

# LINCOLN ELECTRIC



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

## METAL THICKNESS

WELD PROCESS	WIRE TYPE/ ELECTRODE TYPE	WIRE (dia.) ELECTRODE (dia.) (in.)	24 ga .014 in .030 (2)	22 ga .016 in .030 (2)	20 ga .018 in .030 (2)	18 ga .020 in .030 (2)	16 ga .022 in .030 (2)	14 ga .025 in .030 (2)	12 ga .028 in .030 (2)	10 ga (16 ga) .031 in .030 (2)	3/16" .047 in .030 (2)	1/4" .063 in .030 (2)
DC+	Steel MIG 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>(2)</sup>	-
	Steel MIG 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>(2)</sup>	-	-
		0.030 <sup>(1)</sup>	-	-	D/3.5	D/5	E/5.5	F/6	G/7	H/8	J/9 <sup>(2)</sup>	-
DC-	Steel (GMAW Unshielded 100% Ar) MP (DC-) No Gas	0.030 <sup>(1)</sup>	-	-	-	B/2.5	B/3	D/4	E/5	G/6 <sup>(2)</sup>	H/6 <sup>(2)</sup>	J/7 <sup>(2)</sup>
		0.035	-	-	-	B/2	B/2	C/2	D/3	F/6	G/7 <sup>(2)</sup>	I/8 <sup>(2)</sup>
DC+	Aluminum ER5043 (DC+) 100% Argon	0.035	-	-	-	B/2	C/2.5	E/3	G/4.5	I/6	J/10	-
DC+	Steel E6011 / E6013 (DC+)	3/32	-	-	-	E	E	F	G	H	-	-
	Steel E7014 / E7018 (DC+)	3/32	-	-	-	-	G	G	H	I	J	-
DC-	Steel & Stainless Steel (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-H	-	-

(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

**Alan Robinson, Andrew Livesey**

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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 Poznań 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

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