










































Nitrogen Welder Temperature Setting Chart

Typical Applications	Description / How to Identify	Plastic Symbol	Welding Rod Profiles & Part Numbers			Suggested Temperature Settings
<p>Bumper covers, headlight housings, inner fender liners, splash shields, fan shrouds, gas tanks, underhood parts, interior parts, snowmobile cowls.</p> <p>Glass fiber-reinforced PP parts: Radiator supports, underhood plastics, UTV bodies, Sea Doo hulls</p>	<p>Usually black, sometimes gray; semi-flexible. 98% of late-model bumper covers are made of PP. Slightly waxy appearance.</p> <p>Glass fiber-reinforced PP parts: Rigid, usually black with dull, fibrous surface appearance</p>	<p>PP, TPO, TEO, PP/EPDM, PP + EP, TSOP (polypropylene)</p> <p>PP+GF (glass-reinforced PP)</p>	 R02-01 (PP) 1/8" dia 3 mm  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  R18-02 (PP+GF15) 3/16" dia 4.7 mm  R18-04 (PP+GF15) 3/8" x 1/16" 9.5 x 1.6 mm  R18-05 (PP+GF15) 5/8" x 1/16" 15.8 x 1.6 mm	<p>Digital Welders 52-64</p> <p>Analog Welders 7</p>		
<p>Grilles, instrument panels, consoles, armrest supports, street bike fairings, RV body panels and storage tanks</p>	<p>Rigid, usually shiny in appearance if smooth. May be molded in any color, but usually white or black.</p>	<p>ABS</p>	 R03-01 1/8" dia 3 mm  R03-04 3/8" x 1/16" 9.5 x 1.6 mm	<p>Digital 44-56</p> <p>Analog 5</p>		
<p>Windshield washer bottles, radiator overflow bottles, inner fender liners, ATV fenders, RV water storage tanks, gas tanks, kayaks, canoes, trash cans</p> <p>Glass fiber-reinforced HDPE: Agricultural plastics, shipping crates, pallets</p>	<p>Usually translucent white (natural), but often molded in color. Waxy in appearance, semi-flexible. Never painted.</p> <p>Glass fiber-reinforced HDPE: Rigid, usually natural but may be any color, dull, fibrous surface appearance</p>	<p>PE, LDPE, HDPE (polyethylene)</p> <p>HDPE+GF (glass-reinforced HDPE)</p>	 R04-01 (LDPE) 1/8" dia 3 mm  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  R19-04 (HDPE+GF15) 3/8" x 1/16" 9.5 x 1.6 mm  R19-08 (HDPE+GF15) 1/4" x 1/16" 6 x 1.6 mm	<p>Digital Welders 48-60</p> <p>Analog Welders 6</p>		
<p>Bumper covers, headlight housings, inner fender liners. Esp. light gray headlight housings.</p>	<p>Light gray, sometimes black. Same as PP but has a bit of synthetic rubber for flexibility.</p>	<p>PP, TPO, TEO, PP/EPDM, PP + EP (Thermoplastic olefin)</p>	 R05-01 (TPO) 1/8" dia 3 mm  R05-04 (TPO) 3/16" dia 4.7 mm  R05-05 (TPO) 3/8" x 0.05" 9.5 x 1.2 mm	<p>Digital Welders 52-64</p> <p>Analog Welders 7</p>		

Typical Applications	Description / How to Identify	Plastic Symbol	Welding Rod Profiles & Part Numbers			Suggested Temperature Settings
Radiator tanks, oil pans, valve covers, exterior trim parts, mirrors, fenders	Radiator tanks, oil pans, valve covers, exterior trim parts, mirrors, fenders	PA (nylon) PA+GF (glass-reinforced nylon)	 R06-01	1/8" dia 3 mm	Digital Welders 64-72 Analog Welders 8	
			 R06-04	3/8" x 1/16" 9.5 x 1.6 mm		
			 R21-04 (PA+GF15)	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. Trade name: Lexan	PC, PC + ABS, PC + PBT (polycarbonate & blends)	 R07-01	1/8" dia 3 mm	Digital 52-64 Analog 7	
			 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	(Airless Welder) Digital 44-52 Analog 5	
Bumpers, exterior body parts	Semi-flexible	PPE+PS	 R08-01	1/8" dia 3 mm	Digital: 48-60 Analog: 6	
Pipes, hard plastics, usually not used on vehicles	Hard, usually dull in appearance	PVC	 R09-01	1/8" dia 3 mm	Digital: 44-52 Analog: 5	
Hard plastic parts	Hard and shiny, may be molded in any color.	PBT	 R11-01	1/8" dia 3 mm	Digital: 48-60 Analog: 6	
Hard plastic parts	Hard and shiny, may be molded in any color.	PET	 R13-01	1/8" dia 3 mm	Digital: 44-52 Analog: 5	
Hard plastic parts, taillight housings	Hard and shiny, may be molded in any color.	ASA	 R14-01	1/8" dia 3 mm	Digital: 44-52 Analog: 5	
Fenders, body panels	Fairly flexible, usually off-white, dull appearance on backside	PA + PPE (GTX)	 R15-01	1/8" dia 3 mm	Digital: 64-72 Analog: 8	
			 R15-04	3/8" x 1/16" 9.5 x 1.6 mm		
Hard plastic parts	Hard and shiny, may be molded in any color	POM	 R16-01	1/8" dia 3 mm	Digital: 44-52 Analog: 5	
Aircraft interior parts (trade names: Kydex, Boltaron)	Flame resistant material, usually thermoformed sheet	Acrylic/PVC	 R17-04	3/8" x 1/16" 9.5 x 1.6 mm	Digital: 44-52 Analog: 5	
Hard plastic parts	Rigid exterior parts, Saturn door panels	PC+ABS	 R20-01	1/8" dia 3 mm	Digital: 52-64 Analog: 7	
Hard plastic parts	Rigid, usually black or dark color	PPX (PPE+PP+GF30)	 R22-01	1/8" dia 3 mm	Digital: 60-68 Analog: 8	

Note: Suggested temperature settings are for the baseline flow setting about 12 LPM. Increase temperature setting for higher flow; reduce temperature setting for lower flow.