

# TIP TIG Weld Parameters BUTT



## **16 Gauge Material .065"**

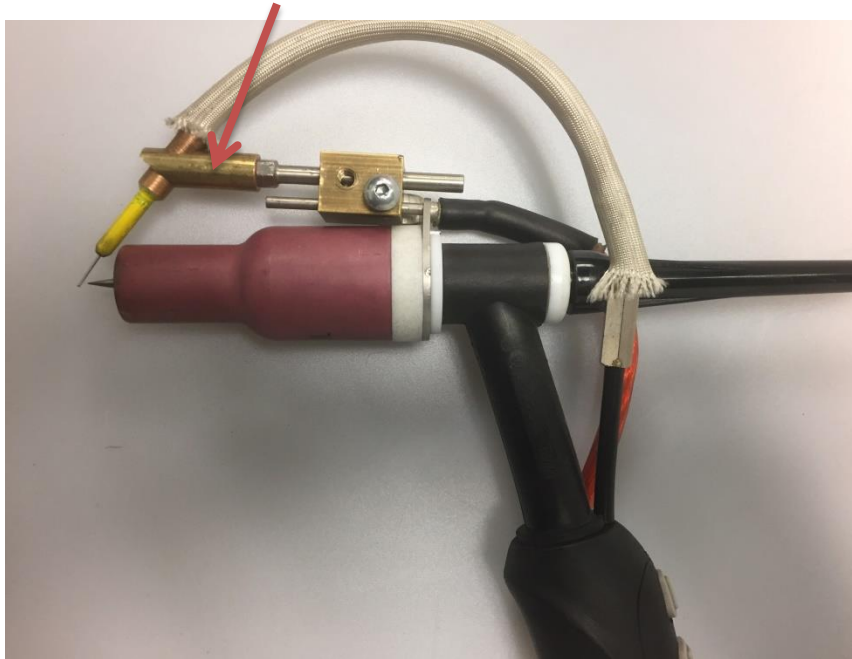
- 70 AMPS Primary
- 60 AMPS HOTWIRE
- 10 Wire Feed Speed
- .030" Filler Material
- 1/8" Tungsten
- 20deg w/ .010 Flat
- .50" Tungsten Stick Out
- #10L BUTT Weld (Red Block)
- Tungsten to wire distance  
2mm

## **18GA Gauge Material .049"**

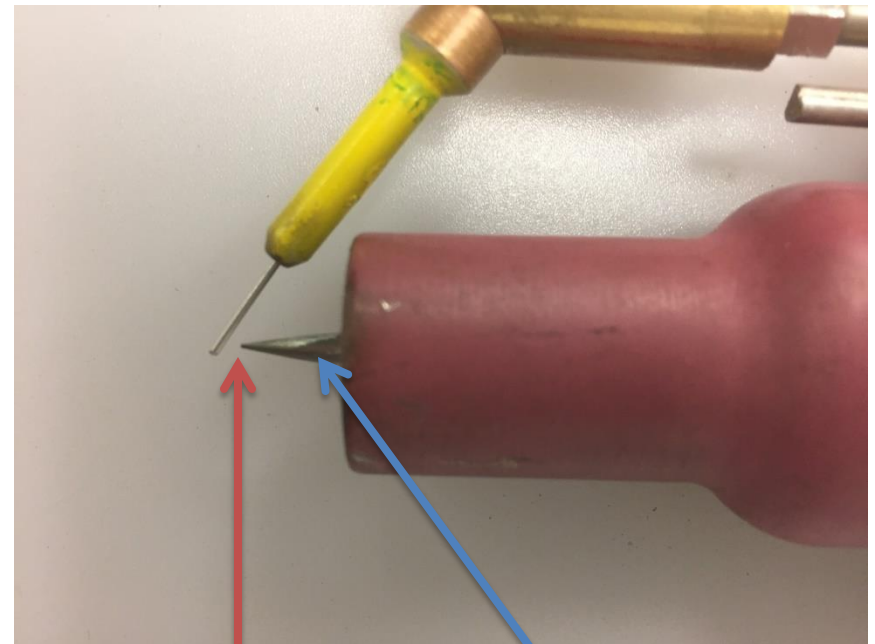
- 60 AMPS Primary
- 60 AMPS HOTWIRE
- 10 Wire Feed Speed
- .030" Filler Material
- 1/8" Tungsten
- 20deg w/ .010 Flat
- .50" Tungsten Stick Out
- #10L BUTT Weld (Red Block)
- Tungsten to wire distance  
2mm

# BUTT WELD CONFIGURATION

**RED 42DEG Block**



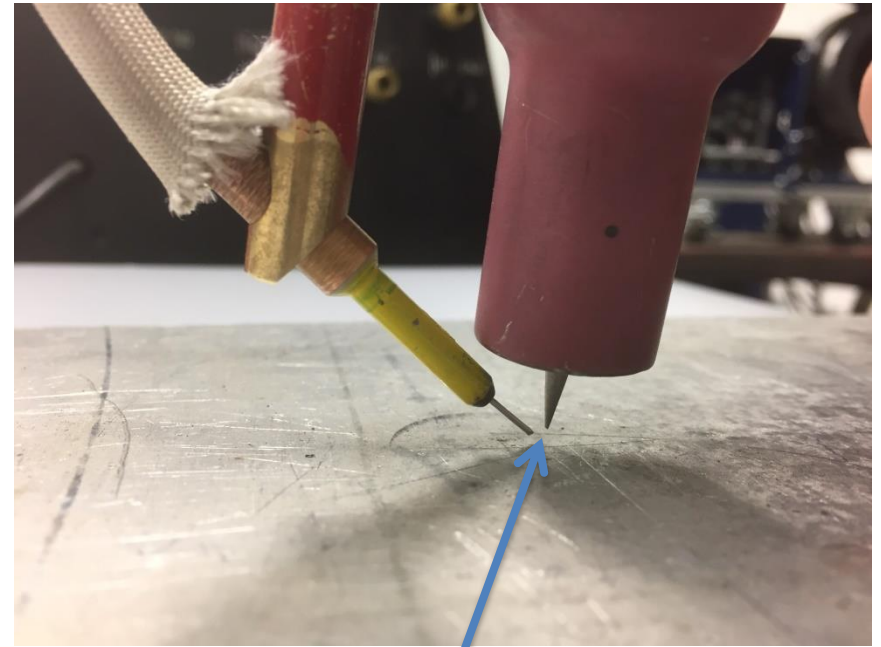
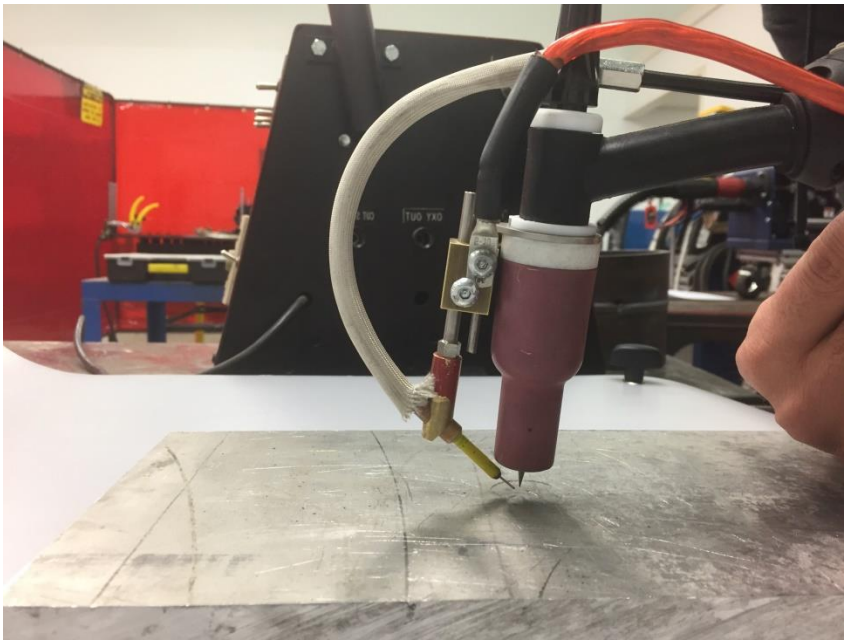
**2mm Tungsten to wire distance**



**Tungsten to wire 2mm**

**1/2" Tungsten Stick out**

# BUTT WELD TORCH POSITION



Tungsten to workpiece 2mm

# TIP TIG Weld Parameters FILLET



## **16 Gauge Material .065"**

- 110 AMPS Primary
- 60 AMPS HOTWIRE
- 20 Wire Feed Speed
- .030" Filler Material
- 1/8" Tungsten
- 20deg w/ .010 Flat
- .75" Tungsten Stick Out
- #8L FILLET Weld (Blue Block)
- Tungsten to wire distance 2mm

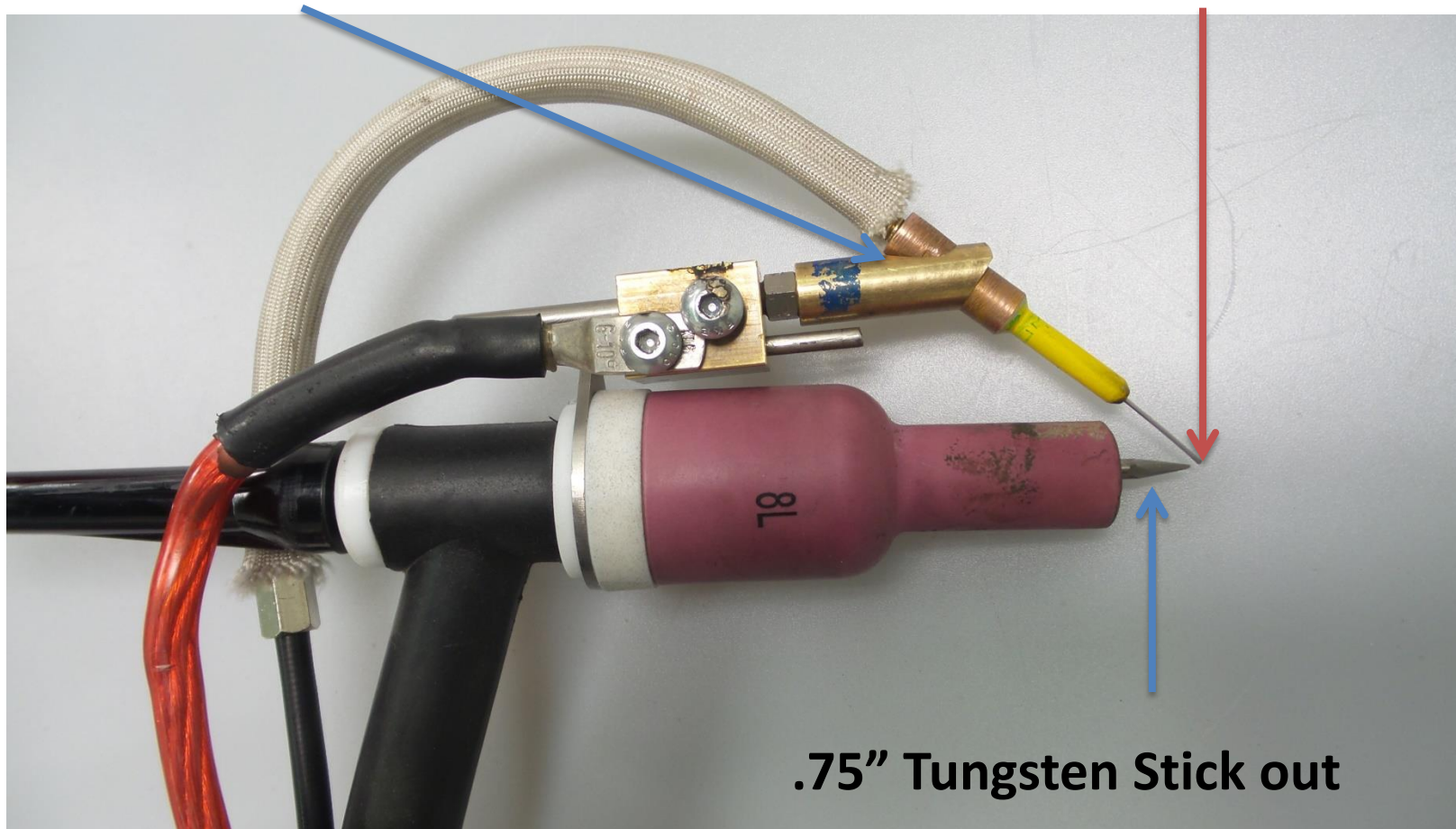
## **18GA Gauge Material .049"**

- 100 AMPS Primary
- 60 AMPS HOTWIRE
- 18 Wire Feed Speed
- .030" Filler Material
- 1/8" Tungsten
- 20deg w/ .010 Flat
- .75" Tungsten Stick Out
- #8L FILLET Weld (Blue Block)
- Tungsten to wire distance 2mm

# FILLET WELD CONFIGURATION

**BLUE 39DEG Block**

**2mm Tungsten to wire distance**



**.75" Tungsten Stick out**



# FILLET WELD TORCH POSITION

TiPTiG | USA  
The Evolution of TIG

