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PRODUCT DATA SHEET

**Welding Shielding Gases
In Australia: Comparison Chart**

Welding

This chart has been compiled by The Welding Technology Institute of Australia (WTIA). The list suggests alternatives, based on information from the companies, technical literature & other sources. The comparisons are not recommendations & should only be used to evaluate the nearest general equivalent. Please contact suppliers directly for further information, & for non-standard mixtures for special applications.

Process			Material				Linde Gas	BOC Gases	Air Liquide	Nominal gas composition in Argon (Vol. %)				
GMAW (MIG)	GTAW (TIG)	FCAW	Carbon Steel	Stainless Steel	Aluminium	Copper Alloys	Duplex Stainless			CO ₂	O ₂	H ₂	He	N ₂
*	*	*	*						Specshield 265JMA	3				
*	*	*	*						Specshield 265FE	5				
*	*	*	*							8				
*	*	*	*						Corgon 10	10				
*	*	*	*						Specshield 265GM	14				
*	*	*	*						Specshield 265ASC	18				
*	*	*	*						Argoshield 52	23				
*	*	*	*						Corgon 25	25				
*	*	*	*						Corgon 16/2	16	2			
*	*	*	*							16	2.5			
*	*	*	*						Argoshield Universal(51)	16	2.75			
*	*	*	*						Argoshield Heavy	18	3			
*	*	*	*							8	2			
*	*	*	*						Argoshield 54	7	1.5			
*	*	*	*							4.5	2.5			
*	*	*	*						Corgon 5i2	5	2			
*	*	*	*							3	1			
*	*	*	*						Argoshield Light (50)	5	3.1			
*	*	*	*						Argoshield 100	10			25	
*	*	*	*							15			10	
*	*	*	*						Corgon He30	10			30	
*	*	*	*						Corgon 07		7			
*	*	*	*						Argoshield 40	5				
*	*	*	*						Specshield Copper(70)	0.7				
*	*	*	*						Cronigon 1	1				
*	*	*	*						Stainshield (60)	1.5				
*	*	*	*						Cronigon 2	2				
*	*	*	*						Stainshield 66	2.8		1		
*	*	*	*						Specshield CS	4		1	30	
*	*	*	*							3		1	30	
*	*	*	*						Stainshield Heavy (62)	2.8				35
*	*	*	*						Cronigon He35	5				35
*	*	*	*						Stainshield 69		0.9			35
*	*	*	*						Cronigon He35-0		1			35
*	*	*	*						Specshield 265WIT	2				20
*	*	*	*						Cronigon He20	2.5				20
*	*	*	*						Cronigon He50	2				50
*	*	*	*										10	2
*	*	*	*							1.8			5	1.7
*	*	*	*						Crontig					3
*	*	*	*						Crontig N5					5
*	*	*	*						Varigon He25					25
*	*	*	*											27
*	*	*	*						Alushield Light (80T)					49
*	*	*	*											50
*	*	*	*						Varigon He50					75
*	*	*	*						Varigon He75					75
*	*	*	*						Alushield Heavy (81T)					75
*	*	*	*						Specshield 90T			4		33
*	*	*	*						Specshield 71T			1.5		11
*	*	*	*						Varigon H5			5		
*	*	*	*						Argoplas 5			5		
*	*	*	*						Varigon H10			10		