

RECOMMENDED TUNGSTEN ELECTRODES & SHIELDING GASES FOR TIG WELDING

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TYPE OF METAL	THICKNESS	CURRENT ELECTR.	TUNGSTEN ELECTRODE	SHIELDING GAS	
ALUMINUM	ALL	AC HIGH FREQ.	PURE, ZIRCONIUM	ARGON, ARGON-HELIUM	
	THICK ONLY	DC NEG.	THORIATED	ARGON-HELIUM, ARGON	
	THIN ONLY	DC POS.	THORIATED, ZIRCONIUM	ARGON	
COPPER AND COPPER ALLOYS	ALL	DC NEG.	THORIATED	ARGON, ARGON-HELIUM	
	THIN ONLY	AC HIGH FREQ.	PURE, ZIRCONIUM	ARGON	
MAGNESIUM ALLOYS	ALL	AC HIGH FREQ.	PURE, ZIRCONIUM	ARGON	
	THIN ONLY	DC NEG.	ZIRCONIUM, THORIATED	ARGON	
	ALL	DC NEG.	THORIATED	ARGON	
NICKEL AND NICKEL ALLOYS	ALL	DC NEG.	THORIATED	ARGON, ARGON-HELIUM	
	THIN ONLY	AC HIGH FREQ.	PURE, ZIRCONIUM	ARGON	
PLAIN CARBON AND LOW ALLOY STEELS	ALL	DC NEG.	THORIATED	ARGON, ARGON-HELIUM	
	THIN ONLY	AC HIGH FREQ.	PURE, ZIRCONIUM	ARGON	
STAINLESS STEEL TOOL STEEL	ALL	DC NEG.	THORIATED	ARGON, ARGON-HELIUM	
	ALL	DC NEG.	THORIATED	ARGON	
TITANIUM	ALL	DC NEG.	THORIATED	ARGON	



THE SOURCE FOR ALL YOUR WELDING PRODUCTS