

SHADE GUIDE TABLE

Welding Process	ARC CURRENT (Amperes)															
	0.5	2.5	10	20	40	80	125	175	225	275	350	450				
	1	5	15	30	60	100	150	200	250	300	400	500				
SMAW					9	10	11		12		13		14			
MIG (heavy)						10	11	12		13		14				
MIG (light)						10	11	12	13	14	15					
TIG, GTAW			9	10	11	12	13		14							
MAG/CO ₂						10	11	12	13		14		15			
SAW							10	11	12	13	14	15				
PAC						11		12		13						
PAW			8	9	10	11	12	13		14		15				
NOTE:																
SMAW - Shielded Metal Arc Welding								MIG (Heavy) - MIG on Heavy Metals								
TIG, GTAW - Gas Tungsten Arc Welding								PAW - Plasma Arc Welding								
PAC - Plasma Arc Cutting								MAG/CO ₂ - Metal Active Gas								
SAW - Shielded Semi-Automatic Arc Welding								MIG (Light) - MIG on Light Alloys								