

# NEPTUNE® - MIG

## Gas Metal Arc Welding (GMAW)

For welding aluminum sheets, extrusion, pipe and castings.

### FEATURES

- High Strength 40,000 psi
- Good ductility (elongation 27%)
- May be anodized
- Excellent color match
- Avoids porosity
- Top quality welds
- Economical and easy to use
- Suitable for a wide range of aluminum alloys

### CHARACTERISTICS

**NEPTUNE-MIG** is designed to produce superior results with minimal skill. This product is particularly excellent for ship superstructures, cargo tanks, truck frames and bodies, lights, furniture, molds, window and door frames. It is recommended in all types of structural aluminum fabrication where post heat treatment is not feasible as a method of producing higher strength welded joints.

5

### APPLICATION

**NEPTUNE-MIG** should be used only on pre-cleaned aluminum to produce sound, porosity free welds. Use stainless brush for cleaning. Preheat 400°F (204°C) to 600°F (315°C) for sections over 1/4".

APPROXIMATE SETTINGS: DCEP (reverse polarity)

WIRE DIAMETER	VOLTS	AMPS	GAS FLOW (Ft <sup>3</sup> /Hr)
.030"(0.8mm)	18-23	95-150	40
.035"(0.9mm)	20-24	180-200	40
.047"(1.2mm)	22-28	130-240	60

### SHIELDING GAS OPTIONS:

100% Argon

50% Argon - 50% Helium

75% Argon - 25% Helium