

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.					Strongly oxidizing
	2	Pure Ar			Bal.					
	3	ArCO ₂ O ₂	>5-50	>8-15	Bal.					
C	1	CO ₂	100							
	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.