

## 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<br>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<br>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<br>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<br>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<br>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<br>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<br>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<br>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<br>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

**A Loxley**



## **Tig Welding Guide Chart:**

**Welding and Metal Fabrication** ,1989      *Welding Design & Fabrication* ,1988      **Vocational Education : State Instruction Materials for ...** Oklahoma. State Department of Vocational and Technical Education. Curriculum and Instructional Materials Center,1974      **Welding Engineer** ,1966      **Basic TIG & MIG Welding** Ivan H. Griffin,Edward M. Roden,1971      **Resources in education** ,1984-07      *Metal Progress* ,1985-06      **Engineering Materials and Design** ,1980      **Fundamentals of Mobile Heavy Equipment** Gus Wright,Owen C. Duffy,Scott A. Heard,2017-09-21  
Fundamentals of Mobile Heavy Equipment provides students with a thorough introduction to the diagnosis repair and maintenance of off road mobile heavy equipment With comprehensive up to date coverage of the latest technology in the field it addresses the equipment used in construction agricultural forestry and mining industries      Basic Metallurgy and Metalworking of Aluminum Kaiser Aluminum and Chemical Sales, inc,1968      *Walford's Guide to Reference Material* Marilyn Mullay,Priscilla Schlicke,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      **Sheet Metal Industries** ,1985      *Production* ,1969      *Catalog of Copyright Entries. Third Series* Library of Congress. Copyright Office,1968 Includes Part 1 Number 2 Books and Pamphlets Including Serials and Contributions to Periodicals July December      **Vocational Education : State Instructional Materials for Trade and Industrial Occupations** Oklahoma. State Dept. of Vocational and Technical Education. Curriculum and Instructional Materials Center,1974      **Library of Congress Catalog** Library of Congress,1971  
**Advanced Materials & Processes** ,1989-07      **Power Engineering** ,1964

## Decoding **Tig Welding Guide Chart**: Revealing the Captivating Potential of Verbal Expression

In a period characterized by interconnectedness and an insatiable thirst for knowledge, the captivating potential of verbal expression has emerged as a formidable force. Its ability to evoke sentiments, stimulate introspection, and incite profound transformations is genuinely awe-inspiring. Within the pages of "**Tig Welding Guide Chart**," a mesmerizing literary creation penned with a celebrated wordsmith, readers embark on an enlightening odyssey, unraveling the intricate significance of language and its enduring impact on our lives. In this appraisal, we shall explore the book's central themes, evaluate its distinctive writing style, and gauge its pervasive influence on the hearts and minds of its readership.

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web the only factor different between the two types of moths is the color of the wings your role in the simulation is that of a predator guide the bird with the mouse to the moths click on the moth with the mouse to eat the moth every time you eat a moth you will hear the crunch of an exoskeleton if you miss the moth you will hear the bird call

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web guide the bird to the moths click on the moth to eat it you have one minute to eat as many moths as you can see what impact eating more light or dark moths has on moth population

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web the chance that the bird will see and eat the moth depends on the color contrast between insect and bark the predation will range from 0 to 50 or from 0 to 99 which can be selected by the user the relation between color contrast and percentage predation can be a straight line or a curved line see graphs below

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