








For your safety and to avoid Electrical Shock,  
read all safety notes and precautions detailed  
throughout your Operator's Manual.

## METAL THICKNESS

| WELD PROCESS   | WIRE TYPE/<br>ELECTRODE TYPE                                    | WIRE DIA./<br>ELECTRODE DIA.<br>(in.) | 24 ga<br>.014 in<br>C/O (C) | 22 ga<br>.018 in<br>C/O (C) | 20 ga<br>.024 in<br>C/O (C) | 18 ga<br>.030 in<br>C/O (C) | 16 ga<br>.036 in<br>C/O (C) | 14 ga<br>.045 in<br>C/O (C) | 12 ga<br>.060 in<br>C/O (C) | 1/8" (16 ga)<br>.125 in<br>C/O (C) | 3/16"<br>.187 in<br>C/O (C) | 1/4"<br>.250 in<br>C/O (C) |
|--|---|---------------------------------------|-----------------------------|-----------------------------|-----------------------------|-----------------------------|-----------------------------|-----------------------------|-----------------------------|------------------------------------|-----------------------------|----------------------------|
| DC+<br>   | Steel MIG<br>SUPERARC® L-56® (DC+) 75% Ar / 25% CO <sub>2</sub> | 0.025                                 | C/3                         | C/3                         | D/4                         | E/5                         | F/6                         | G/7                         | I/9                         | -                                  | -                           | -                          |
|  |   | 0.030 <sup>(1)</sup>                  | -                           | B/3                         | C/3                         | D/4                         | E/5                         | F/6                         | G/8                         | H/8                                | J/9 <sup>(1,2)</sup>        | -                          |
|  | Steel MIG<br>SUPERARC® L-56® (DC+) 100% CO <sub>2</sub>         | 0.025                                 | D/4                         | E/4                         | E/4.5                       | F/5                         | G/6                         | H/7                         | I/9                         | J/9 <sup>(1,2)</sup>               | -                           | -                          |
|  |   | 0.030 <sup>(1)</sup>                  | -                           | -                           | D/3.5                       | D/5                         | E/5.5                       | F/6                         | G/7                         | H/8                                | J/9 <sup>(1,2)</sup>        | -                          |
| DC-<br>   | Steel Self Shielded<br>NR®-311-MP (DC-) No Gas                  | 0.030 <sup>(1)</sup>                  | -                           | -                           | -                           | B/2.5                       | B/3                         | D/4                         | E/5                         | G/6 <sup>(1,2)</sup>               | H/6 <sup>(1,2)</sup>        | J/7 <sup>(1,2)</sup>       |
|  |   | 0.035                                 | -                           | -                           | -                           | B/2                         | B/2                         | C/2                         | D/3                         | F/6                                | G/7 <sup>(1,2)</sup>        | I/8 <sup>(1,2)</sup>       |
| DC+<br>   | Aluminum<br>ER4043 (DC+) 100% Argon                             | 0.035                                 | -                           | -                           | -                           | B/2                         | C/2.5                       | E/3                         | G/4.5                       | I/6                                | J/10                        | -                          |
| DC+<br>  | Steel<br>E6011 / E6013 (DC+)                                    | 3/32                                  | -                           | -                           | -                           | E                           | E                           | F                           | G                           | H                                  | -                           | -                          |
|  | Steel<br>E7014 / E7018 (DC+)                                    | 3/32                                  | -                           | -                           | -                           | -                           | G                           | G                           | H                           | I                                  | J                           | -                          |
| DC-<br> | Steel &<br>Stainless Steel<br>(DC-) 100% Argon                  | 1/16                                  | B-C                         | B-C                         | B-D                         | C-D                         | D-E                         | E-F                         | -                           | -                                  | -                           | -                          |
|  |   | 3/32                                  | -                           | -                           | -                           | C-D                         | D-E                         | E-F                         | F-G                         | H-I                                | -                           | -                          |

(1) Connect to 25 amp circuit. (2) Multiple Pass Required. (3) Use .035 groove in drive roll for .030 wire.  
Refer to manual for Current and Voltage values.

Visit [www.lincolnelectric.com](http://www.lincolnelectric.com) for additional product information.

# Mig Mag Welding Guide

**Huangqi Zhang**



## **Mig Mag Welding Guide:**

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**MIG/MAG Welding Guide for Gas Metal Arc Welding (GMAW).** ,1995 *MIG/Mag Welding Guide* ,1997 *The Repair of Vehicle Bodies*, 6th ed Andrew Livesey, A Robinson, 2013-02-11 This book covers the principles and techniques that will help you develop the skills needed to carry out effective vehicle body repair and re finishing This edition has been updated to deal with changes in technology and best practice and meets the current Automotive Skills standards It also covers the topics studied at NVQ levels 2 and 3 and contains handy revision notes making it an ideal text for students on the following courses Automotive Skills Council Vehicle Body and Paint Operations requirements IMI Body Repair and Refinishing Technical Certificates VRQs National Vocational Qualifications NVQs City Guilds Vehicle Body Repair Competence courses NVQ and Progression Awards of both City Guilds and the Institute of the Motor Industry at levels 2 and 3 Professionals and hobbyists will continue to find this an essential manual for the workshop when repairing the latest models or classic cars Other books by Andrew Livesey Basic Motorsport Engineering 9780750689090 Advanced Motorsport Engineering 9780750689083

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Gapiński, Marek Szostak, Vitalii Ivanov, 2019-05-02 This book covers a variety of topics related to machine manufacturing and concerning machine design product assembly technological aspects of production mechatronics and production maintenance Based on papers presented at the 6th International Scientific Technical Conference MANUFACTURING 2019 held in Poznan Poland on May 19 22 2019 the different chapters reports on cutting edge issues in constructing machine parts mechatronic solutions and modern drives They include new ideas and technologies for machine cutting and precise processing Chipless technologies such as founding plastic forming non metal construction materials and composites and additive techniques alike are also analyzed and thoroughly discussed All in all the book reports on significant scientific contributions in modern manufacturing offering a timely guide for researchers and professionals developing and or using mechanical engineering technologies that have become indispensable for modern manufacturing **Innovative Technologies for Joining Advanced Materials XI** Nicușor-Alin SÎRBU, 2021-06-23 Selected peer reviewed full text papers from the 11th International Conference Innovative Technology for Joining Advanced Materials TIMA 20 Selected peer reviewed papers from the 11th International Conference Innovative Technology for Joining Advanced Materials TIMA 20 November 26 27 2020 Timisoara Romania Innovative Technologies for Joining Advanced Materials Alin Constantin Murariu, 2014-09-12 Selected peer reviewed papers from the 7th International Conference on Innovative Technologies for Joining Advanced Materials TIMA 14 June 19 20 2014 Timisoara Romania **Machinery Buyers' Guide**, 1995 **Welder's Handbook** Richard Finch, 2007-02-21 A newly updated state of the art guide to MIG and TIG arc welding technology Written by a noted authority in the field this revised edition of HP's bestselling automotive book for over 20 years is a detailed instructional manual on the theory technique equipment and proper procedures of metal inert gas MIG and tungsten inert gas TIG welding *Guide to Worldwide Maritime Training*, 1993 Welding and Metal Fabrication, 1987 Basic TIG & MIG Welding, 1971 *Iron and Steel Engineer*, 1997 Contains the proceedings of the Association

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