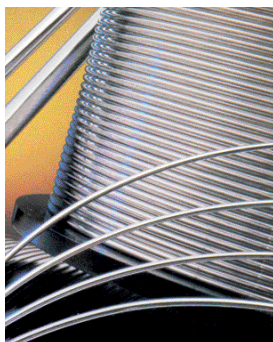


**AWS Spec E4043 ProStar® MIG Wire**

Wire Size (in)	USA			Canada	
	1 lb (.45 kg)	14 lb (6.4 kg)/16 lb (7 kg)	20 lb (9 kg)	1 lb (.45 kg)	20 lb (9 kg)
0.030	PRS404301030243	PRS404315030243 (14 lb)		PRSED702608	PRSED702609
0.035	PRS404301035243	PRS404315035243 (16 lb)		PRSED702610	PRSED702611
3/64	PRS404301047243		PRS404320047243	PRSED702612	PRSED702613
1/16			PRS404320062243		PRSED702614
3/32					PRSED702615

**AWS Spec E5356 ProStar® MIG Wire**

Wire Size (in)	USA			Canada	
	1 lb (.45 kg)	14 lb (6.4 kg)/16 lb (7 kg)	20 lb (9 kg)	1 lb (.45 kg)	20 lb (9 kg)
0.030	PRS535601030243	PRS535615030243 (14 lb)		PRSED702616	PRSED702617
0.035	PRS535601035243	PRS535615035243 (16 lb)		PRSED702618	PRSED702619
3/64	PRS535601047243		PRS535620047243	PRSED702620	PRSED702621
1/16			PRS535620062243		PRSED702622
3/32					PRSED702623



**Typical GMAW Parameters**

Wire Diameter (in)	Suggested Amperage (amp)	Suggested Voltage (volts)	Base Metal Thickness (in)	Wire Speed (ipm)	Consumption 100 ft of weld (lb)	Gas Flow (cfh)
0.030	90	22	0.062	260	1.5	25
0.030	110	23	0.094	320	1.8	25
0.030	130	23	0.125	380	2	25
0.030	150	24	0.187	430	4	25
0.035	90	23	0.062	250	1.5	35
0.035	130	24	0.125	360	2	35
0.035	170	25	0.250	470	6	35
0.047	110	25	0.094	215	1.8	45
0.047	150	26	0.125	290	2	45
0.047	190	26	0.250	370	6	45
0.047	220	27	0.375	430	16	45
0.062	200	26	0.250	190	6	55
0.062	230	27	0.375	215	16	55
0.062	260	28	0.500	240	30	55



**AWS Spec R4043 ProStar® Tig Rod**

Wire Dia.	USA		CANADA
	1 lb	10 lb	10 lb
1/16	PRS404331062243	PRS404336062243	PRSED702631
3/32	PRS404331094243	PRS404336094243	PRSED702633
1/8	PRS404331125243	PRS404336125243	PRSED702632

**AWS Spec R5356 ProStar® Tig Rod**

Wire Dia.	USA		CANADA
	1 lb	10 lb	10 lb
1/16	PRS535631062243	PRS535636062243	PRSED702628
3/32	PRS535631094243	PRS535636094243	PRSED702630
1/8	PRS535631125243	PRS535636125243	PRSED702629

**TIG Welding Parameters for Aluminum Tee Joints**

Metal Thickness (in)	Position	Passes Required	Travel Speed (ipm)	AC Amps (amp)	Cup Diameter (in)	Argon Flowrate (cfh)	Volume used/100 ft weld	Tungsten Diameter (in)	Filler Rod Diameter (in)	lbs. deposited/ 100 ft weld
1/16	Flat	1	8	80	3/8	20	50	1/16	3/32	1/2
1/16	H & V	1	8	80	3/8	20	50	1/16	3/32	1/2
1/16	Overhead	1	8	70	3/8	25	62	1/16	3/32	1/2
1/8	Flat	1	10	150	7/16	20	40	1/8	1/8	2
1/8	H & V	1	8	120	3/8	20	50	3/32	1/8	2
1/8	Overhead	1	8	135	3/8	25	62	3/32	1/8	2
3/16	Flat	1	8	215	1/2	25	62	5/32	5/32	4.5
3/16	H & V	1	8	180	7/16	25	62	1/8	5/32	4.5
3/16	Overhead	1	8	190	7/16	30	75	5/32	5/32	4.5
1/4	Flat	1	8	260	1/2	30	75	3/16	3/16	7
1/4	H & V	1	8	235	1/2	30	75	3/16	3/16	7
1/4	Overhead	1	8	240	1/2	35	87	3/16	3/16	7