

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" O.D. (pl.)	3/16"	1/4"
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 (GMAW Unshielded 100% Ar) 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 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.

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Mig Mag Welding Guide

Edward F. Craig

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