

Shielding Gases for MIG (GMA) and TIG (GTAW) Processes

METALS	ARGON	HELIUM	CO ₂	O ₂	H ₂	N ₂	METHOD		Polarity
							(GTAW)	(GMAW)	
Aluminum Alloys	100							*	DCRP
	100						*		ACHF
		100					*		DCSP
	25	75						*	
Aluminum Bronze	100						*	*	DCSP
Copper	25	75					*	*	DCSP
	100							*	
		100					*		
	95					5			
Magnesium	100							*	DCRP
	100						*		ACHF
Nickel	100						*	*	ACHF
	20	80							DCSP
		100					*A		
Silicon Bronze	100						*	*	ACHF
	100							*	
Steel mild	100						*		DCSP
	75		25					*	DCRP
		100					*A		
			100					*	
	98				2			*	
Low alloy	97				3			*	DCRP
	95				5			*	
	80					20			
	80		20						
Stainless	99				1			*	DCRP
	95				5			*	DCSP
	80					20	*		
	100						*		
		100					*A		
Titanium	100							*	DCSP
	100						*		
		100					*A		
Dissimilar Metals Backup Gas	100						*		DCSP
					5	80			

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