

CIGWELD

AN ESAB BRAND

TUNGSTEN ELECTRODES

Conform to AWS A5.12 | ISO 6848

TIG WELDING



TUNGSTENS FOR ANY TIG WELDING APPLICATION !

CIGWELD's Tungsten Electrodes are essential for TIG welding, offering exceptional durability due to the tungsten's extremely high melting point of approximately 3400°C. This allows the electrode to sustain a stable electric arc between the workpiece and the electrode without rapid wear. Various types of tungsten electrodes are available, each tailored to specific welding applications. For guidance on selecting the right electrode, refer to the AWS A5.12 and ISO 6848 standards, which provide detailed information on CIGWELD's tungsten electrode offerings.

TUNGSTEN ELECTRODE SELECTION GUIDE

CLASSIFICATION	SIZE	CURRENT SUITABILITY	COMPOSITIONS	WELDABLE MATERIALS
2% THORIATED				
WT20 EWTh-2 Provides excellent arc starting, stability, and current capacity.	1.6mm X 175mm 2.4mm X 175mm 3.2mm X 175mm	DC	97.7%~98.2% W 1.7%~2.2% ThO ₂ ≤ 0.1% Others	Mild & Carbon Steel, Stainless Steel, Nickel, Titanium and Copper Alloys.
1.5% LANTHANATED				
WL15 EWLa-1.5 Provides excellent arc starting and stability, similar to Thoriated electrodes.	1.6mm X 175mm 2.4mm X 175mm 3.2mm X 175mm	AC/DC	98.1%~98.5% W 1.3%~1.7% La ₂ O ₃ ≤ 0.2% Others	Aluminum, Copper Alloys, Nickel, Stainless Steel, Mild & Carbon Steel and Titanium
3% RARE EARTH				
WG EWG Excellent arc stability, low wear rate, and superior arc starting, even at lower amperages.	1.6mm X 175mm/150mm 2.4mm X 175mm/150mm 3.2mm X 175mm	AC/DC	97.7%~98.1 W 1.8~2.2% La ₂ O ₃ + Y ₂ O ₃ +WZrO ₂ ≤ 0.1% Others	Aluminum, Copper Alloys, Nickel, Stainless Steel, Mild & Carbon Steel and Titanium
0.8% ZIRCONIATED				
(WZ EWZr-0.8) Excellent arc stability and resistance to contamination.	1.6mm X 175mm/150mm 2.4mm X 175mm/150mm 3.2mm X 175mm	AC	98.9%~99.1% W 0.7~0.9% ZrO ₂ ≤ 0.2% Others	Aluminium and Magnesium Alloys

2% THORIATED TUNGSTEN ELECTRODES



FEATURES:

- Suitable for DC TIG welding.
- Commonly used with materials like Carbon Steel, Stainless Steel, Titanium, Nickel and Copper Alloys.
- Superior DC arc starts and stability, balanced erosion rate.
- Excellent low amperage stability for care on thin materials.
- Clean snap for a safe split.



	THORIATED: 10 Pack 1.6mm x 175mm P/N: TUN16THR
	THORIATED: 10 Pack 2.4mm x 175mm P/N: TUN24THR
	THORIATED: 10 Pack 3.2mm x 175mm P/N: TUN32THR

1.5% LANTHANATED TUNGSTEN ELECTRODES



FEATURES:

- Suitable for AC and DC TIG welding.
- Work exceptionally well with Carbon Steel, Stainless Steel, Titanium, Nickel, Aluminium and Copper Alloys, providing smooth arc starts and excellent arc stability.
- Good ball forming when used for AC-TIG welding on Aluminium and Aluminium Alloys.



	LANTHANATED: 10 Pack 1.6mm x 175mm P/N: TUN16LAN
	LANTHANATED: 10 Pack 2.4mm x 175mm P/N: TUN24LAN
	LANTHANATED: 10 Pack 3.2mm x 175mm P/N: TUN32LAN



CIGWELD Data Sheet
TUNGSTEN ELECTRODES PDS V2-2025
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FEATURES:

- Suitable for AC and DC TIG welding.
- Excellent ignition characteristics and consistent welding properties.
- Holds sharp needle points longer between re-sharpening, compared to Thoriated Tungstens.
- Due to their great ignition characteristics and consistent welding properties, they are well suited for Automated welding applications.
- Made from Lanthanum, Zirconium and Yttrium in a specific chemical analysis to provide cooler welding temperatures at the tungsten tip.
- Non-Radioactive to improve health and safety for operator and environment.



RARE EARTH: 10 Pack
1.6mm x 175mm
P/N: TUN16RE3



RARE EARTH: 10 Pack
2.4mm x 175mm
P/N: TUN24RE3



RARE EARTH: 10 Pack
3.2mm x 175mm
P/N: TUN32RE3



RARE EARTH: 2 Pack
1.6mm x 150mm
P/N: 699859



RARE EARTH 2 Pack
2.4mm x 150mm
P/N: 699860



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0.8% ZIRCONIATED TUNGSTEN ELECTRODES



FEATURES:

- Suitable for AC TIG welding applications.
- Suitable for Aluminium and Magnesium Alloys.
- Retains a balled tip with high resistance to contamination.
- White tipped Zirconiated Tungsten's have the best ball forming characteristics of all welding tungsten's, so they're especially suited to holding a steady arc when welding with AC-Current High Frequency which facilitates the break-up of the Aluminium Oxide layer, which is a critical factor for AC-TIG welding.
- **NOT FOR USE ON DC CURRENT**



ZIRCONIATED: 10 Pack
1.6mm x 175mm
P/N: TUN16ZIR



ZIRCONIATED: 10 Pack
2.4mm x 175mm
P/N: TUN24ZIR



ZIRCONIATED: 10 Pack
3.2mm x 175mm
P/N: TUN32ZIR



ZIRCONIATED: 2 Pack
1.6mm x 150mm
P/N: 699864



ZIRCONIATED: 2 Pack
2.4mm x 150mm
P/N: 699865



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