

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. 0.030 in. 0.030 in.	22 ga .016 in. 0.030 in. 0.030 in.	20 ga .018 in. 0.030 in. 0.030 in.	18 ga .020 in. 0.030 in. 0.030 in.	16 ga .022 in. 0.030 in. 0.030 in.	14 ga .025 in. 0.030 in. 0.030 in.	12 ga .028 in. 0.030 in. 0.030 in.	10 ¹ 11 ¹ 12 ¹ .031 in. .030 in. .030 in.	3/16 ¹ .039 in. 0.030 in.	1/4 ¹ .046 in. 0.030 in.
DC+	Steel MIG SUPERARC® L-56 ¹ (DC+) 75% Ar / 25% CO ₂	0.025	C/3	C/3	D/4	E/5	F/6	G/7	I/9	-	-	-
		0.030 ²	-	B/3	C/3	D/4	E/5	F/6	G/8	H/8	J/9 ^{1,2}	-
	Steel MIG SUPERARC® L-56 ¹ (DC+) 100% CO ₂	0.025	D/4	E/4	E/4.5	F/5	G/6	H/7	I/9	J/9 ^{1,2}	-	-
		0.030 ²	-	-	D/3.5	D/5	E/5.5	F/6	G/7	H/8	J/9 ^{1,2}	-
DC-	Steel Weld Unshielded E6010-E6010-MP (DC-) No Gas	0.030 ²	-	-	-	B/2.5	B/3	D/4	E/5	G/6 ^{1,2}	H/6 ^{1,2}	J/7 ^{1,2}
		0.035	-	-	-	B/2	B/2	C/2	D/3	F/6	G/7 ^{1,2}	I/8 ^{1,2}
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 for additional product information.

Mig Mag Welding Guide

Anthony S. Fauci

Mig Mag Welding Guide:

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MIG/MAG

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Table of Contents Mig Mag Welding Guide

1. Understanding the eBook Mig Mag Welding Guide
 - The Rise of Digital Reading Mig Mag Welding Guide
 - Advantages of eBooks Over Traditional Books
2. Identifying Mig Mag Welding Guide
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Mig Mag Welding Guide
 - User-Friendly Interface
4. Exploring eBook Recommendations from Mig Mag Welding Guide
 - Personalized Recommendations
 - Mig Mag Welding Guide User Reviews and Ratings
 - Mig Mag Welding Guide and Bestseller Lists

5. Accessing Mig Mag Welding Guide Free and Paid eBooks
 - Mig Mag Welding Guide Public Domain eBooks
 - Mig Mag Welding Guide eBook Subscription Services
 - Mig Mag Welding Guide Budget-Friendly Options
6. Navigating Mig Mag Welding Guide eBook Formats
 - ePUB, PDF, MOBI, and More
 - Mig Mag Welding Guide Compatibility with Devices
 - Mig Mag Welding Guide Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Mig Mag Welding Guide
 - Highlighting and Note-Taking Mig Mag Welding Guide
 - Interactive Elements Mig Mag Welding Guide
8. Staying Engaged with Mig Mag Welding Guide
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Mig Mag Welding Guide
9. Balancing eBooks and Physical Books Mig Mag Welding Guide
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Mig Mag Welding Guide
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Mig Mag Welding Guide
 - Setting Reading Goals Mig Mag Welding Guide
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Mig Mag Welding Guide
 - Fact-Checking eBook Content of Mig Mag Welding Guide
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

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- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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