





























Typical Applications	Description/How to Identify	Plastic Symbol	Welding Rod Profiles			Suggested Temperature Settings *
Bumper covers, headlight housings, inner fender liners, splash shields, fan shrouds, gas tanks, underhood parts, interior parts, snow-mobile cowls	Usually black, sometimes gray; semi-flexible. 98% of late-model bumper covers are made of PP. Slightly waxy appearance.	PP, TPO, TEO, PP/EPDM, PP + EP, TSOP (polypropylene)		R02-01 (PP)	1/8" dia 3 mm	Digital Welder <b>60</b>  Analog Welder <b>5</b>
				R02-02 (PP)	3/16" dia 4.7 mm	
				R02-03 (PP)	3/8" x 0.05" 9.5 x 1.2 mm	
				R02-04 (PP)	3/8" x 1/16" 9.5 x 1.6 mm	
				R02-05 (PP)	5/8" x 1/16" 15.8 x 1.6 mm	
				R02-06 (PP)	1/2" x 3/32" 12.7 x 2.4 mm	
				R02-07 (PP)	13/64" x 1/16" 5.2 x 1.6 mm	
				R02-08 (PP)	1/4" x 1/16" 6 x 1.6 mm	
				R05-01 (TPO)	1/8" dia 3 mm	
				R05-04 (TPO)	3/8" x 1/16" 9.5 x 1.6 mm	
				R05-05 (TPO)	5/8" x 1/16" 15.8 x 1.6 mm	
			Windshield washer bottles, radiator overflow bottles, inner fender liners, ATV fenders, RV water storage tanks, gas tanks, kayaks, canoes, trash cans	Usually translucent white (natural), but often molded in color. Waxy in appearance, semi-flexible. Never painted.	PE, LDPE, HDPE (polyethylene)	
	R04-02 (LDPE)	3/16" dia 4.7 mm				
	R04-04 (LDPE)	3/8" x 1/16" 9.5 x 1.6 mm				
	R12-01 (HDPE)	1/8" dia 3 mm				
	R12-04 (HDPE)	3/8" x 1/16" 9.5 x 1.6 mm				
	R12-05 (HDPE)	5/8" x 1/16" 15.8 x 1.6 mm				
Grilles, instrument panels, consoles, armrest supports, street bike fairings, RV body panels and storage tanks	Rigid, usually shiny in appearance if smooth. May be molded in any color, but usually white or black.	ABS		R03-01	1/8" dia 3 mm	Digital Welder <b>48</b>  Analog Welder <b>4</b>
				R03-04	3/8" x 1/16" 9.5 x 1.6 mm	

# Nitrogen Welder Temperature Setting Chart

Typical Applications	Description / How to Identify	Plastic Symbol	Welding Rod Profiles		Suggested Temperature Settings *
Radiator tanks, oil pans, valve covers, exterior trim parts, mirrors, fenders (Saturn, VW)	Radiator tanks, oil pans, valve covers, exterior trim parts, mirrors, fenders (Saturn, VW)	PA (nylon)	 R06-01	1/8" dia 3 mm	Digital Welder <b>72</b> Analog Welder <b>6</b>
			 R06-04	3/8" x 1/16" 9.5 x 1.6 mm	
Bumper covers (old Ford, some M-B), door skins (Saturn), street bike fairings, instrument panels	Rigid, usually black or dark color, bumpers usually have rebar molded with fascia	PC, PC + ABS, PC + PBT (polycarbonate)	 R07-01	1/8" dia 3 mm	Digital Welder <b>52</b> Analog Welder <b>4.5</b>
			 R07-04	3/8" x 1/16" 9.5 x 1.6 mm	
Flexible bumper covers, filler panels, rocker panel covers, snowmobile cowls	Usually flexible, usually yellow in color (but can be gray), bubbles and smokes when melted	PUR, RIM, RRIM (polyurethane)	 R01-01	1/8" dia 3 mm	Digital Welder <b>52</b> Analog Welder <b>4.5</b>
Pipes, hard plastics, usually not used on vehicles	Hard and shiny	PVC	 R09-01	1/8" dia 3 mm	Digital <b>52</b> Analog <b>4.5</b>
Hard plastic parts	Hard and shiny, may be molded in any color.	PET	 R13-01	1/8" dia 3 mm	Digital <b>54</b> Analog <b>4.5</b>
Hard plastic parts, tail-light housings	Hard and shiny, may be molded in any color.	ASA	 R14-01	1/8" dia 3 mm	Digital <b>48</b> Analog <b>4</b>
Fenders (VW, Saturn), body panels	Fairly flexible, off-white, dull appearance on backside	PA/PPE (GTX)	 R15-01	1/8" dia 3 mm	Digital <b>72</b> Analog <b>6</b>
			 R15-04	3/8" x 1/16" 9.5 x 1.6 mm	

\* Suggested temperature settings are for the welder flowing about 12 LPM. Temperature setting should be adjusted if the flow is significantly higher or lower than this. Flow is generally increased when welding thicker plastics, so the temperature should be increased accordingly. The "digital" temperature setting refers to 6080/6085 welders; the "analog" temperature setting refers to 6057/6059 welders.