RECOMMENDED NICKEL WELDING PROCEDURES

Generation4™ Nickel Welding wire alloys can be used with many different joint styles and welding processes. Once the weld joint style, the filler material, and the process has been identified, a proper welding procedure can be identified. The welding procedure chosen for Nickel welding depends upon the process to be used as well as the size and alloy of the actual consumable. The chart below provides detailed information on the voltage, amperage (current), and gas (atmosphere) to be used in TIG (Tungsten Inert Gas), MIG (Metal Inert Gas), and SAW (Submerged-Arc Welding) welding processed for the general alloys that we provide. If you have questions about selecting the right procedure, or about the recommended welding procedure for a specific CWI Generation4 ™ wire, contact a material and applications expert today.

Recommended Welding Procedures for Gen^4 Nickel Welding Wire

Process	Diameter of Wire		Voltage (V)	Amperage (A)	Gas
TIG	0.035”	0.9 mm	12-15	60-90	100% Argon
	0.045”	1.1 mm	13-16	80-110	100% Argon
	1/16”	1.6 mm	14-18	90-130	100% Argon
	3/32”	2.4 mm	15-20	120-175	100% Argon
	1/8”	3.2 mm	15-20	150-220	100% Argon
MIG	0.035”	0.9 mm	26-29	150-190	75% Argon + 25% Helium
	0.045”	1.2 mm	28-32	180-220	75% Argon + 25% Helium
	1/16”	1.6 mm	29-33	200-250	75% Argon + 25% Helium
SAW	3/32”	2.4 mm	28-30	275-350	Suitable Flux may be used
	1/8”	3.2 mm	29-32	350-450	Suitable Flux may be used
	5/32”	4.0 mm	30-33	400-550	Suitable Flux may be used