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Stainless Steel Welding Parameters

Typical Welding Parameters for Stainless Steel SMAW (Electrodes)				
Diameter of Rod		Voltage (V)	Amperage (A)	
Inches	Millimeters		Flat	Vertical & Overhead
3/32	2.4	24 – 28	70 – 85	65 – 75
1/8	3.2	26 – 30	85 – 110	80 – 90
5/32	4.0	28 – 32	110 – 140	100 – 120
3/16	4.8	28 – 32	120 – 160	110 – 130

Typical Welding Parameters of Stainless Steel TIG, MIG and SAW					
Process	Diameter of Wire		Voltage (V)	Amperage (A)	Shielding Gas
	Inches	Millimeters			
TIG (GTWA)	.035	0.9	12 – 15	60 – 90	100 % Argon
	.045	1.14	13 – 16	80 – 110	
	1/16	1.6	14 – 18	90 – 135	
	3/32	2.4	15 – 20	120 – 175	
	1/8	3.2	15 – 20	150 – 220	
MIG (GMAW)	.035	0.9	26 – 29	150 – 180	99% Argon + 1% Oxygen or 97% Argon + 3% CO ²
	.045	1.14	28 – 32	180 – 220	
	1/16	1.6	29 – 33	200 – 250	
Sub-Arc (SAW)	.035	2.4	28 – 30	275 – 350	Suitable Flux
	.045	3.2	29 – 32	350 – 450	
	5/32	4.0	30 – 33	400 – 550	

Data contained in this publication are typical of the products and properties described, but are not suitable to specifications.