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ARC WELDER

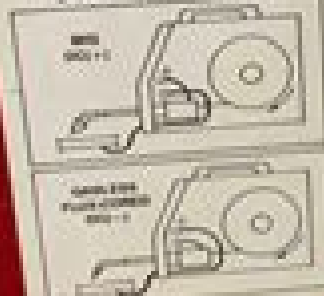
SUGGESTED SETTINGS FOR WELDING

ADJUST FOR OPTIMUM WELDING

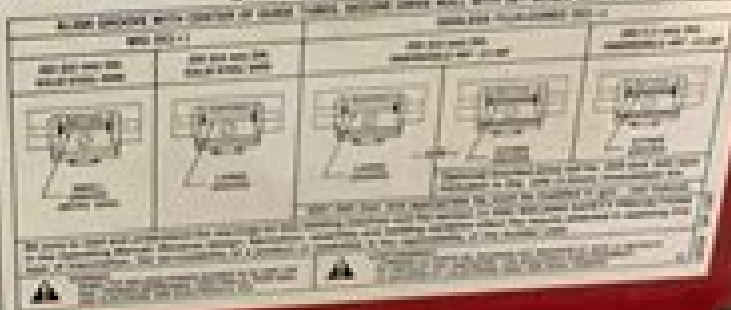
LINCOLN
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PROCESS	WELDING WIRE	SHIELDING GAS	STEEL THICKNESS											
			1/8" (3.2mm)	1/4" (6.4mm)	3/8" (9.5mm)	1/2" (12.7mm)	5/8" (15.9mm)	3/4" (19.1mm)	7/8" (22.2mm)	1" (25.4mm)	1 1/8" (28.6mm)	1 1/4" (31.8mm)	1 3/4" (41.3mm)	2" (50.8mm)
MIG GMAW	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	

OUTPUT POLARITY



DRIVE ROLL ORIENTATION



BigIron

Lincoln Sp 130t Welder Manual

Sabine Zange



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