



Lens Shade Selection Table

Process	Electrode Size in. (mm)	Arc Current in Amperes	Minimum Protective Shade No.	Suggested Shade No. (Comfort)*
Shielded Metal Arc Welding (SMAW)	< 3/32 (2.4) 3/32-5/32 (2.4-4.0) 5/32-1/4 (4.0-6.4) > 1/4 (6.4)	Less than 60 60-160 160-250 250-550	7 8 10 11	- 10 12 14
Gas Metal Arc Welding (GMAW)		Less than 60	7	-
		60-160	10	11
Flux Cored Arc Welding (FCAW)		160-250 250-550	10 10	12 14
Gas Tungsten Arc Welding (TIG)		Less than 50	8	10
		50-150	8	12
		150-500	10	14
Air Carbon Arc Cutting (CAC-A)	Light Heavy	Less than 500 500-1000	10 11	12 14
Plasma Arc Cutting (PAC)		Less than 20	4	4
		20-40	5	5
		40-60	6	6
		60-80	8	8
		80-300	8	9
		300-400	9	12
		400-800	10	14
Plasma Arc Welding (PAW)		Less than 20	6	6-8
		20-100	8	10
		100-400	10	12
		400-800	11	14