

TYPICAL WELDING PARAMETERS OF COBALT SMAW (ELECTRODES)		
Diameter of Rod		Amperage (A)
Inches	Millimeters	Flat
1/8"	3.2	80-110
5/32"	4	120-150
3/16"	4.8	150-180
1/4"	6.4	190-250

TYPICAL WELDING PARAMETERS OF COBALT OAW				
Diameter of Rod		TIP SIZE	FLAME	POSITION
Inches	Millimeters			
1/8"	3.2	4	3X-4X	FLAT
5/32"	4	4	3X-4X	
3/16"	4.8	5	3X-4X	
1/4"	6.4	6	3X-4X	

TYPICAL WELDING PARAMETERS OF COBALT GTAW & GMAW					
Process	Diameter of Wire		Voltage (V)	Amperage (A)	Shielding Gas
	Inches	Millimeters			
TIG (GTAW)	1/8"	3.2	20-40	90-120	100% Argon
	5/32"	4.0	20-40	120-140	
	3/16"	4.8	20-40	140-160	
	1/4"	6.4	20-40	160-180	
GMAW	0.045	1.2	25-27	180-200	100% Argon
	0.062	1.6	26-28	280-300	

Data contained in this publication are typical of products and properties described, but are not suitable for specifications.

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