

Test Specimen Welding Parameters, Fall 2015

1018 Steel:

<u>Weld Type</u>	<u>Volts</u>	<u>Amps</u>
Butt Low Power	16	30
Butt Normal	20	70
Chamfer	20	70

All welds use:

0.030" diameter E70S solid copper clad wire

75/25 gas (75% Argon/25% Carbon Dioxide)

6061 Aluminum:

<u>Weld Type</u>	<u>Volts</u>	<u>Amps</u>
Butt Low Power	18	204
Butt Normal	23	385
Chamfer	23	385

All welds use:

.035" diameter 4043 solid aluminum wire

100% Argon gas