increased penetration.

Filler wire composition should match base metal composition or conform to recommended filler wire for each base material.

Gtaw Amp Chart Guide

R Sandford



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