RECOMMENDED SHIELDING GASES FOR WASHINGTON ALLOY FILLER METALS

ALUMINUM WIRES & RODS	TIG: 100% Argon, or 75% Ar/25% He MIG: 100% Argon or 75% Ar/25% He (Mechanized welding on heavy plate: 100% He or 75% He/25% Ar)
COPPER BASED WIRES & RODS	100% Argon, 100% Helium or 75% Ar/25% He. Nitrogen may also be used
FLUX-CORED WIRE (mild-steel, stainless steel, buildup and hardsurfacing)	100% CO_2 or 75% AR/25% CO_2
LOW ALLOY/HIGH STRENGTH WIRES	98% Ar/2% O_2 or 75% Ar/25% CO_2
MAGNESIUM WIRES & RODS	100% Argon or 100% Helium or a mixture of the two (i.e., 75% Ar/25% He)
MILD STEEL WIRE	Short Arc for Globular Transfer: 100% CO_2 or 75% Ar/25% CO_2 Spray Transfer: Ar/O_2 (1-10% O_2), Ar/CO_2 (5-15% CO_2), Ar/CO_2/O_2 **92%Ar/8%CO_2**
NICKEL ALLOY WIRES & RODS	100% Argon or 75% Argon/25% Helium
STAINLESS STEEL WIRES & RODS	100% Argon, 98% Ar/2% O_2, 90% He/7.5% Ar/2.5% CO_2,
TITANIUM WIRES & RODS	100% Argon or 100% Helium or mixtures of the two (i.e., 75% Ar/25% He)

CAUTION: Protect yourself and others. Read and understand this label. ELECTRIC SHOCK can kill. FUMES and GASES can be dangerous to your health. ARC RAYS can injure eyes and burn skin.

- Read and understand the Material Safety Data Sheet (MSDS), manufacturer's instruction and your employer's safety practices.
- If MSDS not enclosed, obtain from your employer or your supplier.
- Keep your head out of the fumes.
- Use enough ventilation, or exhaust at the arc end, or both, to keep fumes and gases from your breathing zone and general area.
- Wear correct eye, ear and body protection.
- Do not touch live electrical parts.
- See American National Standard Z49.1 "Safety in Welding and Cutting", published by the American Welding Society, 550 Le Jeune Road, Miami, FL 33126, and OSHA Safety and Health Standard, 29 CFR 1910, available from U.S. Dept. of Labor, Washington, D.C. 20210.