**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%)