



PROFESSIONAL PRODUCTS...  
SUPERIOR RESULTS™

## THE HARRIS PRODUCTS GROUP

# RECOMMENDED WELDING PARAMETERS FOR ALUMINUM SPOOLED WIRES GMAW (MIG)

**Spray Transfer:** Shielding gas Argon is suggested for thicknesses up to 1". For thicknesses over 1", Argon / Helium mixtures should be considered.

Wire Diameter	Welding Current, Amperage	Arc Voltage	Wire Feed Speed, ipm
.025"	85 -180	20 -26	520 -750
.030"	95 -200	22 -28	470 -680
.035"	110 -220	22 - 28	350 -475
3/64"	130 -290	22 -28	235 -375
1/16"	160 -360	24 -30	180 -300

Settings based on Ar shielding gas

All aluminum containers have an identification label showing grade, size, weight and heat number. Conformance certifications can be furnished on request.