

CHOOSING A WIRE . . .

Welding Wire Thickness Chart	RECOMMENDED WIRE SIZES						
	MIG SOLID WIRE				GASLESS FLUX-CORED WIRE		
MATERIAL THICKNESS	.024"	.030"	.035"	.045"	.030"	.035"	.045"
24 Gauge (.025)							
22 Gauge (.031)							
20 Gauge (.037)							
18 Gauge (.050)							
16 Gauge (.063)							
14 Gauge (.078)							
1/8" (.125)							
3/16" (.188)							
1/4" (.25)							
5/16" (.313)							
3/8" (.375)							

Multi-pass welding or a beveled joint design may be required on material thickness 3/16" and greater depending on your welding machine's amperage capability.

CHOOSING AN ELECTRODE . . .

Electrode Polarity Chart					
ELECTRODE	DC*	AC	POSITION	PENETRATION	USAGE
6010	EP	--	ALL	DEEP	MIN. PREP, ROUGH, HIGH SPATTER
6011	EP	√	ALL	DEEP	MIN. PREP, ROUGH, HIGH SPATTER
6013	EP, EN	√	ALL	LOW	GENERAL
7014	EP, EN	√	ALL	MED.	SMOOTH, EASY, FAST
7018	EP	√	ALL	LOW	LOW HYDROGEN, STRONG
7018AC	EP	√	ALL	LOW	LOW HYDROGEN, STRONG
Ni-CI	EP	√	ALL	LOW	CAST IRON
308L	EP	√	ALL	LOW	STAINLESS

*EP = ELECTRODE POSITIVE (REVERSE POLARITY) *EN = ELECTRODE NEGATIVE (STRAIGHT POLARITY)

Electrode/Amperage Chart						
ELECTRODE	DIAMETER		AMPERAGE RANGE			
	IN	MM	MIN. 50 A	100 A	150 A	200 A MAX
6011	3/32	2.4				
	1/8	3.2				
	5/32	4.0				
6013	1/16	1.6				
	5/64	2.0				
	3/32	2.4				
	1/8	3.2				
7014	5/32	4.0				
	3/32	2.7				
	1/8	3.2				
7018 7018 AC	5/32	4.0				
	3/32	2.4				
	1/8	3.2				
Ni-CI Nickel 55 and 99	3/32	2.4				
	1/8	3.2				
308L Stainless 312	3/32	2.4				
	1/8	3.2				
Hard Surfacing	1/8	3.2				
	5/32	4.0				
Aluminum	1/8	3.2				
Nomacast	1/8	3.2				
Cutting	3/32	2.4				