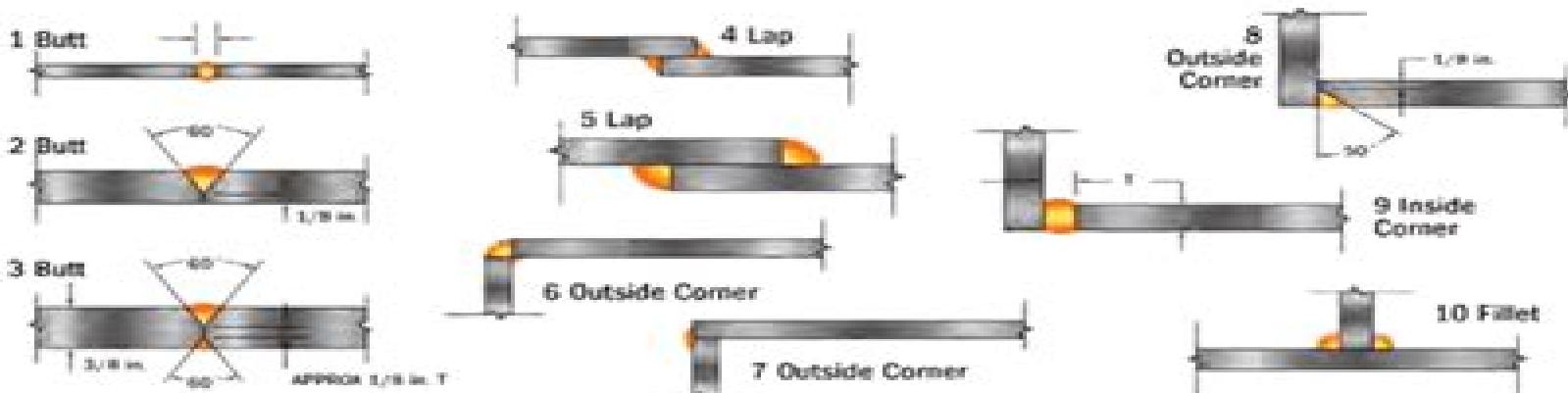


| Work | Weld | | TWCH | Filler Rod | Current (Flat Welding) | | Gas | | | Speed | Remarks |
|------------------------|--------|--------|-----------------------------|-------------------|---------------------------|-----------------------|-------|----------|-----|-------------------------|---------------------|
| Thickness (in.) | Type | Number | Tungsten Electrode Diameter | (16 Amp) Diameter | Type | Amperes (A) | Type | Flow CFH | PSI | Inches Per Minute | |
| Stainless Steel | | | | | | Manual Welding | | | | | |
| 1/16 | butt | 1 | 1/16 | 1/16 | DC | A 80 - 100 | Argon | 11 | 20 | 12 | |
| | lap | 2.5 | 1/16 | 1/16 | DC | A 100 - 120 | Argon | 11 | 20 | 10 | |
| | corner | 6.7.9 | 1/16 | 1/16 | DC | A 80 - 100 | Argon | 11 | 20 | 12 | |
| | fillet | 10 | 1/16 | 1/16 | DC | A 80 - 100 | Argon | 11 | 20 | 10 | |
| 3/32 | butt | 1 | 1/16 | 1/16 or 3/32 | DC | A 100 - 120 | Argon | 11 | 20 | 12 | |
| | lap | 4.5 | 1/16 | 1/16 or 3/32 | DC | A 110 - 130 | Argon | 11 | 20 | 10 | |
| | corner | 6.7.9 | 1/16 | 1/16 or 3/32 | DC | A 100 - 120 | Argon | 11 | 20 | 12 | |
| | fillet | 10 | 1/16 | 1/16 or 3/32 | DC | A 110 - 150 | Argon | 11 | 20 | 10 | |
| 1/8 | butt | 1 | 1/16 | 5/32 | DC | A 120 - 140 | Argon | 11 | 20 | 12 | |
| | lap | 4.5 | 1/16 | 5/32 | DC | A 130 - 150 | Argon | 11 | 20 | 10 | |
| | corner | 6.7.9 | 1/16 | 5/32 | DC | A 130 - 140 | Argon | 11 | 20 | 12 | |
| | fillet | 10 | 1/16 | 5/32 | DC | A 130 - 150 | Argon | 11 | 20 | 10 | |
| 3/16 | butt | 1 | 3/32 | 1/8 | DC | A 200 - 250 | Argon | 13 | 20 | 10 | |
| | lap | 5 | 3/32 or 1/8 | 1/8 | DC | □ 225 - 275 | Argon | 13 | 20 | 8 | |
| | corner | 6.7.9 | 3/32 | 1/8 | DC | A 200 - 250 | Argon | 13 | 20 | 10 | |
| | fillet | 10 | 3/32 or 1/8 | 1/8 | DC | □ 225 - 275 | Argon | 13 | 20 | 8 | |
| 1/4 | butt | 1.2 | 1/8 | 3/16 | DC | □ 375 - 550 | Argon | 13 | 20 | 5 | one or two passes |
| | lap | 5 | 1/8 | 3/16 | DC | □ 300 - 375 | Argon | 13 | 20 | 5 | one or two passes |
| | corner | 6.7.9 | 1/8 | 3/16 | DC | □ 375 - 550 | Argon | 13 | 20 | 5 | one pass |
| | fillet | 10 | 1/8 | 3/16 | DC | □ 300 - 375 | Argon | 13 | 20 | 5 | |
| 1/2 | butt | 2.5 | 1/8 or 3/16 | 1/4 | DC | □ 350 - 450 | Argon | 15 | 20 | 8 | two or three passes |
| | lap | 5 | 1/8 or 3/16 | 1/4 | DC | □ 375 - 475 | Argon | 15 | 20 | 8 | three passes |
| | corner | 8 | 1/8 or 3/16 | 1/4 | DC | □ 375 - 475 | Argon | 15 | 20 | 8 | three passes |
| | fillet | 10 | 1/8 or 3/16 | 1/4 | DC | □ 375 - 475 | Argon | 15 | 20 | 8 | 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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Rosina Ehmann

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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

Japan Trade Guide ,1954 **Magnesium Technology 2020** J. Brian Jordon,Victoria Miller,Vineet V. Joshi,Neale R. Neelameggham,2020-01-22 The Magnesium Technology Symposium the event on which this collection is based is one of the largest yearly gatherings of magnesium specialists in the world Papers represent all aspects of the field ranging from primary production to applications to recycling Moreover papers explore everything from basic research findings to industrialization Magnesium Technology 2020 covers a broad spectrum of current topics including alloys and their properties cast products and processing wrought products and processing forming joining and machining corrosion and surface finishing and structural applications In addition there is coverage of new and emerging applications

ICAMDMS 2024 Rangasamy Rudramoorthy,M Senthilkumar,M R Pratheesh Kumar,J Pradeep Kumar,R Rajamani,Jeevarathinam Baskaran,2024-06-17 We the Department of Production Engineering PSG College of Technology Coimbatore Tamil Nadu India are delighted to introduce the proceedings of the International Conference on the Advancements in Materials Design and Manufacturing for Sustainable Development ICAMDMS 2024 The conference proceedings encapsulate the knowledge of diverse insights and cutting edge research shared by the participants of the conference in significant domains such as materials design manufacturing industrial and production engineering converging on the theme of sustainable development The technical program of ICAMDMS 2024 consists of 46 full papers including nine oral presentation sessions at the main conference themes The conference themes are Track 1 Advanced Materials Track 2 Design Track 3 Manufacturing and Track 4 Industrial and Production Engineering Aside from the high quality technical paper presentations the technical program also featured eight keynote lectures The eight keynote speakers are 1 Dr Redouane Zitoune from Paul Sabatier University Toulouse III France 2 Dr Jinyang Xu from Shanghai Jiao Tong University China 3 Dr Juan Pablo from Escobedo Daiz UNSW Canberra Australia 4 Dr Santhakumar Mohan from IIT Palakkad 5 Dr Afzaal Ahmed from IIT Palakkad 6 Dr Ravi K R from IIT Jodhpur 7 Mr Vijay V from Lakshmi Machine Works Advanced Technology Center Coimbatore and 8 Ms Thangamalar from Research and Development Tractors and Farm Equipment TAFE Chennai The Conference was enlightened with an industrial talk by Dr S Chandrasekar Corporate Director Roots Group of Companies Coimbatore ICAMDMS 2024 was sponsored by Propel Industries Pvt Ltd Coimbatore PSG Centre for Academic Research and Excellence Coimbatore Janatics India Pvt Ltd Coimbatore Baarga Die Castings Coimbatore Crossfields Water Purifiers Pvt Ltd Coimbatore TESA Technology Coimbatore Guruvayurappan Textile Pvt Ltd Udumalpet Sakthi Gear Products Coimbatore and 2017 21 and 2018 22 alumni of the Department of Production Engineering In this compendium one can find

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