

LINCOLN
ARC WELDER

SUGGESTED SETTINGS FOR WELDING

ADJUST FOR OPTIMUM WELDING

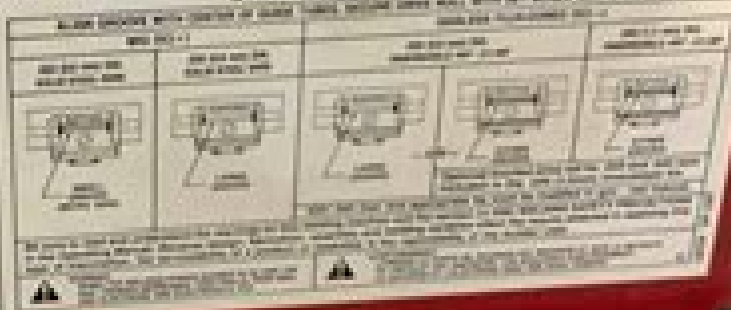
LINCOLN
ARC WELDER

PROCESS	WELDING WIRE	SHIELDING GAS	STEEL THICKNESS											
			1/8" (3.2mm)	1/4" (6.4mm)	3/8" (9.5mm)	1/2" (12.7mm)	5/8" (15.9mm)	3/4" (19.1mm)	7/8" (22.2mm)	1" (25.4mm)	1 1/4" (31.8mm)	1 1/2" (38.1mm)	2" (50.8mm)	2 1/2" (63.5mm)
MIG GMAW	E6010 CELLULOSE CORE	CO ₂	A-2	B-3	B-3	C-4	C-4	D-5	E-6					
		75% Ar/25% CO ₂ OR 90% Ar/10% CO ₂	A-2	A-2	B-3	C-4.5	C-4.5	D-7	E-10					
	E6011 CELLULOSE CORE	CO ₂		B-2	B-2	C-2.5	C-2.5	D-4	E-4					
		75% Ar/25% CO ₂ OR 90% Ar/10% CO ₂		A-2	B-2.5	B-2.5	C-3.5	D-3.5	E-7.5	E-7.5				
TIG GTAW	E6010 CELLULOSE CORE	None				A-1.5	A-1.5	B-2	C-2.5	C-2.5				
	E6011 CELLULOSE CORE	None				A-1.5	B-1.5	B-1.5	C-1.5	C-1.5	D-2	D-2	E-2.5	E-2.5

OUTPUT POLARITY



DRIVE ROLL ORIENTATION



BigIron

Lincoln Sp 130t Welder Manual

Lincoln Electric Company

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Table of Contents Lincoln Sp 130t Welder Manual

1. Understanding the eBook Lincoln Sp 130t Welder Manual
 - The Rise of Digital Reading Lincoln Sp 130t Welder Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Lincoln Sp 130t Welder Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Lincoln Sp 130t Welder Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Lincoln Sp 130t Welder Manual
 - Personalized Recommendations
 - Lincoln Sp 130t Welder Manual User Reviews and Ratings
 - Lincoln Sp 130t Welder Manual and Bestseller Lists

5. Accessing Lincoln Sp 130t Welder Manual Free and Paid eBooks
 - Lincoln Sp 130t Welder Manual Public Domain eBooks
 - Lincoln Sp 130t Welder Manual eBook Subscription Services
 - Lincoln Sp 130t Welder Manual Budget-Friendly Options
6. Navigating Lincoln Sp 130t Welder Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Lincoln Sp 130t Welder Manual Compatibility with Devices
 - Lincoln Sp 130t Welder Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Lincoln Sp 130t Welder Manual
 - Highlighting and Note-Taking Lincoln Sp 130t Welder Manual
 - Interactive Elements Lincoln Sp 130t Welder Manual
8. Staying Engaged with Lincoln Sp 130t Welder Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Lincoln Sp 130t Welder Manual
9. Balancing eBooks and Physical Books Lincoln Sp 130t Welder Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Lincoln Sp 130t Welder Manual
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Lincoln Sp 130t Welder Manual
 - Setting Reading Goals Lincoln Sp 130t Welder Manual
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Lincoln Sp 130t Welder Manual
 - Fact-Checking eBook Content of Lincoln Sp 130t Welder Manual
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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