

Current Ranges for Tungsten Electrodes (Argon Shielding Gas)

Electrode Diameter (inches)	Dcen, A	Dcep, A	High-Frequency unbalanced ac, A			High-Frequency balanced ac, A		
	EWP EWTh-1 EWTh-2 EWTh-3	EWP EWTh-2 EWTh-2 EWTh-3	EWP	EWTh-1 EWTh-2 EWZr	EWTh-3	EWP	EWTh-1 EWTh-2 EWZr	EWTh-3
0.010	up to 15	--	up to 15	up to 15	--	up to 15	up to 15	--
0.020	5-20	--	5-15	5-20	--	10-20	5-20	10-20
0.040	15-80	--	10-60	15-80	10-80	20-30	20-60	20-60
1/16	70-150	10-20	50-100	70-150	50-150	30-80	60-120	30-120
3/32	150-250	15-30	100-160	140-235	100-235	60-130	100-180	60-180
1/8	250-400	25-40	150-210	225-325	150-325	100-180	160-250	100-250
5/32	400-500	40-55	200-275	300-400	200-400	160-240	200-320	160-320
3/16	500-750	55-80	250-350	300-500	250-500	190-300	290-390	190-390
1/4	750-1000	80-125	325-450	400-630	325-630	250-300	340-525	250-525

Stainless Steels - Filler Metals for Welding Dissimilar Steels

Base Alloy Type	201, 202 301, 302 302B, 303 304, 305, 308	304L	309 309S	310 310S	316	316L	317	317L	321 347 348	330	400, 405 410, 412 414, 420	430, 430F, 431, 440A 440B 440C	446	501 502	505	Carbon Steels	Cr-Mo Steels
201, 202, 301, 302, 302B, 303, 304, 305, 308	E308	E308	E308	E308	E308	E308	E308	E308	E308	E309	E309	E309	E310	E309	E309	E309	E309
304L		E308L	E308	E308	E308	E308	E308	E308	E308	E309	E309	E309	E310	E309	E309	E309	E309
309, 309S		E309	E309	E309	E309	E309	E309	E309	E309	E309	E309	E309	E310	E309	E309	E309	E309
310, 310S, 314				E310	E316	E316	E317	E317	E308	E310	E309	E309	E310	E310	E310	E310	E309
316					E316	E316	E316	E316	E308	E309	E309	E309	E310	E309	E309	E309	E309
316L						E316L	E316	E316L	E316L	E309	E309	E309	E310	E309	E309	E309	E309
317							E317	E317	E308	E309	E309	E309	E310	E309	E309	E309	E309
317L								E317L	E308L	E309	E309	E309	E310	E309	E309	E309	E309
321, 347, 348									E347	E309	E309	E309	E310	E309	E309	E309	E309
330										E330	E309	E309	E310	E312	E312	E312	E312
400, 405, 410, 414, 416, 420											E410	E430	E410	E502	E505	E309	E410
430, 430F, 431, 440A, 440B, 440C												E430	E430	E502	E505	E430	E430
446													E446	E502	E502	E430	E430
501, 502														E502	E502	E502	E502
505															E505	E505	E505

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