

Proportion of gas mixture required for welding of different materials



The ratio of the gas mixture can be configured according to the customer's needs.

The following are the general gas mixture ratios:

Ar is the main component gas

1、 Ar+CO₂ gas mixture: (CO₂ volume percentage 16~28%) The most common is Ar:CO₂=80/20

Applied in carbon steel and low alloy steel.

2、 Ar+H₂ mixed gas: (volume percentage of H₂ is 1~8%)

Applied in nickel-based alloys.

3、 Ar+O₂ gas mixture: (The volume percentage of O₂ is 1~5%)

Applied in carbon steel and low alloy steel

4、 Ar+O₂+CO₂ gas mixture: (volume percentage of O₂ is 3~8%, volume percentage of CO₂ is 5~15%)

Carbon steel and low-alloy steel

5、 Ar+CH₄ gas mixture (volume percentage of CH₄ is 9~12%)

N₂ is the main component gas

6、 N₂ + H₂ gas mixture (volume percentage of H₂ is 5~20%)

