

Shielding Gases for MIG (GMA)

METALS	ARGON	HELIUM	CO ₂	O ₂	Polarity
					DCRP
Aluminum Alloys	100				DCRP
	25	75			
Aluminum Bronze	100				DCSP
Copper	25	75			
	100				DCSP
Magnesium	100				DCRP
Nickel	100				ACHF
Silicon Bronze	100				ACHF
	100				
Steel	75		25		DCRP
			100		
	98			2	
Low alloy	97			3	DCRP
	95			5	
Stainless	99			1	DCRP
	95			5	
Titanium	100				DCSP