

LINCOLN ELECTRIC



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.)	METAL THICKNESS									
			24 ga .014 in Ø10 (1)	22 ga .016 in Ø10 (2)	20 ga .019 in Ø10 (2)	18 ga .024 in Ø10 (2)	16 ga .030 in Ø10 (2)	14 ga .037 in Ø10 (2)	12 ga .048 in Ø10 (2)	1/8" (10 ga) .125 in Ø10 (2)	3/16" .187 in Ø10 (2)	1/4" .250 in Ø10 (2)
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 ⁽²⁾	-	B/3	C/3	D/4	E/5	F/6	G/8	H/8	J/9 ⁽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 ⁽²⁾	-	-
		0.030 ⁽²⁾	-	-	D/3.5	D/5	E/5.5	F/6	G/7	H/8	J/9 ⁽²⁾	-
DC- 	Steel Self Shielded NR® 311-MF (DC-) No Gas	0.030 ⁽²⁾	-	-	-	B/2.5	B/3	D/4	E/5	G/6 ⁽²⁾	H/6 ⁽²⁾	J/7 ⁽²⁾
		0.035	-	-	-	B/2	B/2	C/2	D/3	F/6	G/7 ⁽²⁾	I/8 ⁽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

Lauren Gardner



Mig Mag Welding Guide:

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Table of Contents Mig Mag Welding Guide

1. Understanding the eBook Mig Mag Welding Guide
 - The Rise of Digital Reading Mig Mag Welding Guide
 - Advantages of eBooks Over Traditional Books
2. Identifying Mig Mag Welding Guide
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Mig Mag Welding Guide
 - User-Friendly Interface
4. Exploring eBook Recommendations from Mig Mag Welding Guide
 - Personalized Recommendations
 - Mig Mag Welding Guide User Reviews and Ratings
 - Mig Mag Welding Guide and Bestseller Lists
5. Accessing Mig Mag Welding Guide Free and Paid eBooks
 - Mig Mag Welding Guide Public Domain eBooks
 - Mig Mag Welding Guide eBook Subscription Services
 - Mig Mag Welding Guide Budget-Friendly Options
6. Navigating Mig Mag Welding Guide eBook Formats

- ePub, PDF, MOBI, and More
- Mig Mag Welding Guide Compatibility with Devices
- Mig Mag Welding Guide Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Mig Mag Welding Guide
 - Highlighting and Note-Taking Mig Mag Welding Guide
 - Interactive Elements Mig Mag Welding Guide
- 8. Staying Engaged with Mig Mag Welding Guide
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Mig Mag Welding Guide
- 9. Balancing eBooks and Physical Books Mig Mag Welding Guide
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Mig Mag Welding Guide
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Mig Mag Welding Guide
 - Setting Reading Goals Mig Mag Welding Guide
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Mig Mag Welding Guide
 - Fact-Checking eBook Content of Mig Mag Welding Guide
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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