



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 Welding Pocket Guide

K Weman,G Lindén



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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 *Audel Welding Pocket Reference* James E. Brumbaugh,Rex Miller,2007-03-15 Featuring updated charts dealing with the most common situations welding workers face on the job this comprehensive pocket sized reference is based on recommendations from working professionals and covers welding symbols and definitions types of joints and welds typical welding station configurations oxygen cylinders arc welding charts U S metric measures and more **A Management and Engineer's Guide to MIG Welding Quality, Costs, and Training** Edward F. Craig,1996 MIG and flux cored weld results achieved with the world s most utilized welding equipment are frequently influenced by weld sales advice This 600 plus page book has been called the MIG bible by some readers It s the most comprehensive book ever written on managing the MIG process The book covers all aspects of controlling both the MIG and flux cored process A MANAGER OR ENGINEER DOES NOT REQUIRE THE ABILITY TO WELD HOWEVER THEY SHOULD HAVE THE FUNDAMENTAL PROCESS KNOWLEDGE OF WHAT MAKES A GOOD MIG OR FLUX CORED WELD WHEN A MANAGER OR ENGINEER UNDERSTANDS HOW SALES INFLUENCE AND HYPE EFFECTS THE WELD SHOP THEY ARE WELL ON THEIR WAY TO WELD PROCESS MANAGEMENT In the MIG Management book you will find Extensive data on MIG gas selection without sales input Over 100 pages on the problems with the pulsed process How to establish effective weld process controls for robot cells How to use special techniques to increase robot weld speeds How to optimize manual and robot weld deposition rates How to control sheet metal welds in automotive plants How to best utilize MIG and flux cored for pipe welds All this along with a unique simple method for controlling weld costs These are just a few of the important topics Without question this is the most practical and comprehensive book you will ever find on managing the MIG process *Complete Siding Handbook* James E. Brumbaugh,1993-01-19 The ultimate guide to siding for homeowners and professional builders The Complete Siding Handbook Installation Maintenance Repair offers comprehensive guidance for all major types of siding including wood board

aluminum shingle plywood vinyl and more Aimed at professional builders but accessible to homeowners this informative guide includes practical information on sheathing flashing vapor and air retarders insulation and other preparatory materials as well as expert advice on painting staining and finishing Detailed diagrams clarify installation and construction while photographs show real world applications of various materials and methods to provide builders and DIY ers with an

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