

Weld Coupon Kit

Steel Set-Up Sheet

Recommended Weld Set Up	
Material	Low Carbon Steel (1018 or equivalent)
Metal Thickness	11 Gauge (.120", 3mm)
Weld Current	DCEN, 80-100 Amps
Gas Flow Rate	10-12 CFH Argon
Electrode Point	20 Degrees

Weld Coupon Kit Bill-Of-Material		
Qty	Description	Re-Order at Arc-Zone.com
6	3" X 3" Steel Weld Coupons	AZP-BT-Q235
1	3/32" (2.4mm) Double End Ground Tungsten Electrode	9-1775-D
3	12" ER70S2 1/16" (1.6 mm) Steel Filler Rods	ER70S2-116-36-1
1	TIG Cleaning Wire Brush	BW-189
1	Holding Magnets	AZP-BT-003074
1	Package EZ Wipes	AQS-EZW-ONE

Recommended Procedure

1. Clean weld area with wire brush.
2. Clean weld area with EZ Wipes.
3. Use weld magnets to align weld coupons (at 90 degrees, if preferred).
4. Install tungsten electrode supplied in kit.
5. Tack coupons at corners using the filler rod provided.
6. Complete weld.
7. Clean weld with wire brush.

Safety Data Sheets

- 3/32" (2.4mm) Double End Ground Tungsten Electrode



- 12" ER70S2 1/16" (1.6 mm) Steel Filler Rods

