

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.

Visit www.lincolnelectric.com for additional product information.

Mig Mag Welding Guide

Andrew Livesey, Alan Robinson

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

MIG/MAG

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