

Shielding Gas Selection

Metal	Process		Polarity	Gas					
	TIG	MIG		Argon	Helium	CO2	O2	H2	N2
Aluminum Alloys		✓	DCRP	100%					
	✓		ACHF	100%					
	✓		DCSP		100%				
		✓		25%	75%				
Aluminum Bronze	✓	✓	DCSP	100%					
Copper	✓	✓	DCSP	25%	75%				
		✓		100%					
	✓				100%				
				95%				5%	
Magnesium		✓	DCRP	100%					
	✓		ACHF	100%					
Nickel	✓	✓	ACHF	100%					
				20%	80%				
	✓		DCSP		100%				
Silicon Bronze	✓	✓	ACHF	100%					
		✓		100%					
Mild Steel	✓		DCSP	100%					
		✓	DCRP	75%		25%			
	✓				100%				
		✓				100%			
		✓		98%			2%		
Low Alloy		✓	DCRP	97%		3%			
		✓		95%		5%			
				80%			20%		
				80%		20%			
Stainless Steel		✓	DCRP	99%			1%		
		✓	DCSP	95%			5%		
	✓			80%			20%		
	✓			100%					
	✓				100%				
Titanium		✓	DCSP	100%					
	✓			100%					
	✓				100%				