



PROFESSIONAL PRODUCTS...
SUPERIOR RESULTS™

THE HARRIS PRODUCTS GROUP
RECOMMENDED WELDING PARAMETERS FOR
COPPER WELDING ALLOYS GMAW (MIG)

Alloy	Wire Size	Welding Current, (Amps)	Arc Voltage	Wire Feed Speed
Aluminum Bronze A2	.035"	130 - 200	30	280 - 400
	.045"	185 - 245	30	200 - 300
	1/16"	250 - 400	40	150 - 210
Deoxidized Copper	.035"	145 - 185	30	400 - 440
	.045"	195 - 215	30	280 - 310
	1/16"	260 - 280	40	150 - 210
Phos Bronze	.030"	130 - 140	25	340 - 450
	.035"	140 - 160	30	280 - 400
	.045"	165 - 185	30	200 - 300
Silicon Bronze	1/16"	285 - 335	40	150 - 210
	.030"	130 - 150	25	460 - 500
	.035"	145 - 185	30	400 - 440
Silicon Bronze	.045"	195 - 215	30	280 - 310
	1/16"	260 - 280	40	150 - 210