



ELECTRODES

Table of Content

Mild Steel Carbon Electrodes	4
Carbon Steel Welding Wire	5
Low Alloy Electrode for Steel Applications	6
PINNACLE ALLOY (Carbon Steel)	6
Nickel Electrodes for Cast Iron	6
Bronze Alloy Electrodes	7
High Manganese/Build-up and Hardfacing Electrodes	7
Submerged Arc Welding Wire	8
General amperage Chart for coated electrodes	9
Procedures for Product Safe Keeping and Storage	10



ELECTRODES

Mild Steel Carbon Cellulosic

Image	PN	AWS Classification	Diameter		Size	Package	Characteristics	Applications
			Inch.	mm				
	2083	INFRA 10-S E 6010	3/32"	2.4	14"	44 lbs Carton (Four (11 lbs) Bags)	All Positions, deep Arc penetration. Minimum spatter and light slag with easy slag removal. X-Ray weld quality. Use DC PI (+).	General fabrication, holding tanks, construction and field erection, truck chassis, etc.
	2085		1/8"	3.2	14"			
	2095		5/32"	4	14"			
	2096		3/16"	4.8	14"			
	2065	INFRA 10-P E 6010	1/8"	3.2	14"	44 lbs Carton (Four (11 lbs) Bags)	Deep Arc penetration and X-Ray quality welds. Use CD PI (+).	General fabrication, holding tanks, construction and Oil Rigs, truck chassis, etc.
	2075		5/32"	4	14"			
	2105	INFRA 11 E 6011	3/32"	2.4	14"	44 lbs Carton (Four (11 lbs) Bags)	All Positions, good appearance and X-Ray quality welds. Use AC / DC PI (+).	General fabrication, holding tanks, construction and field erection, truck chassis, etc.
	2110		1/8"	3.2	14"			
	2115		5/32"	4	14"			

Rutile Potassium Based Flux Coated

	2145	INFRA 13 VD E 6013	3/32"	2.4	14"	44 lbs Carton (Four (11 lbs) Bags)	All Positions, vertical position is ideal, very stable Arc and good appearance. Use AC / DC(-).	All types of mild steel fabrication, light construction and auto chassis.
	2155		1/8"	3.2	14"			
	2165		5/32"	4	14"			
	2210	INFRA EXCEL ARC E 6013	3/32"	2.4	14"	44 lbs Carton (Four (11 lbs) Bags)	Medium Arc, allows single and multiple pass depositing quick with good appearance. Use AC / DC PI or PD.	All types of mild steel fabrication, specially thin-sheet structures.
	2215		1/8"	3.2	14"			
	2176	INFRA PUNTA NARANJA E 6013	3/32"	2.4	14"	44 lbs Carton (Four (11 lbs) Bags)	Ideal for vertical position, medium Arc, instant restart, with good appearance. Use with most machines. Use AC / DC PI or PD.	All types of mild steel fabrication, auto chassis fabrication and sheet metal.
	2178		1/8"	3.2	14"			
	2180		5/32"	4	14"			
	2255	AW ECO WELD E 6013	3/32"	2.4	14"	44 lbs Carton (Eight (5.5 lbs) Bags)	Only Eco-friendly electrode in México, produces less CO ₂ emissions. Stable Arc and great appearance.	All types of mild steel fabrication, sheet metal and maintenance and repair welding. Can be use with most currents.
	2256		1/8"	3.2	14"			

High Speed Iron Powder Heavy Coated

	2206	INFRA 724 E 7024	1/8"	3.2	14"	44 lbs Carton (Four (11 lbs) Bags)	Medium Arc, high deposit rates with minimal splatter with X-Ray quality. Superior mechanical properties. E 7024, flat/horizontal position only. Use AC / DC PD or PI.	General fabrication, holding tanks, construction equipment, ships and rail cars.
	2207		5/32"	4	14"			





Low Hydrogen

	2190	INFRA 718 E 7018	3/32"	2.4	14"	44 lbs Carton (Four (11 lbs) Bags)	Good ignition and re-ignition, high deposition rates with metallurgical X-Ray quality. Use DC PI.	General fabrication heavy construction dynamic structures in oil, chemical, oil industries
	2195		1/8"	3.2	18"			
	2197		5/32"	4	18"			
	2205		3/16"	4.8	18"			
	2332	INFRA 718 H4 E 7018 H4	3/32"	2.4	14"	44 lbs Carton (Four (11 lbs) Bags)	Stable Arc, low Hydrogen content achieves X-Ray quality. Easy to-use with minimal splatter and light slag with easy slag removal.	Industries where X-Ray quality is required. Buildings, bridges, cranes, ships, trains, holding tanks, and high pressure containers, construction, mining and sugar mills.
	2333		1/8"	3.2	14"			
	2331		5/32"	4	14"			
	2334		3/16"	4.8	14"			
	2320	AW ECO WELD E 7018 •	1/8"	3.2	14"	44 lbs Carton (Eight (5.5 lbs) Bags)	Only Eco-friendly electrode produces less CO ₂ emissions. Stable Arc and great appearance with X-Ray quality.	Steel fabrication, heavy construction, power plants, chemical, oil and mining industries. Applications that will be under low temperatures and cold weather conditions. Rail roads and train carts.
	2321		5/32"	4	14"			






• Certification E-7018 Sismic Grade

E-7018 has been tested and approved as a seismic grade electrode. Approved by FEMA 353 and AWS D1.8 –Structural Welding Code – Seismic Supplement, with the capacity of deep deposits certified to resist impacts higher than 54 Joules at 70°F an higher than 27 Joules a 0°F. E-7018 electrode is also approved on the low Hydrogen content.

Carbon Steel Welding Wire

Image	PN	AWS Classification	Diameter		Package	Characteristics	Applications
			Inch	mm			
	2046 2048	INFRA WELDING WIRE ER 70S-6 AWS A5.18	0.023"	0.6	2 lb Plastic Spool	Great productivity, high deposit rates due to the magnesium content. Stable shield with CO ₂ mix. Use DC PI.	Ideal for carbon steel MIG/TIG applications. Use with portable machines MM-140, MM-180 and Trilogia 200i. Industrial and general fabrication. Complies to SFA 5.18 M.
	2047 2049		0.023"	0.6			
	2025 2035 2058	INFRA WELDING WIRE ER 70S-6 AWS A5.18	0.035" 0.045" 0.052"	0.9 1.1 1.3	33 lb Wire Spool	Great productivity, high deposit rates due to the magnesium content. Stable shield with CO ₂ mix. Use DC PI.	Ideal for carbon steel MIG/TIG applications. Industrial and general fabrication. Automotive, truck chassis and general construction. Complies to SFA 5.18 M.
	2016 2017	WELDMIXX WELDING WIRE ER 70S-6 AWS A5.18	0.035" 0.045"	0.9 1.1	33 lb Wire Spool		
	2020* 2030* 2021*	INFRAPACK ER 70S-6 AWS A5.18	0.035" 0.045" 0.052"	0.9 1.1 1.3	550 lb Drum	INFRAPACK ER 70S-6 allows continuous microwire feeding for heavy duty long lasting projects. Workflow time will not be interrupted to change smaller spools. Stations will need access cone, and accessories to insure wire feeding can be optimal. Please contact Infra for more details.	Ideal for carbon steel MIG/TIG applications. For heavy duty long lasting projects. Workflow time will not be interrupted to change smaller spools. Ideal for manufacturing and industrial plants with multiple work stations. Industrial and general fabrication like ship & barge building. Complies to SFA 5.18 M.
	2168*		-	1.2	660 lb Drum		
	2050* 2051*		INFRAPACK ER 70S-3 AWS A5.18	0.035" 0.045"	0.9 1.1		



Extra Low Carbon Electrode

	6236 6230 6245	AW IL E 308L-16	3/32" 1/8" 5/32"	2.4 3.2 4	12" 14" 14"	Plastic Cylinder with (11 lbs Bag)	Extra low carbon, versatile electrode designed to weld several types of austenitic steels. Smooth ripples with minimal splatter and light slag with easy slag removal. Use AC/ DC PI.	Extra low carbon electrodes were developed for the welding of Type 304L stainless steels but can be used for many other stainless steels including Types 301, 302 & 304. They are used extensively for the welding of chemical plant equipment.
	6226 6215	AW I MoL E 316L-16	3/32" 1/8"	2.4 3.2	12" 14"	Plastic Cylinder with (11 lbs Bag)	Anticorrosive properties due to high content of Molybdenum. High temperature resistance with cristal like finish. Use AC/ DC PI.	Used for many other stainless steels including Types 316, 321 y 316 L. They are used extensively for the welding of chemical plant equipment.
	6385	AW INOX WELD 309 E 309-16	1/8"	3.2	14"	Plastic Cylinder with (11 lbs Bag)	Premium Arc performance and easy strike and re-strike with minimal splatter. Smooth ripples and light slag with easy slag removal. Welds keep up to 900°C temperature. Use AC/ DC PI.	It can be used for carbon and low alloy steels and stainless steel dissimilar joints. 25/20 Cr Ni. Welds Type 405, 420 y 430 Steel. Industrial and general steel and stainless steel fabrication.
	6265	AW II E 310-16	1/8"	3.2	14"	Plastic Cylinder with (11 lbs Bag)	Premium Arc performance and easy strike and re-strike with minimal splatter. Smooth ripples and light slag with easy slag removal. Welds keep up to 1200°C temperature. Use AC/ DC PI.	Excellent for devices that withstand high temperatures in the petrochemical, food and beverage and chemical industry.
	6156 6165 6175 6185*	AW 880 E 312-16	3/32" 1/8" 5/32" 3/16"	2.4 3.2 4 4.8	12" 14" 14" 14"	Plastic Cylinder with (11 lbs Bag)	The perfect electrode to use where the base metal is an unknown grade of steel. Good mechanical properties for welding of mild steels. Welds keep up to 450°C temperature. Use AC/ DC PI.	All types of mild steel fabrication. Maintenance and repair welding. Designed for joining stainless steel to mild or low alloy steel.





ELECTRODES

Low Alloy Electrode for Steel Applications




Image	PN	AWS Classification	Diameter		Size	Package	Characteristics	Applications
			Inch.	mm				
	2218 2219	INFRA 918-B3 E 9018 B3	1/8" 5/32"	3.2 4	14" 14"	44 lbs Cylinder (Four (11 lbs) Bags)	Premium Arc performance and easy strike. X-Ray quality. Low hydrogen allows multiple applications on different types of steel . Use with DC.	Welding of chromium and Molybdenum low alloys steels. Ship building, pressure piping and mild steel.
	6094 6098	AW 8018 D3 E8018 D3	1/8" 5/32"	3.2 4	14" 14"	Plastic Cylinder with (11 lbs Bag)	Molybdenum flux coated low alloy electrode. Excellent for types of steel applications including mechanical and industrial equipment.	Commonly used on pressure vessels, heat exchange piping and other related components.

For a full variety of carbon steel and stainless steel electrodes, please contact infraproducts.us


PINNACLE ALLOY (Carbon Steel)

	6770 6771	TIG WELD ER 70S-3	3/32" 1/8"	2.4 3.2	36"	Tube package (11 lbs)	Premium copper-coated, solid electrode with moderate levels (%) of manganese and silicon.	Excellent feedability and welding characteristics. Ideal for heat exchange equipment in the petrochemical, food, beverage and chemical industry.
	6773 6774	TIG WELD ER 70S-6	3/32" 1/8"	2.4 3.2	36"	Tube package (11 lbs)	Premium copper-coated, solid electrode with moderate levels (+ %) of manganese and silicon.	Excellent feedability and welding characteristics. Ideal for heat exchange equipment in the petrochemical, food, beverage and chemical industry.


Nickel Electrodes for Cast Iron

	6506 6510	AW NILOX E Ni-CI	3/32" 1/8"	2.4 3.2	12" 14"	Plastic Cylinder with (Plastic 11 lbs Bag)	Uses minimal working amperage, without porosity or undercuts. Its great elongation allows it to absorb the residual stresses that remain inside the piece. Use AC/CD PD	For welding cast irons (gray, malleable and nodular). Machinable for precision finishes. In the automotive industry, foundries and maintenance areas.
	6340 6345*	AW FERRONILOX 60 E NiFe-CI	1/8" 5/32"	3.2 4.0	14" 14"	Plastic Cylinder with (Plastic 11 lbs Bag)	Lower expansion coefficient, greater resistance and ductility, lower tendency to fracture. Deposit 60% Ni. It can be combined with NILOX or AW 127 in critical joints, as an anti-friction material. Use AC/CD PI.	For welding malleable and nodular cast iron. In the automotive industry, foundries and maintenance areas.
	6040	AW 127 E St	1/8"	3.2	14"	Plastic Cylinder with (Plastic 11 lbs Bag)	Use with AC/CD PI. Seals the walls of the bevel, allowing pore-free joints in cast irons. DO NOT USE ON ANY TYPE OF MACHINE.	For welding malleable and nodular cast iron. Ideal for use as a healthy material addition to old, burnt or extremely dirty and contaminated foundries.



Tool Electrode

	6325 6330	AW CUT WELD	1/8" 5/32"	3.2 4	14" 14"	44 lbs Cylinder (Three (11 lbs) Bags)	High heat power arc, rapid release of particles that allow the material to be melted and cleanly separated from the cutting area, allowing a groove clean of impurities. Use AC/CD PI or PD.	All types of steel with a ferritic or austenitic structure, as well as cast steel, cast iron and all non-ferrous metals.
--	--------------	-------------	---------------	----------	------------	--	--	--


Flux Coated Aluminum / Silicone (5%) Electrode

	6043	AW 2201 E 4043 Flux coated Al-Si	1/8"	3.2	14"	Cylinder 3 kg	Excellent performance and easy strike and re-strike with minimal splatter. Removal of oxides, Ideal for of outstanding joints. It can be applied with a blowtorch, using a slightly fueled flame. Good bonding properties and capillary fluidity. Use DC PI.	For joints and coatings in alloys and cast iron of the Al-Si types. Architectural structures, manufacturing and repair of molds, correction of casting defects, tanks and containers for the paper and oil industry.
--	------	---	------	-----	-----	---------------	--	--



Bronze Alloy Electrode

Image	PN	AWS Classification	Diameter		Size	Package	Characteristics	Applications
			Inch.	mm				
	6275	AW BRNSOMATIC A E CuAl-A2 Flux Coated	1/8"	3.2	14"	Plastic Cylinder with (11 lbs Bag)	Bronze/aluminum alloy, welds thin cords with a short arc, easy to tie with cast irons and steels. Use DC P.I. Horizontal Position.	For welding of copper and copper alloys, phosphor bronzes and tin alloys, bearings, bushings, shafts, gears, speed reducers, pipes and hardware. In the alcohol, perfumery, sugar, brewing and pharmaceutical industries.
	6295	AW BRNSOMATIC B E Cu Sn-A Flux Coated	1/8"	3.2	14"	Plastic Cylinder with (11 lbs Bag)	Tin bronze electrode. Anti-friction capacity, makes fine cords with short arc. Ease of bonding with steel and cast iron. Thickness more than 1/4" preheat to a 480 °F min. Use DC P.I.	For welding of copper and copper alloys, phosphor bronzes and tin alloys, bearings, bushings, shafts, gears, speed reducers, pipes and hardware. In the alcohol, perfumery, sugar, brewing and pharmaceutical industries.



High Manganese/Build-up and Hardfacing Electrodes

	6005 6000	AW CONOMANG High Manganese	5/32" 3/16"	4 4.8	14" 14"	Plastic Cylinder (11 lbs)	Economical and easy to apply on multiple cords without cracking. High mechanical properties. Hardens on impact. Deposit hardness of 90-92 HRB. Use AC/CD PI	In the reconstruction of machinery and crushing mills, in high manganese steels. In the cement, sugar and mining industries.
	6331 6332	AW NIQMANG High Manganese Nickel	1/8" 5/32"	3.2 4	14" 14"	Plastic Cylinder (11 lbs)	Austenitic electrode for joint welding and hardfacing on high manganese, alloyed, stainless steels, etc. It can be used as an intermediate layer for coatings that work with abrasion and high impact. For multi-layer reconstruction. Hardens on impact, easy application. Hardness: 88-90 HRB when deposited. Use CD PI	For joint and facing welding. Stainless type for reconstruction of tractor parts, bulldozers, mechanical shovels. As an intermediate cushion in hard coatings, food process machinery, grain mills, where there is strong impact and moderate abrasion. To join high manganese and high carbon steel sheets.
	6010	AW DURWELD 122-1 Build-up	5/32"	4	14"	Plastic Cylinder (11 lbs)	Easy application and high performance, supports any number of layers without risk of detachment at high impacts. Hardness from 30 to 35 HRC. Use AC/CD PI	In the cement, sugar and mining industries.
	6015 6020 6021	AW DURMATIC H-10 Chrome Carbide	1/8" 5/32" 3/16"	3.2 4 4.8	14" 14" 14"	Plastic Cylinder (11 lbs)	Resistance to high abrasion and medium impact on cast steels and manganese steels. Hardness 54-56 HRC, 3 layers maximum. Use AC/CD PI	Coating of parts of heavy machinery that works in the movement of materials and/or wear caused by friction pressure and subsequent heating. In the cement, mining, sugar and textile industries.
	6334	AW DURWELD 6000 Chrome Carbide	1/8" 5/32"	3.2 4	14" 14"	Plastic Cylinder (11 lbs)	CrMoV type electrode of medium hardness. Useful for coatings that must withstand high abrasion and high impact, such as minerals and sand. Stable arch and easy application. Supports up to three overlapping cords with minimal cracking. Deposit hardness: 44 to 52 HRC. Use CD PI.	For severe abrasion and combined impacts; in buckets, mines, moves earth (such as bulldozers, wings and excavators). In thick cords and as a final coating. In crushers, mills, ore conveyor edges and agricultural machinery.
	6576	AW THERMALLOY 400 Ni-Mo	1/8"	3.2	14"	Plastic Cylinder (11 lbs)	High resistance to impact combined with heat and friction. Deposit hardness of 89-94 HRB. Use AC/CD PI	Coating of machinery parts subjected to impact, friction and pressure stresses. Recommended for rebuilding dies and dies, laminating rollers and cutting blades. In the foundry and steel mills industry.
	6436*	AW MAZABLIN 99 Chrome Carbide	5/32"	4	18"	44 lbs Cylinder (Four (11 lbs) Bags)	It does not require extreme cleaning, provides globular transfer and can be applied to stationary or moving hubs. Hardness up to 53 HRC. Use AC/CD PI.	Shielding of grinding hammer in the sugar industry. It contains elements that form a structure with high resistance to abrasion in humid environments. Adhesion on the teeth providing a rough surface, which allows better rod drag.

High Manganese/Build-up and Hardfacing Electrodes

Image	PN	AWS Classification	Diameter		Size	Package	Characteristics	Applications
			Inch.	mm				
	6114	AW DURWELD 605 Chrome Carbide Tungsten y Vanadium	1/8"	3.2	14"	Plastic Cylinder (11 lbs)	Basic electrode that produces deposits very resistant to high abrasion, heat resistant up to 500°C, work hardness properties also called hot hardness. Hardness 60 – 64 HRC.	It is applied to machine parts such as conveyor worms, crushers, mixers, kneaders, etc. Use with DC PI
	6116		5/32"	4	14"			
	6117		3/16"	4.8	14"			
	6118	AW DUR WELD 3000 Build - up	1/8"	3.2	14"	Plastic Cylinder (11 lbs)	Build Up type electrode, electrodes with good machinability, hardness 31 - 36 HRC.	It is applied in parts that require deposits of medium hardness and resistance to compression, such as pulleys and traveling cranes. Use with DC PI
	6119		5/32"	4	14"			
	6120		3/16"	4.8	14"			

Flux Weld

Image	PN	AWS Classification	Package	Characteristics	Applications
	6360	FLUX WELD 246 Bronze	7 oz. container	For low temperature bronze/copper brazing with oxyfuel equipment. Effective cleaning work to facilitate capillary flow	In the electrical industry, machine tools, crafts, refrigeration and conduction lines.
	6365	FLUX WELD 800 Silver	12.3 oz. container	For low temperature silver brazing with oxyfuel equipment. Effective cleaning work to facilitate capillary flow	In the electrical industry, machine tools, crafts, refrigeration and conduction lines.

Submerged Arc Welding Wire

Código	Nombre comercial	Diámetro		Presentación	Características	Usos y aplicaciones
		Pulg.	mm			
2063*	SAW 8K (EL 8K)	3/32"	2.4	66 lbs. Wire Spool	Wire on spool thread by thread, excellent appearance and high performance	Submerged arc process for structural steels, pipes, storage tanks, EIF 60 and EIA 72 flux is recommended.
2064*		1/8"	3.2			
2066*		5/32"	4.0			
2067*		3/16"	4.8			
2072*	SAW 12K (EM 12K)	3/32"	2.4	66 lbs. Wire Spool	Great versatility, high productivity, shorter downtime, exceptionally clean and high quality wire.	Manufacture of pressure vessels, building structures, bridges, boilers, etc. EIA 72 and EIA 76 flux is recommended.
2073*		1/8"	3.2			
2074*		5/32"	4.0			
2077*		3/16"	4.8			
2087*	SAW 13K (EM 13K)	3/32"	2.4	66 lbs. Wire Spool	Great deoxidizing power and excellent mechanical properties, high productivity in single or multiple steps.	Widely used in structures, bridges, boilers, pressure vessels, railway cars, etc. EIA 72 and EIA 76 flux is recommended.
2094*		1/8"	3.2			
2097*		5/32"	4.0			
2098*		3/16"	4.8			
2100*	SAW 13K (EM 13K)	1/8"	3.2	661 lbs. Wire Bundle		
2158*	SAW 308L (ER 308L)	3/32"	2.4	66 lbs. Wire Spool	Wire on spool thread by thread excellent appearance with balanced levels of Chrome a Nickel allows high deposits to fill in fracture cracks while welding.	Primarily used on steel and steel alloy joints, for the food industry.
2159*		1/8"	3.2			
2160*		5/32"	4.0			
2161*		3/16"	4.8			

Available in a large 661 lbs bundle.

FLUX for Submerged Arc Welding Wire

PN	AWS Classification	Package	Characteristics	Applications
6160*	EIA 72 (F7A2)	55 lbs Bag (plastic inner bag and outer paper pack)	Basic flux with superb mechanical properties and good appearance, high productivity.	Steel structure, bridges, buildings, pipes, and tanks, etc. SAW 8K, SAW 12K y SAW 13K wire.
6161*	EIA 76 (F7A6)	55 lbs Bag (plastic inner bag and outer paper pack)	Basic flux for applications with high mechanical properties improved to impact, high performance and magnificent appearance.	Steel structures with static or dynamic loads, bridges, platforms, heavy machinery, wagons, etc. SAW 12k and SAW 13k wire.
2261*	EIF 72 (F7A2)	55 lbs Bag (plastic inner bag and outer paper pack)	Molten flux that does not require special storage or reconditioning conditions, deposits of good finish, notable mechanical properties.	Metalworking and construction industry, gas tanks, beams, cars, columns, etc., common and commercial carbon steels.

General amperage Chart for coated electrodes

CARBON STEEL	2.4 mm (3/32")	3.2 mm (1/8")	4.0 mm (5/32")	4.8 mm (3/16")
INFRA 10 - S	60 - 80	80 - 120	110 - 160	140 - 190
INFRA 10 - P	N/A	75 - 115	110 - 155	140 - 185
INFRA 11	50 - 85	80 - 125	120 - 165	145 - 190
INFRA 13 VD	55 - 90	85 - 130	125 - 165	150 - 190
INFRA EXCEL ARC	55 - 90	90 - 130	N/A	N/A
INFRA PUNTA NARANJA	55 - 90	85 - 130	125 - 165	N/A
AW ECO WELD 6013	55 - 90	85 - 130	125 - 165	N/A
INFRA 724	N/A	100 - 150	140 - 190	190 - 230
INFRA 718	70 - 100	90 - 140	130 - 170	160 - 200
AW ECO WELD 7018	70 - 100	90 - 140	130 - 170	160 - 200
LOW ALLOY STEEL	2.4 mm (3/32")	3.2 mm (1/8")	4.0 mm (5/32")	4.8 mm (3/16")
INFRA 918-B3	70 - 110	90 - 135	125 - 170	165 - 200
AW 90	N/A	90 - 130	125 - 165	N/A
AW 8018 B2	N/A	90 - 135	125 - 170	N/A
AW 7018 A1	N/A	95 - 145	130 - 170	N/A
AW 8018 D3	N/A	90 - 135	125 - 170	N/A
AW 8018 B6	N/A	95 - 145	130 - 170	N/A
INFRA 7010- P1	60 - 95	80 - 120	115 - 155	140 - 185
STAINLESS STEEL	2.4 mm (3/32")	3.2 mm (1/8")	4.0 mm (5/32")	4.8 mm (3/16")
AW IL	50 - 75	70 - 100	95 - 130	130 - 180
AW IMoL	50 - 80	75 - 105	100 - 135	130 - 165
AW II	60 - 85	80 - 105	95 - 135	130 - 165
AW 880	50 - 75	75 - 105	95 - 130	125 - 160
AW INOX WELD 309	55 - 80	80 - 100	95 - 130	N/A
AW INOX 608	50 - 80	75 - 105	100 - 135	130 - 165
AW INOX 3008	50 - 75	70 - 100	95 - 130	125 - 160
AW INOX 3016	50 - 80	75 - 105	100 - 135	130 - 165
AW INOX 3017 LC	50 - 75	70 - 100	95 - 130	N/A
AW INOX 6053	50 - 80	70 - 105	N/A	N/A
AW INOX 68024 Cb	50 - 75	70 - 100	N/A	N/A
CAST IRON	2.4 mm (3/32")	3.2 mm (1/8")	4.0 mm (5/32")	4.8 mm (3/16")
AW NILOX	70 - 90	85 - 105	110 - 140	N/A
AW FERRONILOX 60	65 - 90	80 - 105	110 - 150	N/A
AW 127	70 - 90	80 - 120	110 - 150	N/A
TOOL ELECTRODE	2.4 mm (3/32")	3.2 mm (1/8")	4.0 mm (5/32")	4.8 mm (3/16")
AW CUT WELD	N/A	150 - 250	200 - 300	220 - 350
ALUMINUN	2.4 mm (3/32")	3.2 mm (1/8")	4.0 mm (5/32")	4.8 mm (3/16")
AW 2201	N/A	70 - 100	90 - 125	N/A
COPPER ALLOY	2.4 mm (3/32")	3.2 mm (1/8")	4.0 mm (5/32")	4.8 mm (3/16")
AW BRONSOMATIC A	N/A	90 - 130	125 - 165	N/A
AW BRONSOMATIC B	N/A	90 - 130	120 - 165	N/A
HARD FACING	2.4 mm (3/32")	3.2 mm (1/8")	4.0 mm (5/32")	4.8 mm (3/16")
AW CONOMANG	N/A	110 - 150	140 - 175	170 - 200
AW DURWELD 122 -1	N/A	N/A	140 - 170	N/A
AW DURMATIC H-10	N/A	100 - 140	130 - 180	170 - 210
AW THERMALLOY 400	N/A	110 - 140	120 - 170	N/A
AW DURWELD 6000	N/A	90 - 140	120 - 160	150 - 200
AW DURWELD 6300	N/A	N/A	140 - 190	160 - 220
AW NIQMANG	N/A	90 - 130	130 - 180	N/A
AW MAZABLIN 99	N/A	120 - 160	150 - 180	N/A
AW DURWELD 7020	N/A	90 - 130	120 - 160	150 - 190
AW DURWELD 7020 A	N/A	100 - 130	120 - 160	150 - 190
AW DURWELD 70200	N/A	90 - 130	120 - 160	145 - 190
AW DURWELD 7100	N/A	100 - 140	130 - 170	160 - 200
AW DURWELD 605	N/A	110 - 150	140 - 190	180 - 230
AW DURWELD 3000	N/A	90 - 130	140 - 180	160 - 210
AW DURWELD 660	N/A	90 - 140	130 - 180	170 - 210
AW DURWELD 6021	N/A	100 - 150	140 - 190	180 - 230
AW DURWELD 601	N/A	100 - 140	130 - 170	N/A
AW DURWELD 6070	N/A	N/A	130 - 170	160 - 200
AW DURWELD 6020	N/A	N/A	140 - 190	180 - 230
AW DURWELD 7180	N/A	140 - 190	190 - 240	N/A
AW DURWELD MEGA 64	N/A	100 - 130	120 - 150	140 - 170

Voltage y amperages for submerged Flux core (FCAW)

Wire Diameter Inch	Amperage	Voltage
0.045"	140 - 160	24 - 27
	160 - 180	25 - 28
	180 - 200	26 - 29
	200 - 220	27 - 30
	220 - 240	27 - 30
1/16"	200 - 240	25 - 28
	240 - 260	25 - 28
	260 - 280	26 - 29
3/32"	300 - 380	26 - 32

Voltage y amperages for wire GMAW

Wire Diameter Inch	Amperage	Voltage
0.023 (0.6)	120 - 140	16 - 22
0.030 (0.8)	120 - 140	16 - 22
0.035 (0.9)	160 - 180	18 - 24
0.045 (1.1)	190 - 220	20 - 26



