

2% THORIATED Tungsten Electrodes

Gas Tungsten Arc Welding (GTAW)



Standards

AWS A5.12/ASME SFA 5.12, Class EWTH-2

Description & Applications

A popular electrode for GTAW containing a nominal 2% thorium oxide. Typical applications include welding carbon and stainless steels as well as copper and nickel alloys.

The BLUESHIELD™ Advantage

- Ground finished to ensure smoothness and consistency.
- Good arc stability.
- Maintains sharpened tip configuration.
- Highly resistant to weld pool contamination.
- Color coded red according to AWS electrode identification requirements for tungsten electrodes.

Typical Welding Parameters



- Difficult to maintain balled end when using on AC.
- Refer to **Typical Current Ranges for Tungsten Electrodes**.

Recommended Shielding Gases

100% Argon, Argon-Helium, ALTIG™, ARCAL™ He25 (BLUESHIELD™ 1), ARCAL™ He50 (BLUESHIELD™ 2) and ARCAL™ He75 (BLUESHIELD™ 3) mixtures are recommended.

Typical Chemistry

Fe	Ni	Al	Ca	Mg	O	Si	N	C	ThO ₂	W
0.003	0.003	0.002	0.002	0.002	0.002	0.003	0.003	0.003	2.02	98.00%

Packaging

DIAMETER		PACKAGING		ITEM NUMBER
mm	in			
1.0	0.040	10 electrodes	Box	A0403395
1.6	1/16			A0403396
2.4	3/32			A0403397
3.2	1/8			A0403398
4.0	5/32			A0403399