

Approximate Parameters for GTAW of Aluminum Alloys for Flat-position Butt Joints, Lap Joints, and Horizontal Fillets

Material Thickness in. (mm)	Electrode Diameter in. (mm)	Electrode Angle*	Electrode Tip Diameter* in. (mm)	Arc Current, Amps	Arc Volts, Volts	Filler Wire Diameter in. (mm)	Travel Speed IPM (mm/sec.)	Cup Diameter in. (mm)	Gas Flow Rate CFM(l/min.)
1/8 (1.6)	1/8 (1.6)	Horiz.	1/8 (1.6)	60-80	15	1/8 (1.6)	10 (4.2)	1/8 (9.5)	20 (9.4)
1/4 (3.2)	1/4 (2.4)	Horiz.	1/4 (2.4)	125-160	15	1/4 (2.4)	10 (4.2)	1/4 (9.5)	20 (9.4)
3/8 (4.8)	1/4 (3.2)	Horiz.	1/4 (3.2)	190-220	15	1/4 (3.2)	10 (4.2)	3/8 (11.1)	20 (9.4)
1/2 (6.4)	1/4 (4.0)	Horiz.	1/4 (4.0)	200-300	15	1/4 (3.2)	10 (4.2)	1/2 (12.7)	25 (11.8)
5/8 (9.5)	1/4 (4.8)	Horiz.	1/4 (4.8)	330-380	15	1/4 (4.8)	8 (3.4)	5/8 (15.9)	25 (11.8)
3/4 (12.7)	1/4 (6.4)	Horiz.	1/4 (6.4)	400-450	25	1/4 (6.4)	8 (3.4)	3/4 (15.9)	25 (11.8)

*See Figure 1.

Notes: Electrodes should be EW2 or EWP used on AC power.

Shielding gas should be argon except for 1/4-inch (12.7-mm) plate, with which a helium/argon mixture can be used for increased penetration.

Filler wire composition should match base metal composition or conform to recommended filler wire for each base material.

Gtaw Amp Chart Guide

CL Gary



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