

Group	Designation		Constituents in percent volume					Procedure	Remarks		
	Code	Mixture (data-sheet)	Oxidizing		Inert		Reducing			Un-reactive	
			CO ₂	O ₂	Ar	He	H ₂			N ₂	
R	1	-			Bal.		>0-15		TIG, root shielding, plasma cutting	reducing	
	2	-			Bal.		>15-35				
I	1	Pure Ar			100				MIG, TIG, root shielding	inert	
	2	-				100					
	3	ArHe			Bal.	>0-95					
M1	1	ArCO ₂	>0-5		Bal.		>0-5		MAG	Slightly oxidizing	
	2	ArCO ₂	>0-5		Bal.						
	3	ArCO ₂ O ₂		>0-3	Bal.						
	4	ArCO ₂ O ₂	>0-5	>0-3	Bal.						
M2	1	ArCO ₂	>5-25		Bal.						
	2	ArO ₂		>3-10	Bal.						
	3	ArCO ₂ O ₂	>0-5	>3-10	Bal.						
	4	ArCO ₂ O ₂	>5-25	>0-8	Bal.						
M3	1	ArCO ₂ O ₂	>25-50	>10-15	Bal.						
	2	Pure Ar			Bal.						
	3	ArCO ₂ O ₂	>5-50	>8-15	Bal.						
C	1	CO ₂	100							Strongly oxidizing	
	2	CO ₂ O ₂	Bal.	>0-30							
F	1							100	Plasma cutting, root shielding	Unreactive reducing	
	2						>0-50	Bal.			

Note: Argon (Ar) may be substituted by Helium (He) up to 95% - the He percentage is indicated by an extra digit.