

Cobalt Welding Parameters

Typical Welding Parameters of Cobalt SMAW (Electrodes)		
Diameter of Rod		Amperage (A)
Inches	Millimeters	Flat
1/8	3.2	80 - 110
5/32	4.0	120 - 150
3/16	4.8	150 - 180
1/4	6.4	190 - 250

Typical Welding Parameters of Cobalt OAW				
Diameter of Wire		Tip Size	Flame	Position
Inches	Millimeters			
1/8	3.2	4	3X -4X	Flat
5/32	4.0	4	3X -4X	
3/16	4.8	5	3X -4X	
1/4	6.4	6	3X -4X	

Typical Welding Parameters of Cobalt GTAW & GMAW					
Process	Diameter of Wire		Voltage (V)	Amperage (A)	Shielding Gas
	Inches	Millimeters			
TIG (GTAW)	1/8	3.2	20 - 40	90 - 120	100% Argon
	5/32	4.0	20 - 40	120 - 140	
	3/16	4.8	20 - 40	140 - 160	
	1/4	6.4	20 - 40	160 - 180	
GMAW	.045	1.14	25 - 27	180 - 200	100% Argon
	1/16	1.6	26 - 28	280 - 300	