

# ARCAL™ Shielding Gases

## Reference Tier

Class	Components	Application	Replacement Information	Size	
				49	49 x 16
ARCAL 1	Ar	Nonferrous GMAW/GTAW on most materials; back purge		•	•
ARCAL 9	Ar, CO <sub>2</sub> , He	Short-circuit on stainless steel		•	•
ARCAL 12	Ar, CO <sub>2</sub>	Short-circuit/spray GMAW on carbon and stainless steel		•	•
ARCAL 21	Ar, CO <sub>2</sub>	Short-circuit and spray ferrous GMAW, MCAW		•	•
ARCAL 25	Ar, CO <sub>2</sub>	Short-circuit GMAW on carbon steel; FCAW on carbon and stainless steel		•	•

## Premium Tier

Class	Components	Application	Replacement Information	Size	
				49	49 x 16
ARCAL 10	Ar, H <sub>2</sub>	GTAW on 300 Stainless Steel		•	
ARCAL 11	Ar, He, N <sub>2</sub>	GTAW on stainless steel		•	
ARCAL 14	Ar, CO <sub>2</sub> , O <sub>2</sub>	Short-circuit and spray on carbon and low alloy steel	Standard Ar in CO <sub>2</sub> ; Ar in O <sub>2</sub> and Ar, CO <sub>2</sub> , O <sub>2</sub> mixtures	•	•
ARCAL 15	Ar, H <sub>2</sub>	GTAW on 300 Stainless Steel		•	
ARCAL 39	Ar, He, N <sub>2</sub>	GTAW on duplex/super duplex stainless steel	The choice for GTAW (TIG) welding of duplex materials	•	
ARCAL 121	Ar, CO <sub>2</sub> , He	Short-circuit, pulsed and spray GMAW on stainless steel and nickel-based alloy; preferred composition	Standard O <sub>2</sub> in Ar and Ar, CO <sub>2</sub> , He mixtures	•	•
ARCAL 129	Ar, CO <sub>2</sub> , He, N <sub>2</sub>	GMAW on duplex/super duplex stainless steel	The choice for GMAW (MIG) welding of duplex materials	•	
ARCAL 211	Ar, CO <sub>2</sub> , He	FCAW on carbon and stainless steel	The ideal clean alternative to standard CO <sub>2</sub> and Ar in CO <sub>2</sub> mixtures	•	•
ARCAL 301	Ar, N <sub>2</sub>	GTAW and GMAW spray and pulsed spray on aluminum and copper	Standard Ar in He for aluminum and copper	•	•
ARCAL 331	Ar, He, N <sub>2</sub>	GTAW and GMAW spray and pulsed spray on aluminum and copper	Standard Ar in He for aluminum and copper	•	