








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/ ELECTRODE TYPE | WIRE DIA./ ELECTRODE DIA. (in.) | 24 ga .014 in C/O (C) | 22 ga .018 in C/O (C) | 20 ga .024 in C/O (C) | 18 ga .030 in C/O (C) | 16 ga .036 in C/O (C) | 14 ga .045 in C/O (C) | 12 ga .060 in C/O (C) | 1/8" (16 ga) .125 in C/O (C) | 3/16" .187 in C/O (C) | 1/4" .250 in C/O (C) |
|--|---|---------------------------------------|-----------------------------|-----------------------------|-----------------------------|-----------------------------|-----------------------------|-----------------------------|-----------------------------|------------------------------------|-----------------------------|----------------------------|
| DC+  | Steel MIG SUPERARC® L-56® (DC+) 75% Ar / 25% CO ₂ | 0.025 | C/3 | C/3 | D/4 | E/5 | F/6 | G/7 | I/9 | - | - | - |
| | | 0.030 ⁽¹⁾ | - | B/3 | C/3 | D/4 | E/5 | F/6 | G/8 | H/8 | J/9 ^(1,2) | - |
| | Steel MIG SUPERARC® L-56® (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 ⁽¹⁾ | - | - | D/3.5 | D/5 | E/5.5 | F/6 | G/7 | H/8 | J/9 ^(1,2) | - |
| DC-  | Steel Self Shielded NR®-311-MP (DC-) No Gas | 0.030 ⁽¹⁾ | - | - | - | 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 ER4043 (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-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 for additional product information.

Mig Mag Welding Guide

Edward F. Craig



Mig Mag Welding Guide:

Mig Welding Guide K Weman,G Lindén,2006-04-30 MIG metal inert gas welding also known as gas metal arc welding GMAW is a key joining technology in manufacturing MIG welding guide provides a comprehensive practical and accessible guide to this widely used process Part one discusses the range of technologies used in MIG welding including power sources shielding gases and consumables Fluxed cored arc welding pulsed MIG welding and MIG brazing are also explored Part two reviews quality and safety issues such as improving productivity in MIG MAG welding assessing weld quality health and safety and methods for reducing costs The final part of the book takes a practical look at the applications of MIG welding with chapters dedicated to the welding of steel and aluminium the use of robotics in MIG welding and the application of MIG welding in the automotive industry MIG welding guide is essential reading for welding and production engineers designers and all those involved in manufacturing Provides extensive coverage on gas metal arc welding a key process in industrial manufacturing User friendly in its language and layout Looks at the practical applications of MIG welding

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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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