

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
 TIG, GTAW - Gas Tungsten Arc Welding
 PAC - Plasma Arc Cutting
 SAW - Shielded Semi-Automatic Arc Welding

MIG (Heavy) - MIG on Heavy Metals
PAW - Plasma Arc Welding
MAG/CO₂ - Metal Active Gas
MIG (Light) - MIG on Light Alloys