



Cobalt Welding Wire and Rod

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com

Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925



Basic Guidelines & settings

OXY-FUEL TYPICAL WELDING PROCEDURES; 3X-4X FLAME

Wire Diameter	TIP	Wire Diameter	TIP
1/16 -5/32	4-5	3/16"-1/4"	5-6

TYPICAL GTAW WELDING PROCEDURES; DCEN with EWTh-2 truncated conical tip

Filler Wire Size	Tungsten	Amps	Filler Wire Size	Tungsten	Amps
1/16"	1/16"	45-75	5/32"	5/32"	120-150
3/32"	3/32"	60-90	3/16"	3/16"	150-200
1/8"	1/8"	80-110	1/4"	1/4"	200-250

Argon (cfh) 20-45 with 18-40 volts

TYPICAL WELDING PROCEDURES; DCEP

Wire Diameter	Amps	Volts	Argon (cfh)
0.045	175-220	25-28	35-65
1/16	270-300	26-30	35-65

FLUX CORED TYPICAL GMAW WELDING PROCEDURES; DCEP SHELF SHEILD

Wire Diameter	Stickout	Amps	Volts
1/16	1 - 1 ¼	155-215	24-27
3/32	1 ¼- 1 ½	280-340	24-27

METAL CORED TYPICAL WELDING PROCEDURES; DCEP

Wire Diameter	Stickout	Amps	Volts	CO ₂ & Ar+CO ₂ (cfh)
0.035	½"	65-165	16-27	35-65
0.045	½"	125-260	18-32	35-65
1/16	½"	175-280	20-32	35-65

COATED ELECTRODES TYPICAL WELDING PROCEDURES

Diameter	DC+	AC
1/8"	85-110	90-120
5/32"	120-150	130-160
3/16"	150-180	160-180
1/4"	185-250	220-275

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