

Diagram 4: Welding Wire Thickness Chart

MATERIAL THICKNESS	RECOMMENDED WIRE SIZES						
	MIG SOLID WIRE				GASLESS FLUX-CORED WIRE		
	.024"	.030"	.035"	.045"	.030"	.035"	.045"
24 Gauge (.025)							
22 Gauge (.031)							
20 Gauge (.037)							
18 Gauge (.050)							
16 Gauge (.063)							
14 Gauge (.078)							
1/8" (.125)							
3/16" (.188)							
1/4" (.25)							
5/16" (.313)							
3/8" (.375)							
1/2" (.5)							

Multi-pass welding or a beveled joint design may be required on material thickness 3/16" and greater depending on your welding machine's amperage capability.