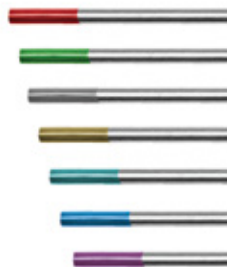


▼ 6.10. Tungsten electrodes and electrode grinders



MOST tungsten electrodes for TIG welding



Electrode sharpening angle (according to Lorch instructions)	
Welding current (DC)	The angle of the electrode
20 A	30°
20-100 A	60°-90°
100-200 A	90°-120°
>200 A	120°

Recommended current (according to Lorch instructions)		
Electrode diam.	DC	AC
1,0 mm	3-40 A	5-30 A**
1,6 mm	15-130 A	20-90 A**
2,0 mm	45-180 A	45-135 A**
2,4 mm	70-240 A	70-180 A**
3,2 mm	140-320 A	130-250 A**
4,0 mm	220-450 A	200-320 A**

***) Depending on the type of electrode and AC balance parameter settings

Name and symbol	A distinctive color	Type of work	Diameters at length L=175 mm	Catalogue No.	Remarks
Thorium 2% WT20	red	DC	Ø1,0 mm	50 19 921017	Slightly radioactive
			Ø1,6 mm	50 19 921617	
			Ø2,0 mm	50 19 922017	
			Ø2,4 mm	50 19 922417	
			Ø3,0 mm	50 19 923017	
			Ø3,2 mm	50 19 923217	
From pure tungsten WP	green	AC	Ø1,0 mm	50 19 931017	Welding of aluminium and its alloys
			Ø1,6 mm	50 19 931617	
			Ø2,0 mm	50 19 932017	
			Ø2,4 mm	50 19 932417	
			Ø3,0 mm	50 19 933017	
			Ø3,2 mm	50 19 933217	
Cerium WC20	grey	AC/DC	Ø1,0 mm	50 19 971017	Universal, long service life and load capacity
			Ø1,6 mm	50 19 971617	
			Ø2,0 mm	50 19 972017	
			Ø2,4 mm	50 19 972417	
			Ø3,0 mm	50 19 973017	
			Ø3,2 mm	50 19 973217	
WL15 lanthanum	gold	AC/DC	Ø1,0 mm	50 19 941017	Universal, very good arc ignition properties
			Ø1,6 mm	50 19 941617	
			Ø2,0 mm	50 19 942017	
			Ø2,4 mm	50 19 942417	
			Ø3,0 mm	50 19 943017	
			Ø3,2 mm	50 19 943217	
With the addition of Multi-Strike rare earths	turquoise	AC/DC	Ø1,0 mm	50 19 951017	The best properties when welding steel and aluminium
			Ø1,6 mm	50 19 951617	
			Ø2,4 mm	50 19 952417	
			Ø3,2 mm	50 19 953217	
			Ø4,0 mm	50 19 954017	
			With the addition of WS20 rare earths	blue	
Ø1,6 mm	50 19 975016				
Ø2,0 mm	50 19 975020				
Ø2,4 mm	50 19 975024				
Ø3,0 mm	50 19 975030				
Ø3,2 mm	50 19 975032				
With the addition of WE3 rare earths	violet	AC/DC	Ø1,6 mm	50 19 976016	Universal, long life WT20 replacement suggested
			Ø2,0 mm	50 19 976020	
			Ø2,4 mm	50 19 976024	
			Ø3,2 mm	50 19 976032	

AC-alternating current / aluminium welding

DC-direct current / welding of carbon and stainless steels