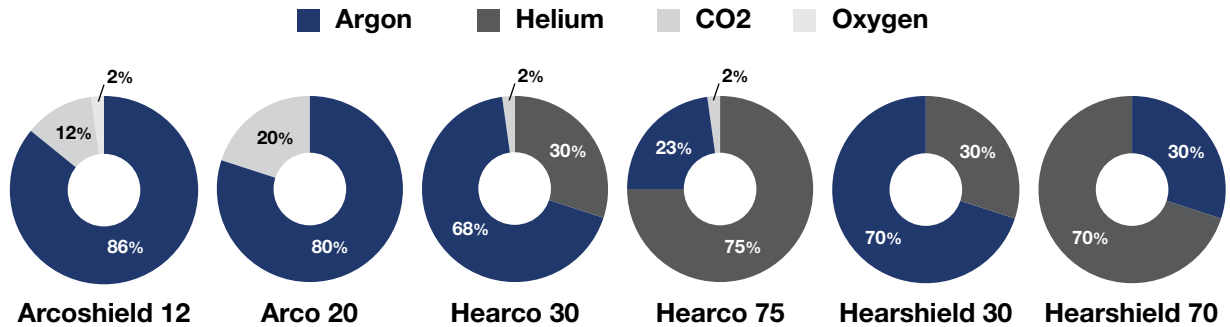


## WELDING GASES - TECHNICAL APPLICATIONS

Some of the standard range is listed below along with their gas composition:

*\*Remember: the higher the CO2 content the greater the penetration, however as CO2 increases so does spatter.*



### Shielding Gases for M.I.G. (Metal Inert Gas) and M.A.G. (Metal Active Gas) Welding

Material	Solid Wires		Flux Cored Wire
	Up to 12mm	Above 12mm	
Carbon Carbon Manganese Low Alloy Steels	<b>Arcoshield 5 / 8 / 12</b> (depending on material thickness)	<b>Arcoshield 20</b>	<b>Arco 20</b>
Stainless Steels	<b>Hearco 75</b> <b>Arco 20</b>	<b>Hearco 30</b> <b>Arco 20</b>	<b>Arco 20</b>
Aluminium	<b>Argon</b> <b>Hearshield 30</b>	<b>Hearshield 75</b> <b>Hearshield 50</b>	<b>N/A</b>

### Shielding Gases for T.I.G. (Tungsten Inert Gas) Welding

Material	Shielding Gas	Purge / Backing Gas
Carbon and Low Alloy Steels	<b>Argon</b> <b>Hearshield 30</b>	<b>Argon</b> <b>Argon</b>
Stainless Steels	<b>Argon</b>	<b>Argon</b>
Aluminium	<b>Argon Hearshield 30 / 75</b> (Thicker Sections)	<b>Argon</b> <b>Argon</b>