



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/<br>ELECTRODE TYPE                                    | WIRE DIA./<br>ELECTRODE DIA.<br>(in.) | 24 ga<br>.014 in<br>C/O (C) | 22 ga<br>.018 in<br>C/O (C) | 20 ga<br>.024 in<br>C/O (C) | 18 ga<br>.030 in<br>C/O (C) | 16 ga<br>.036 in<br>C/O (C) | 14 ga<br>.045 in<br>C/O (C) | 12 ga<br>.060 in<br>C/O (C) | 1/8" (16 ga)<br>.125 in<br>C/O (C) | 3/16"<br>.187 in<br>C/O (C) | 1/4"<br>.250 in<br>C/O (C) |
|--------------|---|---------------------------------------|-----------------------------|-----------------------------|-----------------------------|-----------------------------|-----------------------------|-----------------------------|-----------------------------|------------------------------------|-----------------------------|----------------------------|
| DC+<br>      | Steel MIG<br>SUPERARC® L-56® (DC+) 75% Ar / 25% CO <sub>2</sub> | 0.025                                 | C/3                         | C/3                         | D/4                         | E/5                         | F/6                         | G/7                         | I/9                         | -                                  | -                           | -                          |
|              |   | 0.030 <sup>(1)</sup>                  | -                           | B/3                         | C/3                         | D/4                         | E/5                         | F/6                         | G/8                         | H/8                                | J/9 <sup>(1,2)</sup>        | -                          |
|              | Steel MIG<br>SUPERARC® L-56® (DC+) 100% CO <sub>2</sub>         | 0.025                                 | D/4                         | E/4                         | E/4.5                       | F/5                         | G/6                         | H/7                         | I/9                         | J/9 <sup>(1,2)</sup>               | -                           | -                          |
|              |   | 0.030 <sup>(1)</sup>                  | -                           | -                           | D/3.5                       | D/5                         | E/5.5                       | F/6                         | G/7                         | H/8                                | J/9 <sup>(1,2)</sup>        | -                          |
| DC-<br>      | Steel Self Shielded<br>NR®-311-MP (DC-) No Gas                  | 0.030 <sup>(1)</sup>                  | -                           | -                           | -                           | B/2.5                       | B/3                         | D/4                         | E/5                         | G/6 <sup>(1,2)</sup>               | H/6 <sup>(1,2)</sup>        | J/7 <sup>(1,2)</sup>       |
|              |   | 0.035                                 | -                           | -                           | -                           | B/2                         | B/2                         | C/2                         | D/3                         | F/6                                | G/7 <sup>(1,2)</sup>        | I/8 <sup>(1,2)</sup>       |
| DC+<br>      | Aluminum<br>ER4043 (DC+) 100% Argon                             | 0.035                                 | -                           | -                           | -                           | B/2                         | C/2.5                       | E/3                         | G/4.5                       | I/6                                | J/10                        | -                          |
| DC+<br>      | Steel<br>E6011 / E6013 (DC+)                                    | 3/32                                  | -                           | -                           | -                           | E                           | E                           | F                           | G                           | H                                  | -                           | -                          |
|              | Steel<br>E7014 / E7018 (DC+)                                    | 3/32                                  | -                           | -                           | -                           | -                           | G                           | G                           | H                           | I                                  | J                           | -                          |
| DC-<br>      | Steel &<br>Stainless Steel<br>(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](http://www.lincolnelectric.com) for additional product information.

# Mig Mag Welding Guide

**Zhe Xu**



## **Mig Mag Welding Guide:**

## Decoding **Mig Mag Welding Guide**: Revealing the Captivating Potential of Verbal Expression

In a period characterized by interconnectedness and an insatiable thirst for knowledge, the captivating potential of verbal expression has emerged as a formidable force. Its power to evoke sentiments, stimulate introspection, and incite profound transformations is genuinely awe-inspiring. Within the pages of "**Mig Mag Welding Guide**," a mesmerizing literary creation penned with a celebrated wordsmith, readers attempt an enlightening odyssey, unraveling the intricate significance of language and its enduring affect our lives. In this appraisal, we shall explore the book's central themes, evaluate its distinctive writing style, and gauge its pervasive influence on the hearts and minds of its readership.

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