

All suggested settings are approximate.

Settings are for manual, not automated, welding.

**Inverter-based welders generally require less heat input
(lower amps)**

Welds should be tested to comply to your specifications.

Tungsten Electrode Diameter:

1/16" (1.6 mm)

Traditional Squarewave machines typically perform well with pure tungsten (green band). Alternative tungsten includes 2% ceriated (orange band). Green or orange tungsten should be balled before welding.

Inverter Squarewave machines typically perform best with 2% ceriated (orange band) tungsten. Other tungsten will work. With proper parameter settings (balance 70% or greater, frequency 100hz or greater) orange tungsten will allow you to weld aluminum with pointed tungsten.

Torch Cup Orifice Diameter:

1/4 - 3/8" (6.4 - 9.5 mm)

Use ceramic cup when welding with less than 250 amps. Use water-cooled torch when welding with more than 200 amps.

Filler Metal Diameter:

3/32" (2.4 mm) or 1/8" (3.2 mm)

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