Praxair's Mig Mix Gold™ – Argon/Carbon Dioxide Blend for All Forms of GMAW (MIG/MAG Welding) of Carbon Steel

Praxair's Mig Mix Gold™ is a precise blend of argon and carbon dioxide for high productivity mild steel welding. It is designed to provide fast, clean, high quality welds over a wide range of applications.

It offers significant improvements over many other general purpose MIG shielding gases because of its lower, controlled oxidation potential. Bead shape and puddle control are excellent; spatter and fume levels are reduced also. Mechanical properties meet or exceed normal requirements for the weld metal.

Product Features	Benefits
• Controlled CO_2 content.	• Reduced spatter; less wasted welding wire. • Improved wire deposition efficiency. • Better weld appearance.
• Produces good wetting characteristics.	• Controlled bead shape. • Less overwelding – reduced consumables costs. • Higher productivity – higher welding speeds.
• Low oxidizing potential.	• Reduced fume levels. • Improved operator environment. • Reduced air handling costs.
• Broad operating range.	• Can be used in all welding positions with all types of metal transfer. • Bridges gaps well. • Reduced distortion and burn-through on thin material. • Suitable for use with low fume flux and metal-cored wires.

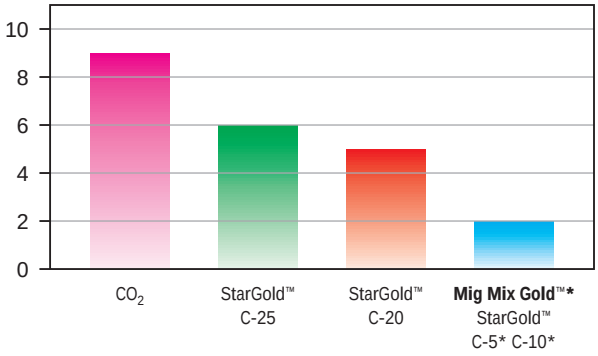
Typical Applications

- Structural steels (spray arc) for heavy equipment.
- Sheet metal fabrication (short arc) for appliances.
- Pulsed welding of 3/8" plate; farm implements.
- Rail car fabrication with metal-cored wire.
- Truck and trailer manufacturing.

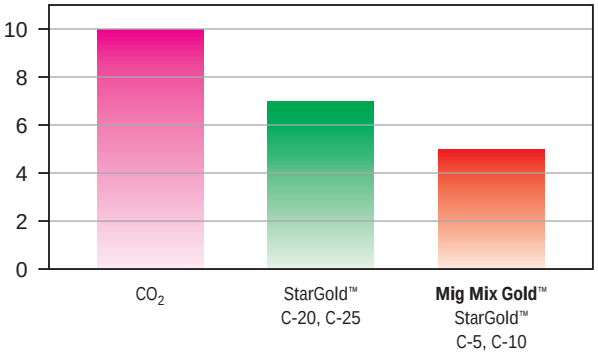
Performance Characteristics

Illustrated below are comparisons between shielding gas blends used with ER70S-3 and ER70S-6 solid wire electrodes over a range of current levels. They are intended to provide suggestions for gas blend selection based on the criteria indicated.

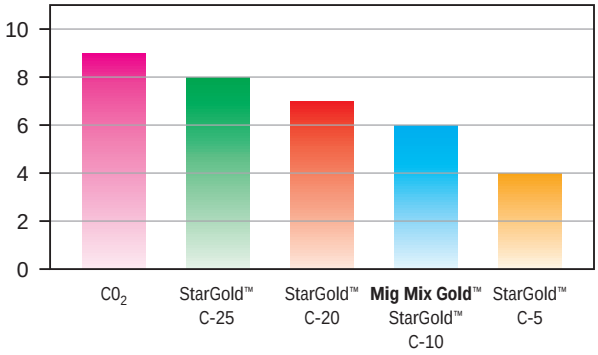
Spatter (10 = most, 1 = least) * Spray arc transfer



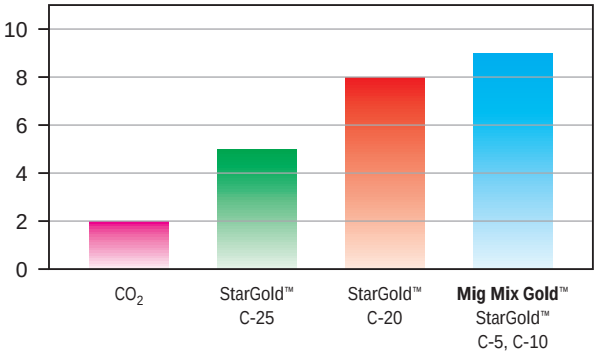
Fume (10 = most, 1 = least)



Penetration (10 = most, 1 = least)



Travel Speed (10 = most, 1 = least)



Note: The selection of the appropriate shielding gas can become quite complex due to the large variety of operating conditions (base metal, chemistry and thickness, metal transfer, wire selection, welding position, etc). Please consult with your Praxair representative for the best option available for your application.

Welding Conditions Selection Table

Wire diameter (inches)	Wire feed speed (ipm)	Current level (amps)	Voltage (volts)*
0.035 (1.0 mm)	150-280	100-175 (short arc)	16-20
0.035 (1.0 mm)	350-550	190-210 (spray)	26-28
0.045 (1.2 mm)	300-500	260-320 (spray)	27-31
0.063 (1.6 mm)	150-300	250-400 (spray)	30-33

* Voltage level for 60 Hz power supply. With 50 Hz, add 3 volts.

Praxair, Inc.
39 Old Ridgebury Road
Danbury, CT 06810-5113
Tel: 1-800-PRAXAIR
Fax: 1-800-772-9985
Internet: www.praxair.com
e-mail: info@praxair.com

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