

Welding Theory 1069-01 – Notes

Shielding Gas & Welding Electrodes:

Shielding Gas:

- Shields the weld from air
- Influence the emission of fumes and gasses
- Provide reliable arc initiation and stability
- Influence the mode of metal transfer
 - o Short circuit
 - o Globular
 - o Spray
 - o pulse
- Assist in achieving the required metallurgical and mechanical properties
- Affect the weld appearance and profile

Shielding gas can be grouped accordingly to their chemical activity

- o Inert
 - Inert does not combine with elements in the weld pool
 - Argon
 - o Will not mix with materials in the weld zone. Argon is denser than air and will sink. These are more effective for use as a shielding gas to protect the arc. Overtime is cheaper than helium as it doesn't disperse as quickly. It is required to weld non-ferrous metals such as aluminum and is used for welding low alloy steels and stainless steels. The lower ionization potential of argon allows for axial spray transfer ranges in concentrations above 85% and gives deep, narrow base metal penetration. Pure argon should not be used to weld Carbon steel and thus combined with other gasses give weld metal more desirable properties.
 - Helium
 - o Is an inert gas. It is less dense than air requiring a higher gas flow rates in flat and horizontal positions. Higher arc voltage than argon is needed for a given arc length leading to a hotter puddle deposition. Helium is most used as a component in mixed gasses, primarily for non-ferrous metals.
 - Helium-Argon Mixtures

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American Society for Metals

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