

# INFO - WELD NO. 2



## WELDAMAX WELDING INFORMATION BULLETIN

ACCOUNTABILITY - COMMITMENT - CONTINUOUS IMPROVEMENT - TEAMWORK

### GUIDE FOR FILTER LENS SHADE NUMBERS

OPERATION	ARC CURRENT(amps)	MINIMUM SHADE	SUGGESTED COMFORT SHADE
Stick Electrode Welding	Less than 60	8	8
	60 -160	8	10
	160 - 250	10	12
	250 - 600	11	14
	600+	14	14
M.I.G. / M.A.G. Welding	Less than 60	8	8
	60 - 160	10	11
	160 - 250	10	12
	250 - 600	10	14
	600+	14	14
T.I.G. Welding	Less than 60	8	10
	50 - 150	8	12
	150 - 500	10	14
Arc Air Carbon Arc Gouging	400 +	14	14
Plasma Arc Cutting	Less than 300	8	10
	300 - 400	9	12
	400 - 800	10	14
Torch Brazing		4	4
Torch Soldering		3	3
Gas Welding	Light	4	5
	Medium	5	6
	Heavy	5	8
Oxygen Acetylene Cutting	Light (25mm)	4	4
	Medium (25 - 150mm)	4	5
	Heavy ( Over 150mm)	6	8

As a rule of thumb, start with a shade that is too dark to see the weld / cut zone. Then go to a lighter shade which gives sufficient view of the weld zone without going below the minimum recommended shade.

### MAGNIFIER LENSES

The optically correct, clear magnifier lenses are available in three optic strengths: 1.50 2.00 2.50 (size 51 x 108 x 3 mm thick) Polycarbonate

Replacing the clear vision lens, behind the filter lens of your welding helmet, with a magnifier lens, most suited to the operator's vision strength, the operator is able to weld without using his expensive prescription spectacles.

