



Lusail Real Estate Development Company

Health, Safety, Security, Environment, Logistics & Quality Department

Lusail Construction Safety Procedural Forms/Checklists – Filter Lenses for Welding

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COMPANY PROPRIETARY INFORMATION

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Filter lenses for Welding

Welding Process	Arc Current (Amperes)	Minimum Protective Shade	Suggested Protective Shade (Comfort)
Shielded Metal Arc Welding (SMAW)	Less than 60	7	—
	60 to 160	8	10
	160 to 250	10	12
	250 to 550	11	14
Gas Metal Arc Welding (GMAW) (MIG)	Less than 60	7	—
	60 to 160	10	11
	160 to 250	10	12
	250 to 550	10	14
Gas Tungsten Arc Welding (GTAW) (TIG)	Less than 50	8	10
	50 to 150	8	12
	150 to 500	10	14
Air Carbon (light)	Less than 500	10	12
Air Carbon (heavy)	500 to 1,000	11	14
Plasma Arc Welding (PAW)	20 to 100	8	10
	100 to 400	10	12
	400 to 800	11	14
Plasma Arc Cutting (PAC)	Less than 300	8	9
	300 to 400	9	12
	400 to 800	10	14
Carbon Arc Welding (CAW)	—	—	14
MIG = metal inert gas TIG = tungsten inert gas			