

SHADE GUIDE TABLE

Welding Process	ARC CURRENT (Amperes)													
	0.5	2.5	10	20	40	80	125	175	225	275	350	450		
	1	5	15	30	60	100	150	200	250	300	400	500		
SMAW					9	10	11	12			13	14		
MIG (heavy)							10	11	12		13	14		
MIG (light)							10	11	12	13	14	15		
TIG, GTAW			9	10	11	12	13				14			
MAG/CO₂					10	11	12	13			14	15		
SAW							10	11	12	13	14	15		
PAC							11	12		13				
PAW			8	9	10	11	12	13		14		15		

NOTE:

SMAW - Shielded Metal Arc Welding
 TIG, GTAW - Gas Tungsten Arc Welding
 PAC - Plasma Arc Cutting
 SAW - Shielded Semi-Automatic Arc Welding

MIG (Heavy) - MIG on Heavy Metals
 PAW - Plasma Arc Welding
 MAG/CO₂ - Metal Active Gas
 MIG (Light) - MIG on Light Alloys