

## LENS - DETAILS OF FIELD USE

ELECTRIC ARC WELDING AND GOUGING										
Welding Current In Amps	WELDING PROCESS									
	Plasma Jet Cutting	Coated Electrodes	Mig on Heavy Metals	Mig on Light Metals	Tig on all Allows & Metals	Mag	Arc/Air Gouging	Plasma Jet Welding		
0.5								Shades 2.5, 3, 4, 5		
1								Shades 2.5, 3, 4, 5		
2.5								Shade 6		
5								Shade 7		
10					Shade 9			Shade 8		
15					Shade 9			Shade 9		
20					Shade 9			Shade 10		
30		Shade 9			Shade 10			Shade 10		
40	Shade 11	Shade 9			Shade 10			Shade 11		
60	Shade 11	Shade 10			Shade 11	Shade 10		Shade 11		
80	Shade 11	Shade 10			Shade 11	Shade 10		Shade 12		
100	Shade 11	Shade 11	Shade 10	Shade 10	Shade 11	Shade 11		Shade 12		
125	Shade 11	Shade 11	Shade 11	Shade 11	Shade 12	Shade 11		Shade 12		
150	Shade 11	Shade 11	Shade 11	Shade 11	Shade 12	Shade 12	Shade 10	Shade 13		
175	Shade 12	Shade 11	Shade 11	Shade 11	Shade 12	Shade 12	Shade 10	Shade 13		
200	Shade 12	Shade 12	Shade 12	Shade 12	Shade 13	Shade 13	Shade 11	Shade 13		
225	Shade 12	Shade 12	Shade 12	Shade 12	Shade 13	Shade 13	Shade 11	Shade 13		
250	Shade 12	Shade 12	Shade 12	Shade 12	Shade 13	Shade 13	Shade 1	Shade 14		
275	Shade 13	Shade 12	Shade 12	Shade 12	Shade 14	Shade 14	Shade 1	Shade 14		
300	Shade 13	Shade 12	Shade 12	Shade 12	Shade 14	Shade 14	Shade 1	Shade 14		
350	Shade 13	Shade 13	Shade 13	Shade 13	Shade 14	Shade 14	Shade 1	Shade 14		
400	Shade 13	Shade 13	Shade 13	Shade 14	Shade 14	Shade 14	Shade 1	Shade 14		
450		Shade 13	Shade 13	Shade 14			Shade 1	Shade 14		
500		Shade 13	Shade 13	Shade 14			Shade 1	Shade 15		
		Shade 14	Shade 14	Shade 15			Shade 1	Shade 15		
		Shade 14	Shade 14	Shade 15			Shade 1	Shade 15		
Gas Welding Welding and Bronze Welds of Heavy Metals		Output of Acetylene In lit/hr			Oxy Acetylene Cutting Flame			Output of Oxygen Lit/hr.		Shade 5 Shade 6 Shade 7
		Less than 70						900 to 2000		
		70 to 200						2000 to 4000		
		200 to 800						4000 to 8000		
Greater than 800										