

# Stick Welding Rod Size, Amperage & Metal Thickness Chart

| Electrode   | Diameter |     | Amperage | Metal Thickness |           |
|-------------|----------|-----|----------|-----------------|-----------|
|             | In       | mm  |          | In              | mm        |
| 6010 / 6011 | 3/32"    | 2.4 | 40-85    | 3/32 - 3/16"    | 2.4 - 4.8 |
| 6010 / 6011 | 1/8"     | 3.2 | 75-125   | 1/8 - 1/4"      | 3.2 - 6.4 |
| 6010 / 6011 | 5/32"    | 4   | 110-165  | 1/4" - 3/8"     | 6.4 - 9.5 |
| 6010 / 6011 | 3/16"    | 4.8 | 140-210  | Over 3/8"       | Over 9.5  |
| 6010 / 6011 | 7/32"    | 5.6 | 160-250  | Over 3/8"       | Over 9.5  |
| 6013        | 1/16"    | 1.6 | 20-45    | Up to 1/8"      | Up to 3.2 |
| 6013        | 5/64"    | 2   | 35-60    | Up to 3/16"     | Up to 4.8 |
| 6013        | 3/32"    | 2.4 | 40-90    | 3/32 - 3/16"    | 2.4 - 4.8 |
| 6013        | 1/8"     | 3.2 | 80-130   | 1/8 - 1/4"      | 3.2 - 6.4 |
| 6013        | 5/32"    | 4   | 105-180  | 1/4" - 3/8"     | 6.4 - 9.5 |
| 6013        | 3/16"    | 4.8 | 150-230  | Over 3/8"       | Over 9.5  |
| 6013        | 7/32"    | 5.6 | 210-300  | Over 3/8"       | Over 9.5  |
| 7014        | 3/32"    | 2.4 | 80-125   | 3/32 - 3/16"    | 2.4 - 4.8 |
| 7014        | 1/8"     | 3.2 | 110-165  | 1/8 - 1/4"      | 3.2 - 6.4 |
| 7014        | 5/32"    | 4   | 150-210  | 1/4" - 3/8"     | 6.4 - 9.5 |
| 7014        | 3/16"    | 4.8 | 200-275  | Over 3/8"       | Over 9.5  |
| 7014        | 7/32"    | 5.6 | 255-340  | Over 3/8"       | Over 9.5  |
| 7018        | 3/32"    | 2.4 | 65-100   | 3/32 - 3/16"    | 2.4 - 4.8 |
| 7018        | 1/8"     | 3.2 | 110-165  | 1/8 - 1/4"      | 3.2 - 6.4 |
| 7018        | 5/32"    | 4   | 150-220  | 1/4" - 3/8"     | 6.4 - 9.5 |
| 7018        | 3/16"    | 4.8 | 200-275  | Over 3/8"       | Over 9.5  |
| 7018        | 7/32"    | 5.6 | 260-340  | Over 3/8"       | Over 9.5  |

# Welding Rod Guide Size Chart

**United States Employment Service**

A red circular graphic with a gradient, appearing as a partial circle or a stylized arrow pointing to the right, located to the right of the United States Employment Service text.

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