

LENS - DETAILS OF FIELD USE

ELECTRIC ARC WELDING AND GOUGING											
Welding Current In Amps	WELDING PROCESS										
	Plasma Jet Cutting	Coated Electrodes	Mig on Heavy Metals	Mig on Light Metals	Tig on all Allows & Metals	Mag	Arc/Air Gouging	Plasma Jet Welding			
0.5								Shades 2.5, 3, 4, 5			
1								Shades 2.5, 3, 4, 5			
2.5								Shade 6			
5								Shade 7			
10					Shade 9			Shade 8			
15					Shade 9			Shade 9			
20					Shade 9			Shade 10			
30		Shade 9			Shade 10			Shade 10			
40	Shade 11	Shade 9			Shade 10			Shade 11			
60	Shade 11	Shade 10			Shade 11	Shade 10		Shade 11			
80	Shade 11	Shade 10			Shade 11	Shade 10		Shade 12			
100	Shade 11	Shade 11	Shade 10	Shade 10	Shade 11	Shade 11		Shade 12			
125	Shade 11	Shade 11	Shade 11	Shade 11	Shade 12	Shade 11		Shade 12			
150	Shade 11	Shade 11	Shade 11	Shade 11	Shade 12	Shade 12	Shade 10	Shade 13			
175	Shade 12	Shade 11	Shade 11	Shade 11	Shade 12	Shade 12	Shade 10	Shade 13			
200	Shade 12	Shade 12	Shade 12	Shade 12	Shade 13	Shade 13	Shade 11	Shade 13			
225	Shade 12	Shade 12	Shade 12	Shade 12	Shade 13	Shade 13	Shade 11	Shade 13			
250	Shade 12	Shade 12	Shade 12	Shade 12	Shade 13	Shade 13	Shade 1	Shade 14			
275	Shade 13	Shade 12	Shade 12	Shade 12	Shade 14	Shade 14	Shade 1	Shade 14			
300	Shade 13	Shade 12	Shade 12	Shade 12	Shade 14	Shade 14	Shade 1	Shade 14			
350	Shade 13	Shade 13	Shade 13	Shade 13	Shade 14	Shade 14	Shade 1	Shade 14			
400	Shade 13	Shade 13	Shade 13	Shade 14	Shade 14	Shade 14	Shade 1	Shade 14			
450		Shade 13	Shade 13	Shade 14			Shade 1	Shade 14			
500		Shade 13	Shade 13	Shade 14			Shade 1	Shade 15			
		Shade 14	Shade 14	Shade 15			Shade 1	Shade 15			
		Shade 14	Shade 14	Shade 15			Shade 1	Shade 15			
Gas Welding Welding and Bronze Welds of Heavy Metals		Output of Acetylene In lit/hr			Oxy Acetylene Cutting Flame			Output of Oxygen Lit/hr.			
		Less than 70						Shade 4	900 to 2000		Shade 5
		70 to 200						Shade 5	2000 to 4000		Shade 6
		200 to 800						Shade 6	4000 to 8000		Shade 7
Greater than 800			Shade 7								