

## Aluminum Welding Parameters

Typical Welding Parameters of Aluminum TIG & MIG Wire					
Process	Diameter of Wire		Voltage (V)	Amperage (A)	Shielding Gas
	Inches	Millimeters			
TIG (GTAW)	1/16	1.6		60-100	100% Argon
	3/32	2.4		125-160	
	1/8	3.2		180-240	
MIG (GMAW) Short Circuiting Transfer	.030	0.8	15-18	45-120	100% Argon
	.035	0.9	17-19	50-150	
	3/64	1.2	16-20	60-175	
MIG (GMAW) Spray Transfer	.030	0.8	22-28	90-150	100% Argon
	.035	0.9	22-28	100-175	
	3/64	1.2	22-28	120-210	
	1/16	1.6	24-30	160-300	