Filter Lenses for Protection Against Radiant Energy

Operations	Electrode Size 1/32 in.	Arc Current	Minimum(*) Protective Shade
Shielded metal arc welding	Less than 3	Less than 60 ...	7
	3-5	60-160	8
	5-8	160-250	10
	More than 8	250-550	11
Gas metal arc welding and flux cored arc welding		less than 60 ...	7
		60-160	10
		160-250	10
		250-500	10
Gas Tungsten arc welding		less than 50 ...	8
		50-150	8
		150-500	10
Air carbon Arc cutting	(Light)	less than 500 ..	10
	(Heavy)	500-1000	11
Plasma arc welding		less than 20 ...	6
		20-100	8
		100-400	10
		400-800	11
Plasma arc cutting	(light)(**)	less than 300 ..	8
	(medium)(**)	300-400	9
	(heavy)(**)	400-800	10
Torch brazing		.....	3
Torch soldering		.....	2
Carbon arc welding		.....	14

Filter Lenses for Protection Against Radiant Energy

Operations	Plate thickness-inches	Plate thickness-mm	Minimum(*) Protective Shade
Gas Welding:			
Light	Under 1/8	Under 3.2	4
Medium	1/8 to 1/2	3.2 to 12.7	5
Heavy	Over 1/2	Over 12.7	6
Oxygen cutting:			
Light	Under 1	Under 25	3
Medium	1 to 6	25 to 150	4
Heavy	Over 6	Over 150	5

Footnote(*) As a rule of thumb, start with a shade that is too dark to see the weld zone. Then go to a lighter shade which gives sufficient view of the weld zone without going below the minimum. In oxyfuel gas welding or cutting where the torch produces a high yellow light, it is desirable to use a filter lens that absorbs the yellow or sodium line in the visible light of the (spectrum) operation.

Footnote(**) These values apply where the actual arc is clearly seen. Experience has shown that lighter filters may be used when the arc is hidden by the workpiece.

Reference: 29 CFR 1910.133(a)(5)