Nickel Base Alloy MIG•TIG Wire/Rod

Welding Notes

For GMAW (MIG)

1. Using pulse arc transfer mode (the preferred method) for welding, even if the welding current is very low will allow stable arc. Welding polarity : DC+ mainly.

2. Spray arc transfer mode or pulse arc transfer mode requires Ar as shield gas while He is more fitting for short circuit arc transfer mode. The proper shielding gas flow rate is 20~25L/min.

3. Ar-He mixing gas can be also applied to the welding of Nickel base alloy, with the He amount increase, the bead appearance is to get wider, flatter and shallower penetration.

4. Short circuit arc transfer mode is recommended for Ni-Mo or Ni-Cr-Mo alloy; furthermore, adding about 1% O_2 into He-Ar mixing gas can stabilize arc so as to get great weld metal soundness.

5. No preheat necessary and the inter-pass temperature ≦150°C.

6. When applying pulse arc transfer mode, using the suggested lower limited welding current for speedy welding can avoid hot crack occurrence.

For GTAW (TIG)

1. Use Ar, He, or Ar-He mixing gas as shielding gas.

2. Welding polarity: DC– (electrode negative);
   Shielding gas flow rate :10~15 L/min.

3. During one side welding, the backside must be purged by inert gas to prevent oxidization.

4. No preheat necessary and the inter-pass temperature ≦150°C.

5. Proper adjust arc voltage to keep the arc length within 4~6 mm.

6. Use low welding current to prevent hot crack occurrence.

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