



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	22 ga	20 ga	18 ga	16 ga	14 ga	12 ga	1/8" (32 ga)	3/16"	1/4"
			.024 in Ø10 (2)	.028 in Ø10 (2)	.034 in Ø10 (2)	.048 in Ø10 (2)	.060 in Ø10 (2)	.075 in Ø10 (2)	.100 in Ø10 (2)	.125 in Ø10 (2)	.187 in Ø10 (2)	.250 in Ø10 (2)
<b>DC+</b> 	Steel MIG 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>3</sup>	-	B/3	C/3	D/4	E/5	F/6	G/8	H/8	J/9 <sup>1,2</sup>	-
	Steel MIG 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>3</sup>	-	-	D/3.5	D/5	E/5.5	F/6	G/7	H/8	J/9 <sup>1,2</sup>	-
<b>DC-</b> 	Steel Self Shielded NR® 311-MF (DC-) No Gas	0.030 <sup>3</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>
<b>DC+</b> 	Aluminum ER4043 (DC+) 100% Argon	0.035	-	-	-	B/2	C/2.5	E/3	G/4.5	I/6	J/10	-
<b>DC+</b> 	Steel E6011 / E6013 (DC+)	3/32	-	-	-	E	E	F	G	H	-	-
	Steel E7014 / E7018 (DC+)	3/32	-	-	-	-	G	G	H	I	J	-
<b>DC-</b> 	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](http://www.lincolnelectric.com) for additional product information.

# Mig Mag Welding Guide

**K Weman,G Lindén**



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