

SHADE GUIDE TABLE

WELDING PROCESS	CURRENT IN AMPERES																					
	1.5	6	10	15	30	40	60	70	100	125	150	175	200	225	250	300	350	400	450	500	600	
Covered Electrodes	8						9	10	11	12	13	14										
MAG	8							9	10	11	12	13										
TIG on all metals and alloys	8				9	10	11	12	13													
MIG on heavy metals	9								10	11	12	13	14									
MIG on light metals	10										11	12	13	14								
Arc-air gouging	10										11	12	13	14	15							
Plasma jet cutting	9								10	11	12	13										
Micro plasma arc welding	4	5	6	7	8	9	10	11	12													

PLATE THICKNESS

	in.	mm	SUGGESTED SHADE NO. (COMFORT)
Gas welding			
light	Under 1/8	Under 3.2	4 or 5
medium	1/8 to 1/2	3.2 to 12.7	5 or 6
heavy	over 1/2	over 12.7	6 or 8
Oxygen cutting			
light	Under 1	Under 25	3 or 4
medium	1 to 6	25 to 150	4 or 5
heavy	over 6	over 150	4 or 6