

LINCOLN
ARC WELDER

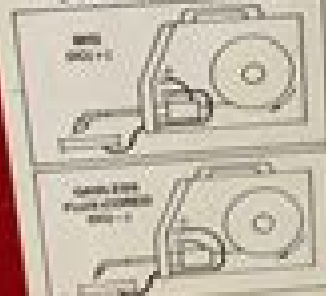
SUGGESTED SETTINGS FOR WELDING

ADJUST FOR OPTIMUM WELDING

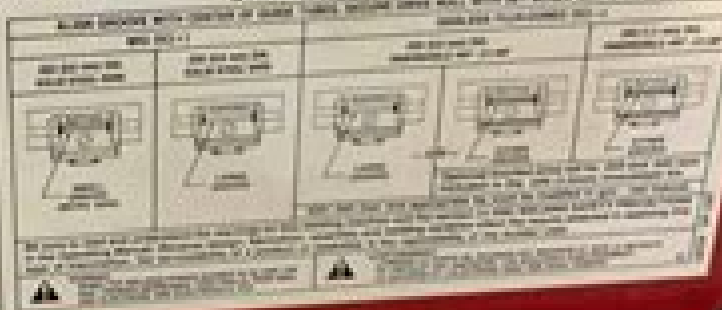
LINCOLN
ARC WELDER

| 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 1/8" (28.6mm) | 1 1/4" (31.8mm) | 1 3/8" (34.9mm) | 1 1/2" (38.1mm) |
| 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

N Colangelo



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