Application Guide

POLARITY: Electrode Positive - DCEP/Reverse

AMPERAGE: Tuffband 330 (300 to 380)
           Duraband 320 (300 to 365)

VOLTS: 30 (28 to 33)

GAS MIX: 98% Argon/2% Oxygen (100% Argon, 95/5)

GAS FLOW RATE: 35 CFH (16.5 LPM)
                (32 to 37 15-17.5 LPM)

TORCH

ANGLE: 15° (10° to 17°)

OFFSET: 1” (25mm) (3/4 to 1-1/2” 19-38mm)

STICKOUT: 1” (25mm) (3/4 to 1-1/8” 19-28.5mm)

OSCILLATION

WIDTH: 1” (25mm) (3/4 to 1-1/4” 19-32mm)

SPEED: 80 per minute (60 to 100)

TIE-IN: Use 10-15% Band Overlap

PREHEAT: See Chart on Reverse Side

MAX INTERPASS TEMPERATURE: 850°F (454°C)

SLOW COOLING: Cover immediately with Postle HB Insulator or cooling can

RECOMMENDED ROTATIONAL SPEED:
7 seconds per inch of circumference
Connection OD x 3.14 = Circumference
Circumference x 7 seconds = Rotation Speed (seconds)

Adjust Parameters as Needed to Achieve Best Bead Profile

Black - Recommended
Red - Parameters