

Neptune[®] MIG

Gas Metal Arc Welding (GMAW – Wire)

For welding aluminum sheets, extrusion, pipe and castings.

Features

- High Strength 40,000 psi
- Good Ductility (elongation 27%)
- May Be Anodized
- Excellent Color Match
- Avoids Porosity
- Top Quality Welds
- Economical and Easy To Use
- Suitable For A Wide Range Of Aluminum Alloys

Characteristics

Neptune MIG is designed to produce superior results with minimal skill. This product is particularly excellent for ship superstructures, cargo tanks, truck frames and bodies, lights, furniture, molds, window and door frames. It is recommended in all types of structural aluminum fabrication where post heat treatment is not feasible as a method of producing higher strength welded joints.

Technical

Inches	.030	.035	.047
(mm)	(0.8)	(0.9)	(1.2)
Volts	18-23	20-24	22-28
Amps	95-150	180-200	130-240
Gas Flow (ft ³ /hr)	40	40	60

Use Reverse Polarity (DCEP)

Spool Size

- 1# Available in .030, .035 and .047
- 5# Available in .030 and .035
- 16# Available in .035 and .047

Application

Neptune MIG should be used only on pre-cleaned aluminum to produce sound, porosity free welds.

- Use stainless brush for cleaning.
- Preheat 400°F (204°C) to 600°F (315°C) for sections over 1/4".
- We recommend **Gemini Anti-Spatter spray** for lasting protection of your contact tip and MIG nozzle (see chemical aids in Abrasives & Metal Working products section).

Shielding Gas Options

- 100% Argon
- 50% Argon – 50% Helium
- 75% Argon – 25% Helium