

Forney SINCE 1932

Operating Manual

CAT. 00308 8/1/09

MIG/FLUX CORE WIRE WELDER 180FI



Tweco® Style Torch
Infinite Wire Speed Control
Multiple Power Settings
Thermal Overload Protection

Welds all types of:

- Mild (Carbon) Steel
- Stainless Steel
- Aluminum
- Cast Iron

Complete & Ready to Weld

Comes with: Operating Manual,
Set-Up Chart. Spool of Flux Cored
Wire, Extra Contact Tips, Chipping
Hammer & Brush Combo &
Welding Face Shield

5/3/1
WARRANTY

Ideal For:

Do-It-Yourself, Agriculture, Maintenance & Repair, Automotive,
Contractor, Metal Fabrication, Hobbyist and More...

Forney 5/3/1 Limited Warranty

Effective August 1st 2009

- 1) **Limited Warranty** – Subject to the terms and conditions below, Forney Industries, Inc., Fort Collins, Colorado, warrants to its original retail purchaser that the new Forney equipment sold after the effective date of this limited warranty is free of defects in material and workmanship at the time it is shipped by Forney. This is in lieu of all other warranties, express or implied.
- 2) **Notification:** Please call 1-800-521-6038 with your warranty questions. You can also visit forneywelding.forneyind.com for additional information about your new welder.
- 3) **Length of Warranty:** Within the warranty periods listed below, Forney will repair or replace any warranted parts or components that fall due to defects in material or workmanship. Warranty is effective from the date of original retail purchase. Warranty duration is as follows.
 - A) **5 years:** Original main power rectifiers only to include SCRs, diodes and discrete rectifier modules, transformers, stabilizers and reactors.
 - B) **3 years:** Drive Systems, PC Boards, Motors, and Switches and Controls
 - C) **1 year:** MiG guns, relays, contactors and regulators, plasma cutting torches, and accessories.
 - D) **90 days:** Replacement parts. Does not include labor.
- 4) Forney's limited warranty shall not apply to consumables such as contact tips, cutting nozzles, felt wire cleaner, drive rollers, gas diffusers, plasma torch tips and electrodes, weld cables, tips and parts that fall due to normal wear. In addition, this warranty does not extend to any damage caused by the untimely replacement or maintenance of any of the previously listed consumable parts.
- 5) **Warrantor:**
Forney Industries
1830 LaPorte Avenue
Fort Collins, CO 80521
1-800-521-6038
forneywelding.forneyind.com
- 6) **Purchaser 1 Warranty:** The original purchaser of the Forney Industries product. The warranty is not transferable. Forney Industries products are intended for purchase and use by persons trained and experienced in the use and maintenance of welding equipment.
- 7) **What is not covered under the warranty:**
 - A) Implied warranties, including those of merchantability and fitness for a particular purpose are limited in duration to this express warranty. After this period, all risks of loss, from whatever reason, shall be on the purchaser.
 - B) Any incidental, indirect, or consequential loss, damage, or expense that may result from any defect, failure or malfunction of the Forney product.
 - C) Any failure that results from accident purchaser's abuse, neglect or failure to operate products in accordance with instructions provided in the owner's manual(s) supplied with the product.
 - D) Pre-delivery service, i.e. assembly and adjustment.
- 8) **Claim:** In the event of a warranty claim under this warranty, the exclusive remedies shall be, at Forney Industries sole option:
 - A) Repair; or
 - B) Replacement; or
 - C) Where authorized in writing by Forney Industries, the cost of repair or replacement at an authorized Forney Industries service station; or
 - D) Payment of or credit for the purchase price less reasonable depreciation based on actual use upon the return of the goods at the customer's risk and expense.
- 9) **Purchaser will:**
 - A) Contact Forney's customer service at 1-800-521-6038 within 30 days of the defect or failure.
 - B) Provide dated proof of purchase (typically a purchase receipt).
 - C) Provide the serial number. Registering your welder at forneywelding.forneyind.com will speed up this process.
 - D) Deliver or ship welder to a Forney authorized service center. Freight &/or packaging costs, if any, must be borne by the purchaser.

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SAFETY SUMMARY

Every welder respects the tools with which they work. They know that the tools represent years of constantly improved designs and developments. The true craftsman also knows that tools are dangerous if misused or abused.

Reading this operator's manual before using the welder will enable you to do a better, safer job. Learn the welder's applications and limitations as well as the specific potential hazards peculiar to welding.

IMPORTANT SAFETY INFORMATION

The following safety information is provided as guidelines to help you operate your new welder under the safest possible conditions. Any equipment that uses electrical power can be potentially dangerous to use when safety or safe handling instructions are not known or not followed. The following safety information is provided to give the user the information necessary for safe use and operation.

A procedure step preceded by a **WARNING** is an indication that the next step contains a procedure that might be injurious to a person if proper safety precautions are not heeded.

A procedure preceded by a **CAUTION** is an indication that the next step contains a procedure that might damage the equipment being used.

A **NOTE** may be used before or after a procedure step to highlight or explain something in that step.

READ ALL SAFETY INSTRUCTIONS CAREFULLY before attempting to install, operate, or service this welder. Failure to comply with these instructions could result in personal injury and/or property damage.

RETAIN THESE INSTRUCTIONS FOR FUTURE REFERENCE.

Note:

- The following safety alert symbols identify important safety messages in this manual.

- When you see one of the symbols shown here, be alert to the possibility of personal injury and carefully read the message that follows.



This symbol indicates that the possibility of electric shock hazard exists during the operation of the step(s) that follow.



This symbol indicates that the possibility of fire hazard exists during the operation of the step(s) that follow.



This symbol indicates that the helmet must be worn during the step(s) that follow to protect against eye damage and burns due to flash hazard.



This symbol indicates that the possibility of toxic gas hazard exists during operation of the step(s) that follow.



This symbol indicates that the possibility of being burned by hot slag exists during operation of the step(s) that follow.



This symbol indicates that the eye protection should be worn to protect against flying debris in the following step(s).



This symbol indicates that the possibility of injury or death exists due to improper handling and maintenance of compresses gas cylinders or regulators.

- Published standards on safety are available. They are listed in **ADDITIONAL SAFETY INFORMATION** at the end of this **SAFETY SUMMARY**.

The National Electrical Code, Occupation Safety and Health Act regulations, local industrial codes and local inspection requirements also provide a basis for equipment installation, use, and service.

SHOCK HAZARD



WARNING

ELECTRIC SHOCK CAN KILL! To reduce the risk of death or serious injury from shock, read, understand, and follow the following safety instructions. In addition, make certain that anyone else who uses this welding equipment, or who is a bystander in the welding area understands and follows these safety instructions as well.

- **IMPORTANT! TO REDUCE THE RISK OF DEATH, INJURY, OR PROPERTY DAMAGE, DO NOT ATTEMPT OPERATION** of this welding equipment until you have read and understand the following safety summary.
- Do not, in any manner, come into physical contact with any part of the welding current circuit. The welding current circuit includes:
 - a. the work piece or any conductive material in contact with it,
 - b. the ground clamp,
 - c. the electrode or welding wire,
 - d. any metal parts on the electrode holder, or wire feed gun.
- Do not weld in a damp area or come in contact with a moist or wet surface.
- Do not attempt to weld if any part of clothing or body is wet.
- Do not allow the welding equipment to come in contact with water or moisture.
- Do not drag welding cables, wire feed gun, or welder power cord through or allow them to come into contact with water or moisture.
- Do not touch welder, attempt to turn welder on or off if any part of the body or clothing is moist or if you are in physical contact with water or moisture.
- Do not attempt to plug the welder into the power source if any part of body or clothing is moist, or if you are in physical contact with water or moisture.
- Do not connect welder work piece clamp to or weld on electrical conduit.
- Do not alter power cord or power cord plug in any way.
- Do not attempt to plug the welder

into the power source if the ground prong on power cord plug is bent over, broken off, or missing.

- Do not allow the welder to be connected to the power source or attempt to weld if the welder, welding cables, welding site, or welder power cord are exposed to any form of atmospheric precipitation, or salt water spray.
- Do not carry coiled welding cables around shoulders, or any other part of the body, when they are plugged into the welder.
- Do not modify any wiring, ground connections, switches, or fuses in this welding equipment.
- Wear welding gloves to help insulate hands from welding circuit.
- Keep all liquid containers far enough away from the welder and work area so that if spilled, the liquid can not possibly come in contact with any part of the welder or electrical welding circuit.
- Replace any cracked or damaged parts that are insulated or act as insulators such as welding cables, power cord, or electrode holder **IMMEDIATELY**.

FLASH HAZARDS



WARNING

ARC RAYS CAN INJURE EYES AND BURN SKIN!

To reduce the risk of injury from arc rays, read, understand, and follow the following safety instructions. In addition, make certain that anyone else that uses this welding equipment, or is a bystander in the welding area understands and follows these safety instructions as well. Headshields and filter should conform to ANSI Z87.1 standards.

- Do not look at an electric arc without proper protection. A welding arc is extremely bright and intense and, with inadequate or no eye protection, the retina can be burned, leaving a permanent dark spot in the field of vision. A shield or helmet with a number 10 shade filter lens (minimum) must be used.
- Do not strike a welding arc until all bystanders and you (the welder) have welding shields and/or helmets in place.
- Do not wear a cracked or broken

helmet and replace any cracked or broken filter lenses IMMEDIATELY.

- Do not allow the uninsulated portion of the wire feed gun to touch the ground clamp or grounded work to prevent an arc flash from being created on contact.
- Provide bystanders with shields or helmets fitted with a #10 shade filter lens.
- Wear protective clothing. The intense light of the welding arc can burn the skin in much the same way as the sun, even through light-weight clothing. Wear dark clothing of heavy material. The shirt worn should be long sleeved and the collar kept buttoned to protect chest and neck.
- Protect against REFLECTED ARC RAYS. Arc rays can be reflected off shiny surfaces such as a glossy painted surface, aluminum, stainless steel, and glass. It is possible for your eyes to be injured by reflected arc rays even when wearing a protective helmet or shield. If welding with a reflective surface behind you, arc rays can bounce off the surface, then off the filter lens on the inside of your helmet or shield, then into your eyes. If a reflective background exists in your welding area, either remove it or cover it with something non-flammable and non-reflective. Reflective arc rays can also cause skin burn in addition to eye injury.

FIRE HAZARDS



WARNING

FIRE OR EXPLOSION CAN CAUSE DEATH, INJURY, AND PROPERTY DAMAGE! To reduce the risk of death, injury, or property damage from fire or explosion, read, understand, and follow the following safety instructions. In addition, make certain that anyone else that uses this welding equipment, or is a bystander in the welding area, understands and follows these safety instructions as well. REMEMBER! Arc welding by nature produces sparks, hot spatter, molten metal drops, hot slag, and hot metal parts that can start fires, burn skin, and damage eyes.

- Do not wear gloves or other clothing that contains oil, grease, or other flammable substances.

- Do not wear flammable hair preparations.
- Do not weld in an area until it is checked and cleared of combustible and/or flammable materials. BE AWARE that sparks and slag can fly 35 feet and can pass through small cracks and openings. If work and combustibles cannot be separated by a minimum of 35 feet, protect against ignition with suitable, snug-fitting, fire resistant, covers or shields.
- Do not weld on walls until checking for and removing combustibles touching the other side of the walls.
- Do not weld, cut, or perform other such work on used barrels, drums, tanks, or other containers that had contained a flammable or toxic substance. The techniques for removing flammable substance and vapors, to make a used container safe for welding or cutting, are quite complex and require special education and training.
- Do not strike an arc on a compressed gas or air cylinder or other pressure vessel. Doing so will create a brittle area that can result in a violent rupture immediately or at a later time as a result of rough handling.
- Do not weld or cut in an area where the air may contain flammable dust (such as grain dust), gas, or liquid vapors (such as gasoline).
- Do not handle hot metal, such as the work piece or electrode stubs, with bare hands.
- Wear leather gloves, heavy long sleeve shirt, cuffless trousers, high-topped shoes, helmet, and cap. As necessary, use additional protective clothing such as leather jacket or sleeves, fire resistant leggings, or apron. Hot sparks or metal can lodge in rolled up sleeves, trouser cuffs, or pockets. Sleeves and collars should be kept buttoned and pockets eliminated from the shirt front.
- Have fire extinguisher equipment handy for immediate use! A portable chemical fire extinguisher, type ABC, is recommended.
- Wear ear plugs when welding overhead to prevent spatter or slag from falling into ear.
- Make sure welding area has a good, solid, safe floor, preferably concrete or masonry, not tiled, carpeted, or made of

- any other flammable material.
- Protect flammable walls, ceilings, and floors with heat resistant covers or shields.
- Check welding area to make sure it is free of sparks, glowing metal or slag, and flames before leaving the welding area.

FUME HAZARDS



WARNING

FUMES, GASSES, AND VAPORS CAN CAUSE DISCOMFORT, ILLNESS, AND DEATH!

To reduce the risk of discomfort, illness, or death, read, understand, and follow the following safety instructions. In addition, make certain that anyone else that uses this welding equipment or is a bystander in the welding area, understands and follows these safety instructions as well.

- Do not weld in an area until it is checked for adequate ventilation as described in ANSI standard #Z49.1. If ventilation is not adequate to exchange all fumes and gasses generated during the welding process with fresh air, do not weld unless you (the welder) and all bystanders are wearing air-supplied respirators.
- Do not heat metals coated with, or that contain, materials that produce toxic fumes (such as galvanized steel), unless the coating is removed. Make certain the area is well ventilated, and the operator and all bystanders are wearing air-supplied respirators.
- Do not weld, cut, or heat lead, zinc, cadmium, mercury, beryllium, or similar metals without seeking professional advice and inspection of the ventilation of the welding area. These metals produce **EXTREMELY TOXIC** fumes which can cause discomfort, illness, and death.
- Do not weld or cut in areas that are near chlorinated solvents. Vapors from chlorinated hydrocarbons, such as trichloroethylene and perchloroethylene, can be decomposed by the heat of an electric arc or its ultraviolet radiation. These actions can cause **PHOSGENE**, a HIGH-

LY **TOXIC** gas to form, along with other lung and eye-irritating gasses. Do not weld or cut where these solvent vapors can be drawn into the work area or where the ultraviolet radiation can penetrate to areas containing even very small amounts of these vapors.

- Do not weld in a confined area unless it is being ventilated or the operator (and anyone else in the area) is wearing an air-supplied respirator.
- Stop welding if you develop momentary eye, nose, or throat irritation as this indicates inadequate ventilation. Stop work and take necessary steps to improve ventilation in the welding area. Do not resume welding if physical discomfort persists.

COMPRESSED GASSES AND EQUIPMENT HAZARDS



WARNING IMPROPER

HANDLING AND MAINTENANCE OF COMPRESSED GAS CYLINDERS AND REGULATORS CAN RESULT IN SERIOUS INJURY OR DEATH!

To reduce the risk of injury or death from compressed gasses and equipment hazards, read, understand, and follow the following safety instructions. In addition, make certain that anyone else who uses this welding equipment or a bystander in the welding area understands and follows these safety instructions as well.

- Do not use flammable gasses with MIG welders. Only inert or nonflammable gasses are suitable for MIG welding. Examples are Carbon Dioxide, Argon, Helium, etc. or mixtures of more than one of these gasses.
- Do not attempt to mix gasses or refill a cylinder yourself. Do not expose cylinders to excessive heat, sparks, slag and flame, etc. Cylinders exposed to temperatures above 130°F will require water spray cooling.
- Do not expose cylinders to electricity of any kind.
- Do not use a cylinder or its contents for

anything other than its intended use. Do not use as a support or roller.

- Do not locate cylinders in passageways or work area where they may be struck.
- Do not use a wrench or hammer to open a cylinder valve that cannot be opened by hand. Notify your supplier.
- Do not modify or exchange gas cylinder fittings.
- Do not deface or alter name, number or other markings on a cylinder. Do not rely on cylinder color to identify the contents.
- Do not connect a regulator to a cylinder containing gas other than that for which the regulator was designed.
- Do not attempt to make regulator repairs. Send faulty regulators to manufacturer's designated repair center for repair.
- Do not attempt to lubricate a regulator.
- Always change cylinders carefully to prevent leaks and damage to their walls, valves, or safety devices.
- Always secure cylinders with a steel chain so that they cannot be knocked over.
- Always protect a cylinder, especially the valve, from bumps, falls, falling objects and weather. Remember that gasses in the cylinders are under pressure and damage to a regulator can cause the regulator or portion of the regulator to be explosively ejected from the cylinder.
- Always make certain the cylinder cap is securely in place on the cylinder, whenever the cylinder is moved.
- Always close the cylinder valve and immediately remove a faulty regulator from service, for repair, if any of the following conditions exist.
- Gas leaks externally.
- Delivery pressure continues to rise with down stream valve closed.
- The gauge pointer does not move off the stop pin when pressurized or fails to return to the stop pin after pressure is released.

WARNING

This product contains chemicals, including lead, or otherwise produces chemicals known to the State of California to cause cancer, birth defects and other reproductive harm. **Wash hands after Handling.** (California Health & Safety Code Sec. 25249.5 et seq.)

ADDITIONAL SAFETY INFORMATION

For additional information concerning welding safety, refer to the following standards and comply with them as applicable.

- ANSI Standard Z49.1 – SAFETY IN WELDING AND CUTTING – obtainable from the American Welding Society, 550 NW Le Jeune Road, Miami, FL 33126 Telephone (800) 443-9353, Fax (305) 443-7559 – www.amweld.org or www.aws.org
- ANSI Standard Z87.1 – SAFE PRACTICE FOR OCCUPATION AND EDUCATIONAL EYE AND FACE PROTECTION – obtainable from the American National Standards Institute, 11 West 42nd St., New York, NY 10036 Telephone (212) 642-4900, Fax (212) 398-0023 – www.ansi.org
- NFPA Standard 51B – CUTTING AND WELDING PROCESS – obtainable from the National Fire Protection Association, 1 Batterymarch Park, P.O. Box 9101, Quincy, MA 02269-9101 Telephone (617) 770-3000 Fax (617) 770-0700 – www.nfpa.org
- OSHA Standard 29 CFR, Part 1910, Subpart Q., WELDING, CUTTING AND BRAZING – obtainable from your state OSHA office or U.S. Dept. of Labor OSHA, Office of Public Affairs, Room N3647, 200 Constitution Ave., Washington, DC 20210 – www.osha.gov
- CSA Standard W117.2 – Code for SAFETY IN WELDING AND CUTTING. – obtainable from Canadian Standards Association, 178 Rexdale Blvd., Etobicoke, Ontario M9W 1R3 – www.csa.ca
- American Welding Society Standard A6.0. WELDING AND CUTTING CONTAINERS WHICH HAVE HELD COMBUSTIBLES. – obtainable from the American Welding Society, 550 NW Le Jeune Road, Miami, FL 33126 Telephone (800) 443-9353, Fax (305) 443-7559 – www.amweld.org or www.aws.org

WELDER SPECIFICATIONS

DESCRIPTION

Your new MIG (GMAW) flux core (FCAW) wire feed welder is designed for maintenance and sheet metal fabrication. The welder consists of a single-phase power transformer, stabilizer, rectifier, and a unique built-in control/feeder.

Now you can weld sheet metal from 24 gauge up to 1/4 inch thick with a single pass. You can weld thicker steel with beveling and multiple pass techniques. Table 1 lists your MIG welder specifications.

Table 1. Welder Specifications

Primary (input) volts	230 VAC
Primary (input) Amps	22.5
Phase	Single
Frequency	60Hz
Secondary (output) volts	20
CSA rated output amps	120
Open Circuit Volts (Max.)	30 VDC
Duty Cycle Rating	25%

MIG welders equipped with gas are capable of welding with 0.024 (0.6mm), 0.030 (0.8mm), and 0.035 (0.9mm) solid steel, bronze or aluminium wire on DC reverse polarity and with 0.030 (0.8mm) and 0.035 (0.9mm) self-shielding flux-core wire on DC straight polarity. The use of larger diameter wire makes welding difficult and the results cannot be guaranteed. Use of larger than .035 diameter wire is not recommended.

WELDER OPERATING CHARACTERISTICS

DUTY CYCLE

The duty cycle rating of a welder defines how long the operator can weld and how long the welder must be rested and cooled. Duty cycle is expressed as a percentage of 10 minutes and represents the maximum welding time allowed. The balance of the 10-minute cycle is required for cooling. Your new welder has a duty cycle rating of 25% at the rated output. This means that you can weld for 2.5 minutes out of 10 with the remaining 7.5 minutes required for cooling. (See Table 2).

Table 2. Duty Cycle Ratings

Duty Cycle Rating	Maximum Welding Time	Required Resting Time
10%	1 minutes	9 minutes
25%	2.5 minutes	7.5 minutes
50%	5 minutes	5 minutes
75%	7.5 minutes	2.5 minutes
100%	10 minutes	0 minutes

INTERNAL THERMAL PROTECTION

CAUTION

Do not constantly exceed the duty cycle or damage to the welder can result. If you exceed the duty cycle of the welder, an internal thermal protector will open, shutting off all welder functions except the cooling fan. If this happens, DO NOT SHUT OFF THE WELDER. Leave the welder turned on with the fan running. After cooling, the thermal protector will automatically reset and the welder will function normally again. However you should wait at least ten minutes after the thermal protector opens before resuming welding. You must do this even if the thermal protector resets itself before the ten minutes is up or you may experience less than specified duty cycle performance.

If you find that the welder will not weld for two minutes without stopping, reduce the wire speed slightly and tune in the welder at the lowest wire speed setting that still produces a smooth arc. Welding with the wire speed set too high causes excessive current draw and shortens the duty cycle.

KNOW YOUR WELDER

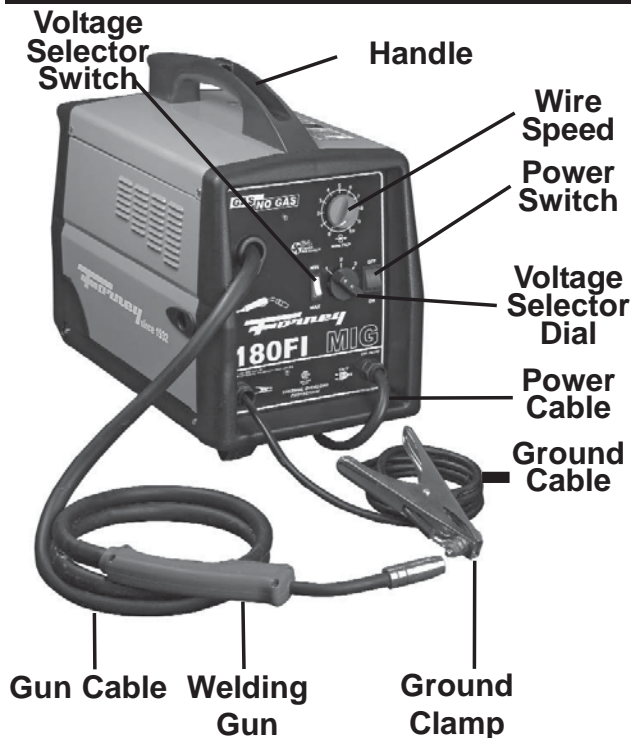


Figure 1. Model Cat. 00308

Handle – Rugged, top mounted handle allows for easy transport of your welder.

Wire Speed Control – Use this dial to adjust the speed at which the welder feeds wire to the gun. 1 is the slowest wire feed speed, 10 is the highest. You will need to adjust or “tune-in” your wire speed for different welding conditions (thickness of metals, gas -vs- gas-less welding, metal type, wire size, etc.). When the wire speed is properly “tuned-in” the welding wire will melt into the material you are welding as quickly as it is fed through the welding gun.

Voltage Selectors – The voltage selectors control the weld heat. There are six voltage heat selections available on this welder. Lower voltage (less heat) is achieved by setting the **Voltage Selector Switch** to the MIN position and/or the **Voltage Selector Switch** to a lower number. Higher voltage (more heat) is achieved by setting the **Voltage Selector Switch** to the MAX position and/or the **Voltage Selector Switch** to a higher number. Different materials and material thickness will require different voltage settings. You will need to adjust your voltage accordingly for different welding conditions. By properly adjusting your voltage settings and wire feed speed, you will enable clean,

precision welds. (Refer to the Suggested Settings Chart on p.33 of this manual OR on the inside of the door of the welder.)

Power Switch – This switch turns the welder ON and OFF. (Make sure the power switch is in the OFF position before performing any maintenance on the welder.)

Power Cord – This is a standard, 230 volt power cord with a NEMA 6-50P 50 amp plug. (Make sure you are using a properly grounded 230 VAC, 60Hz, single phase, 50 amp power source.)

Ground Clamp – Attaching the ground clamp to your work piece completes the welding current circuit. You must attach the ground clamp to the metal you are welding. If the ground clamp is not connected to the metal work piece you intend to weld, the welder will not have a completed circuit and you will be unable to weld. A poor connection at the ground clamp will waste power and heat. Scrape away dirt, rust, scale, oil or paint before attaching the ground clamp.

Ground Cable – The ground cable connects the ground clamp to the internal workings of the welder.

Welding Gun and Cable – The welding gun controls the delivery of the welding wire to the material to be welded. The welding wire is fed through the welding cable and welding gun when the welding gun trigger is pulled. You will need to install a contact tip and welding nozzle to the end of the welding gun, as described later in this manual, prior to welding.

Welding Terms

Now that you are familiar with the main parts of the welder, make note of the following terms. You will see them used throughout this manual.

weld puddle: The localized volume of molten metal in a weld prior to its solidification.

weld angle: The angle of the welding wire, as it extends from the welding gun, in relation to the item being welded.

slag: The protective coating that forms on the surface of molten metal.

arc: A sustained luminous discharge of electricity across a gap in a circuit.

welding bead: The extended build up of a weld, made by pushing or pulling the weld puddle.

WELDER INSTALLATION

POWER SOURCE CONNECTION

POWER REQUIREMENTS

This welder is designed to operate on a properly grounded 230 volt, 60Hz, single-phase alternating current (AC) power source fused with a 50 amp time delayed fuse or circuit breaker. It is recommended that a qualified electrician verify the *ACTUAL VOLTAGE* at the receptacle into which the welder will be plugged and confirm that the receptacle is properly fused and grounded. The use of the proper circuit size can eliminate nuisance circuit breaker tripping when welding.

DO NOT OPERATE THIS WELDER if the *ACTUAL* power source voltage is less than 198 volts AC or greater than 240 volts AC. Contact a qualified electrician if this problem exists. Improper performance and/or damage to the welder will result if operated on inadequate or excessive power.

CONNECT TO POWER SOURCE



WARNING

High voltage danger from power source!

Consult a qualified electrician for proper installation of receptacle at the power source.

This welder must be grounded while in use to protect the operator from electrical shock. If you are not sure if your outlet is properly grounded, have it checked by a qualified electrician. Do not cut off the grounding prong or alter the plug in any way and do not use any adapters between the welder's power cord and the power source receptacle. Make sure the POWER switch is OFF then connect your welder's power cord to a properly grounded 230 VAC, 60 Hz, single phase, 50 amp power source.

EXTENSION CORDS

For optimum welder performance, an extension cord should not be used unless absolutely necessary. If necessary, care must be taken in selecting an extension cord appropriate for use with your specific welder.

Select a properly grounded extension cord that will mate directly with the power source receptacle

and the welder power cord without the use of adapters. Make certain that the extension is properly wired and in good electrical condition. Extension cords must be a #12 gauge cord at the smallest. Do not use an extension cord over 25 ft. in length.

ASSEMBLING THE WELDER

The following procedures describe the process required to assemble, install, maintain, and prepare to weld with your new wire feed welder.

UNPACKING THE WELDER

1. Remove any cartons or bags containing parts/accessories. (Most parts are shipped *INSIDE* the welder door.)
2. Open the cartons or bags packed with your welder and inspect their contents for damage.
3. Layout the parts and compare them to the packing list in Table 3 to familiarize yourself with the parts and what they are called. This will help you when reading the manual.

PACKING LIST

Table 3 contains a list of the items you will find packed in the carton.

Table 3. Packing List

ITEM	QTY.
Welder	1
Face Shield	1
Face Shield Handle	1
Face Shield Handle Cover	1
Face Shield Retaining Clips	2
Shaded Lens	1
Welder Handle	1
Handle Screws	2
Front and Back Feet	1 ea.
Feet Screws	4
Wire Brush/Hammer	1
Parts Bag	1
Set Screw	1
Contact Tip .024-.030-.040	1 ea.
Nozzle	1
Wire .035 Fluxcore	1/2 lb.
Manual, Instruction	1

ASSEMBLE THE FACE SHIELD

1. Insert the upper tongue of the handle into the upper slot on the face shield.
2. Align the second tab on the handle with the second slot in the face shield by pushing the

bottom of the handle in towards the face mask, while at the same time pushing upwards. (Alignment of the second tab is made easier by applying pressure to the point shown below.)

- Once the handle tabs are properly seated in the face shield slots, install the handle cover by firmly pushing it into the recessed area on the face shield.
 - Install the dark glass by sliding it into place behind the glass retaining tabs.
- Note: if your face shield was supplied with a 3" x 3.8" dark glass you may choose to remove the extra material from the face shield to allow a larger field of vision when welding. To remove the extra material, remove the glass from the face shield and carefully cut the material out of the face shield with a utility knife.
- Once protective dark glass has been installed into face shield, secure it in place with the retaining clips. Align the holes on each of the retaining clips with the pins on the retaining tabs and firmly press into place.

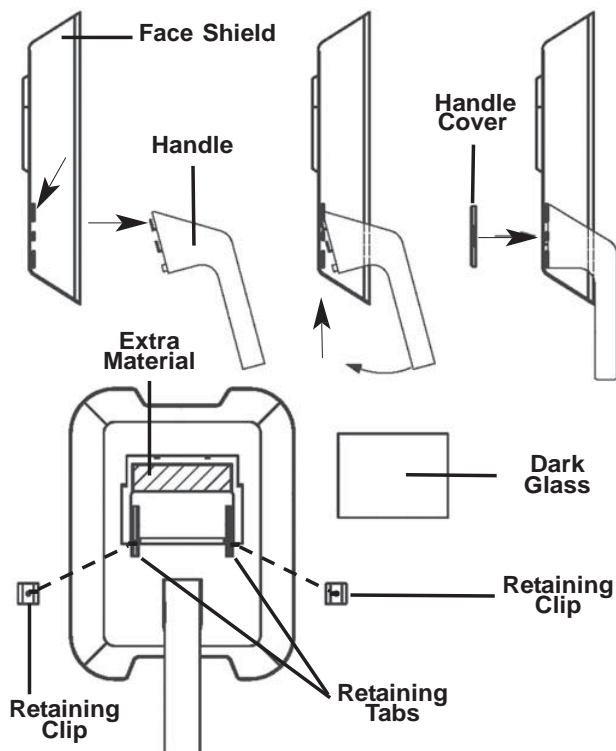


Figure 2. Face Shield Assembly

INSTALLING THE HANDLE

- Insert the tabs of the welder handle into the slots provided on the top of the welder.
- Insert a large flat head screw (included in the accessories bag) into each hole on the top of the welder handle.
- With a flat tip screwdriver, securely tighten both screws. (see Figure 3)

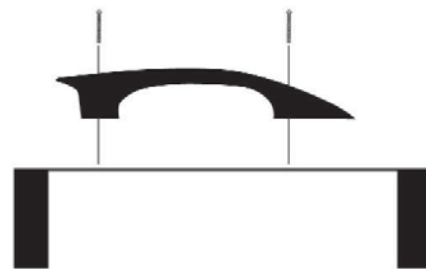


Figure 3. Handle Installation

INSTALLING THE FEET

Locate the two black plastic feet for the welder. (The front feet are slightly larger than the back feet.)

- Lay the welder on its side.
- Align the holes of the front feet with the front screw holes on the bottom of the welder. The curved face of the front feet should face the front of the welder.
- Insert the two Phillips head screws (included in the accessories bag) into the holes.
- With a Phillips head screwdriver, securely tighten both screws.
- Align the holes of the back feet with the rear screw holes on the bottom of the welder. The curved face of the back feet should face the rear of the welder.
- Insert the two Phillips head screws (included in the accessories bag) into the holes.
- With a Phillips head screwdriver, securely tighten both screws. (see Figure 4)



Figure 4. Feet Installation

SELECTING SHIELDING GAS

The shielding gas plays an extremely important role in the MIG welding process. It is critical that the molten weld puddle be shielded from the atmosphere. The shielding gas creates a protective pocket around the weld puddle which keeps impurities in the air from contaminating the weld. Inadequate shielding will result in porous, brittle welds.

Although there are many gasses and gas mixtures available for MIG welding, the fol-

lowing recommendations are based on the electrical output characteristics and metal thickness capabilities of this specific MIG welder.

Gas Selection For Steel Welding With Steel Wire

For either mild or low carbon (High Strength Structural) steel, use a gas mixture of 75% Argon and 25% Carbon Dioxide. DO NOT USE Argon gas concentrations higher than 75% on steel. The result will be extremely poor penetration, porosity, and brittleness of weld.

This gas mixture helps to prevent burn through and distortion on very thin steel yet provides good penetration on thicker steel. Its ability to minimize spatter results in clean, smooth weld appearances. In addition, it provides good puddle control when welding vertically or overhead.

Gas Selection For Stainless Steel Welding

The best shielding gas for stainless steel welding is a mixture of 90% Helium, 7.5% Argon, and 2.5% Carbon Dioxide. However, the 100% Argon, can also be used, but an increase in the area being heated by the arc will be experienced causing slightly greater distortion of the base metal.

Gas Selection For Steel Welding With Silicon Bronze Wire

Use only pure Argon when welding steel with Silicon-Bronze wire.

Gas Selection For Aluminium Welding with Aluminium Wire

Use only pure Argon when welding Aluminium.

INSTALLING THE SHIELDING GAS



WARNING

IMPROPER HANDLING AND MAINTENANCE OF COMPRESSED GAS CYLINDERS AND REGULATORS CAN RESULT IN SERIOUS INJURY OR DEATH! Always secure gas cylinders to the welding cart, a wall, or other fixed support to prevent the cylinder from falling over and rupturing. Read, understand, and follow all the COMPRESSED GASSES AND

EQUIPMENT HAZARDS in the SAFETY SUMMARY at the front of this manual. Secure your gas cylinder to the welding cart, or other fixed support.

1. Remove the protective cap from the cylinder and inspect the regulator connecting threads for dust, dirt, oil, and grease. Remove any dust or dirt with a clean cloth. DO NOT ATTACH YOUR REGULATOR IF OIL, GREASE, OR DAMAGE ARE PRESENT.
2. Open the cylinder valve FOR JUST AN INSTANT to blow out any foreign matter inside the valve port. Never aim the open valve cylinder port at yourself or bystanders.
3. Screw the regulator into the cylinder valve and tighten with a wrench.
4. Firmly push the gas hose over barbed fittings on back of welder and regulator.
5. Secure both ends of hose onto barbed fittings with hose clamps.

CHECK THE GAS FLOW



WARNING

IMPROPER HANDLING AND MAINTENANCE OF COMPRESSED GAS CYLINDERS AND REGULATORS CAN RESULT IN SERIOUS INJURY OR DEATH. To reduce the risk of injury or death, always stand to the side of the cylinder opposite the regulator when opening the cylinder valve, keeping the cylinder valve between you and the regulator. Never aim the open cylinder valve port at yourself or bystanders. Failure to comply with this warning could result in serious personal injury.

Note: If the cylinder you have is equipped with male regulator connecting threads instead of female, you will need to obtain a special compressed gas cylinder adaptor from your gas supplier to install between your gas cylinder and regulator.

- The gas control function does not require the welder to be turned on or plugged in.
- To avoid damage to your regulator, make sure you have the regulator valve closed before opening the cylinder valve.

1. Slowly crack open the cylinder valve, then

- turn open ALL THE WAY.
2. Pull the trigger on the gun to allow the gas to flow. **KEEP THE TRIGGER PULLED.** Listen and feel for gas flowing from the end of the welding gun. If your regulator has no adjustment, it has been preset at the factory for a flow of 20 cubic feet per hour. If your gas regulator has an adjustment to control the gas flow rate, turn the adjustment key clockwise to increase gas flow; counterclockwise to reduce flow. For most welding, the gas flow should be set at 15-20 cubic feet per hour. If no gas is heard or felt, verify all steps involved in connecting the gas.
 3. Release the trigger.

Note: If welding outside or in a draft, it may become necessary to set up a wind break to keep the shielding gas from being blown from the weld area.

-MAKE SURE TO TURN OFF THE GAS CYLINDER VALVE WHEN DONE WELDING.

ALIGN AND SET THE DRIVE ROLLER

Before installing any welding wire into the unit, the proper sized groove must be placed into position on the wire drive mechanism.

Change the drive roller according to the following steps:

1. Remove the drive tension by unscrewing the tension adjusting screw (**ALL THE WAY** in a counterclockwise direction). The drive tension screw will come loose, allowing you to pull the drive tension arm up away from the drive roller. Make sure to keep the screw and the spring in place with the drive tension arm.
2. If there is wire already installed in the welder, roll it back onto the wire spool by hand-turning the spool counter-clockwise. Be careful not to allow the wire to come out of the rear end of the gun without holding onto it or it will unspool itself. Put the end of the wire into the hole on the outside edge of the wire spool and bend it over to hold the wire in place. Remove the spool of wire from the welder.
3. Loosen the drive roller set screw with the provided hex wrench and pull the drive roller off the drive shaft.

Note: The drive roller has two wire size grooves built into it. When installing the drive roller the number stamped on the drive roller for the wire size you are using should be facing away from you. If you can read the wire size you are using on the drive roller, it is installed backwards. Use only the proper size drive roller when using your welder.

4. Find the side of the drive roller that is stamped with the same wire diameter as that of the wire being installed (see Figure 5, and if in metric, see DESCRIPTION). Push the drive roller onto the motor shaft, aligning the set screw with the flat side of the drive shaft. Make sure the side stamped with the desired wire diameter is away from you.

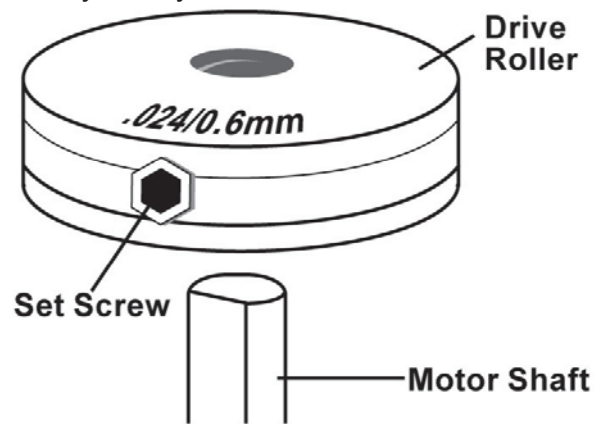


Figure 5. Drive Roller

5. Slide the roller onto the shaft so that the groove in the roller lines up with the inlet tube and the welding gun liner.
6. Tighten the set screw, while holding the drive roller in place.

INSTALL THE WELDING WIRE



WARNING

Electric shock can kill! Always turn the POWER switch OFF and unplug the power cord from the ac power source before installing wire.

Be very careful when removing the welding nozzle. The contact tip on this welder is electrically hot as long as POWER is turned ON. Make certain POWER is turned OFF.

1. Remove the nozzle and contact tip from

the end of the gun assembly.

2. Make sure the proper groove on the drive roller is in place for the wire being installed. If the proper groove is not in place, change the drive roller as described above.
3. Unwrap the spool of wire and then find the leading end of the wire (it goes through a hole in the outer edge of the spool and is bent over the spool edge to prevent the wire from unspooling), BUT DO NOT UNHOOK IT YET.
4. Place the spool on the spindle in such a manner that when the wire comes off the spool, it will look like the top illustration in Figure 6. The welding wire should always come off the top of the spool into the drive mechanism.

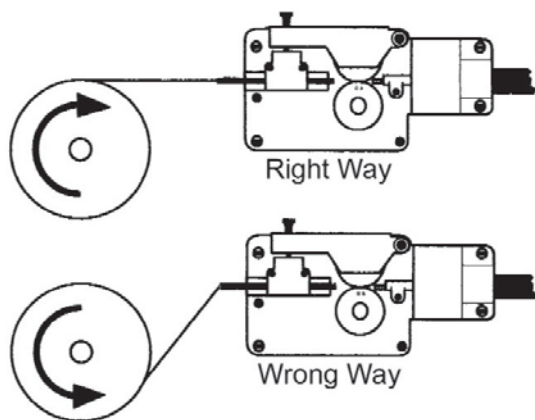


Figure 6. Wire Installation

5. If you are installing a four-inch spool of wire, install the drive brake hardware on the top of the spool of wire according to figure 7A. If you are installing an eight-inch spool, install the spindle adapter and drive brake hardware as shown in Figure 7B.

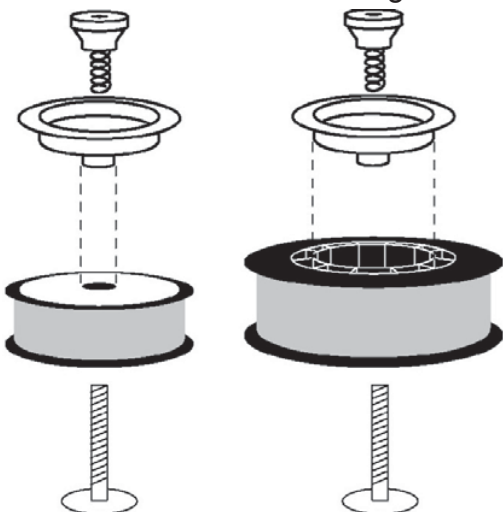


Figure 7A. Drive Brake Hardware Installation

Figure 7B. Spindle Adapter and Drive Brake Installation

The purpose of the drive brake is to cause the spool of wire to stop turning at nearly the same moment that wire feeding stops.

6. Once the drive brake hardware is installed, set the spool tension. With one hand, turn the wire spool and continue turning it while adjusting the tension on the spool. With your free hand, tighten (turn clockwise) the knob that holds the spool in place. Stop tightening when drag is felt on the wire spool that you are turning, then stop hand-turning the wire spool.

Note: If TOO MUCH tension is applied to the wire spool, the wire will slip on the drive roller or will not be able to feed at all. If TOO LITTLE tension is applied, the spool of wire will want to unspool itself. Readjust the drive brake tension as necessary to correct for either problem.

7. After checking to make sure that your welder is disconnected from the ac power source, free the leading end of the wire from the spool, but do not let go of it until told to do so, or the wire will unspool itself.
8. Use a wire cutter, cut the bent end off the leading end of the wire so that only a straight leading end remains.
9. Loosen the tension adjusting screw holding the drive tension arm in place and lift the tension arm up off the drive roller.
10. Insert the leading end of the wire into the inlet guide tube. Then push it across the drive roller and into the gun assembly about six inches.

CAUTION

Make certain that the welding wire is actually going into the gun liner. Be very sure it has not somehow been accidentally been routed alongside the liner or even in some other direction. If this should happen, the wire could feed inside the cable casing or take a right angle and follow the wires and gas hose inside the welder. It could also feed back on itself jamming up the mechanism.

11. Line the wire up in the inside groove of the drive roller, then allow the drive tension arm to drop onto the drive roller.
12. Flip the quick release drive tensioner back up into position on the drive tensioner arm.
13. Tighten (turn clockwise) the drive tension adjusting screw until the tension roller is applying enough force on the wire to prevent it from slipping out of the drive assembly.
14. Let go of the wire.

15. Connect the welder power cord to the ac power source. Turn the welder ON by setting the VOLTAGE switch to the voltage (heat) setting recommended for the gauge metal that is to be welded. Refer to the label mounted on the cover, inside the drive compartment, for recommended voltage (heat) settings for your welding job. The VOLTAGE selector controls the weld heat. There are six voltage heat selections available on this welder. Placing the voltage switch in MIN position, and the voltage dial in position 1 provides the lowest voltage (heat). Placing the voltage switch in MAX position, and the voltage dial in position 3 provides the highest voltage (heat).
 16. Set the WIRE SPEED control to the middle of the wire speed range.
 17. Straighten the gun cable and pull the trigger on the welding gun to feed the wire through the gun assembly.
 18. When at least an inch of wire sticks out past the end of the gun, release the trigger.
 19. Select a contact tip stamped with the same diameter as the wire being used. If stamped in metric see DESCRIPTION.
- Note:** Due to inherent variances in flux-cored welding wire, it may be necessary to use a contact tip one size larger than your flux core wire if wire jams occur.
20. Slide the contact tip over the wire (protruding from the end of the gun). Thread the contact tip into the end of the gun and hand-tighten securely.
 21. Install the nozzle on the gun assembly. For best results, coat the inside of the nozzle with anti-stick spray or gel.
 22. Cut off the excess wire that extends past the end of the nozzle.

SET THE WIRE DRIVE TENSION



WARNING

Arc flash can injure your eyes! To reduce the risk of arc flash, make certain that the wire coming out of the end of the gun does not come in contact with work piece, ground clamp or any grounded material during the drive tension setting process or arcing will occur.

1. Pull the trigger on the gun.
2. Turn the drive tension adjustment knob clockwise, increasing the drive tension until the wire seems to feed smoothly without slipping.

When set correctly, there should be no slippage between the wire and the drive roller under normal conditions. If an obstruction occurs along the wire feed path, the wire should then slip on the drive roller.

After the tension is properly adjusted, the quick release drive tensioner may be unlocked and relocked and no readjustment of the drive tension adjustment knob will be necessary (unless the diameter or type of wire is changed).

INSTALLING ALUMINIUM WIRE

Install aluminium wire the same as steel wire, but with the following exceptions:

1. Install a plastic liner in the welding gun.
2. Adjust the drive tension VERY carefully. Aluminium wire is very sensitive to slight changes in drive tension.

Note: For welding aluminium with this unit, 5356 alloy wire is recommended because of its superior feedability. A plastic liner is needed. When welding with softer aluminium alloys, you may experience feed problems.

CHANGE POLARITY

This welder allows you the capability to change the welding current polarity. You may select either Straight Flux Core (FCAW) Polarity or Reverse MIG Polarity (GMAW). For welding steel with solid wire, stainless steel, flux cored hardfacing of steel, and silicon bronze welding of steel, select DC Reverse Polarity (DC + MIG). When using self-shielding, flux-core steel wire, use DC Straight Polarity (DC - Flux Cored).

Change the polarity of your welder according to the following procedure steps. Figure 8 shows what the polarity block should look like for each polarity setting.



WARNING

Electric shock can kill! Always turn the power OFF and unplug the power cord from the ac power source before changing polarity.

CAUTION

Do not use a ratchet, crescent or other lever type wrench to tighten knobs on the polarity block. The nuts must be hand tightened only. Too much torque applied to one of the knobs could cause the knob to break off.

1. Remove the retaining knobs from the + and - mounting posts on the Gas/No Gas Board, located just below the drive motor on the inside of your welder.
 - A. For Gasless (FCAW) welding, mount the Ground Clamp ring terminal to the "+" mounting post and the Torch ring terminal to the "-" mounting post.
 - B. For MIG (GMAW) welding, mount the Ground Clamp ring terminal to the "-" mounting post and the Torch ring terminal to the "+" mounting post.

See configuration shown in Figure 8.

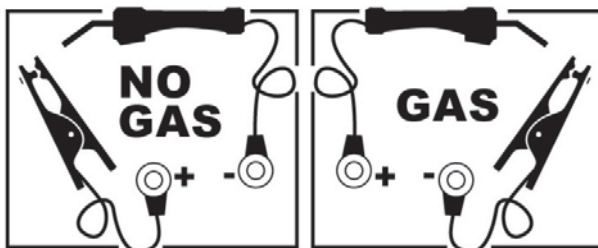


Figure 8. Changing Polarity

2. Attach the ground clamp to the work piece, making sure that it is cleaned of dirt, oil, rust, scale, oxidation, and paint at the point of connection.

Note: It is best to connect the ground clamp directly to the work piece and as close to the weld as possible. If it is impractical to connect the ground clamp directly to the work piece, connect it to the metal that is securely attached to the work piece, but not electrically insulated from it. Make certain this other metal is of equal or greater thickness than that of the workpiece.



CAUTION

Risk of electric component damage! If the ground clamp is being connected to an automobile or other equipment with on-board computer systems, solid state electronic controls, solid state sound systems, etc., do not weld until disconnecting the battery that is attached to the chassis ground. Failure to do so may result in electronic component damage.

OPERATION

Operation of this welder consists of selecting and adjusting operating controls for optimum voltage (welding heat) and wire speed settings.

CONTROLS AND INDICATORS



WARNING

Electric shock can kill! Whenever the POWER switch is in the ON position, the welding circuit is activated. Under this condition, an arc will occur if the welding wire or any part of the welding circuit comes in contact with welding ground.

POWER SWITCH - The power switch supplies electrical current to the welder. ALWAYS turn the power switch to the OFF position and unplug the welder before performing any maintenance.

VOLTAGE SELECTOR - The voltage selector switch and dial control the welding heat. The voltage selector switch is labeled MIN/MAX, referring to minimum and maximum voltage output. The voltage selector dial is numbered 1-3. Number 1 is the lowest heat and number 3 is the highest. Refer to the label under the welder hood (or on page 33 of this manual) for recommended heat settings for your welding job. Switch position "MAX" and dial position "3" produce the rated output of 120 amps.

WIRE SPEED CONTROL - The wire speed control adjusts the speed at which the wire is fed out of the welding gun. The wire speed needs to be closely matched (tuned-in) to the rate at which it is being melted off. Some things that affect wire speed selection are the type and diameter of the wire being used, the heat setting selected, and the welding position to be used.

Note: The wire will feed faster without an arc. When an arc is being drawn, the wire speed will slow down.

TUNING IN THE WIRE SPEED

This is one of the most important parts of MIG welder operation and must be done before starting each welding job whenever any of the following variables are changed: heat setting wire diameter, or wire type.

1. Set up and ground a scrap piece of the same type of material which you will be welding. It should be equal to or greater than the thickness of the actual work piece, and free of oil, paint, rust, etc.
2. Select a heat setting.
3. Hold the gun in one hand, allowing the nozzle to rest on the edge of the workpiece farthest away from you, and at an angle similar to that which will be used when welding. (SEE HOLDING THE GUN on page 19 if you are uncertain of the angle at which you will be welding)
4. With your free hand, turn the Wire Speed Dial to maximum and continue to hold onto the knob.



WARNING

EXPOSURE TO A WELDING ARC IS EXTREMELY HARMFUL TO THE EYES AND SKIN! Prolonged exposure to the welding arc can cause blindness and burns. Never strike an arc or being welding until you are adequately protected. Wear flameproof welding gloves, a heavy long sleeved shirt, cuffless trousers, high topped shoes and a welding helmet.

3. Lower your welding helmet and pull the trigger on the gun to start an arc, then begin to drag the gun towards you while simultaneously turning the Wire Speed Dial counter-clockwise.
4. LISTEN! As you decrease the wire speed, the sound that the arc makes will change from a sputtering to a high-pitched buzzing sound and then will begin sputtering again if you decrease the wire speed too much. The point on the wire speed adjustment where the high-pitched buzzing sound is achieved is the correct setting.

You can use the wire speed control to slightly increase or decrease the heat and penetration

for a given heat setting by selecting higher or lower wire speed settings. Repeat this tune-in procedure if you select a new heat setting, a different diameter wire, or a different type of welding wire.

LEARNING TO WELD

MIG (GMAW) welding is the process of uniting metallic parts by heating and allowing the metals to flow together through the use of an electrical arc. The electrical arc is created between a continuous consumable wire electrode (the welding wire) and the work piece. An inert shielding gas is used to protect the weld puddle from contamination and enhance the welding capabilities of the electrical arc.

Whether you have welded before or not, it is important that you become familiar with your new welder, its controls, and the results achieved at different settings. We strongly recommend that you practice with your new welder on scrap metal trying different heat settings, base metal thicknesses, and welding positions for each type and size of wire you will be using. By doing this you will gain a feel for how changes in these welding variables affect the weld.

Of course, if you have not welded before, you will need to develop welding skills and techniques as well.

The self-taught welder learns through a process of trial and error. The best way to teach yourself how to weld is with short periods of practice at regular intervals. All practice welds should be done on scrap metal that can be discarded. Do not attempt to make any repairs on valuable equipment until you have satisfied yourself that your practice welds are of good appearance and free of slag or gas inclusions. What you fail to learn through practice will be learned through mistakes and re-welds later on.

HOLDING THE GUN

The best way to hold the welding gun is the way that feels most comfortable to you. While practicing to use your new welder, experiment holding the gun in different positions until you find the one that seems to

work best for you. Refer to WELDING POSITIONS - p.21)

Position the Gun to the Work Piece There are two angles of the gun nozzle in relation to the work piece that must be considered when welding.

1. Angle A (Figure 9) can be varied, but in most cases the optimum angle will be 60 degrees. The point at which the gun handle is parallel to the work piece. If angle A is increased, penetration will increase. If angle A is decreased, penetration will decrease also.

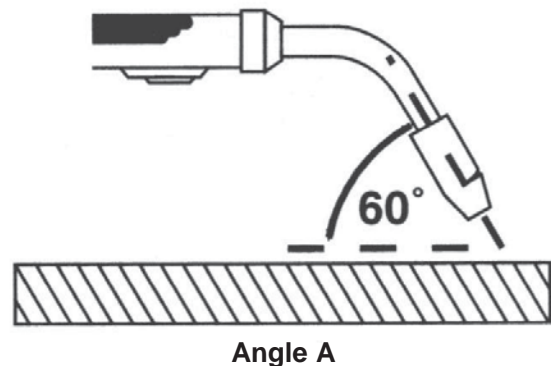


Figure 9. Gun Position, Angle A

2. Angle B (Figure 10) can be varied for two reasons: to improve the ability to see the arc in relation to the weld puddle and to direct the force of the arc.

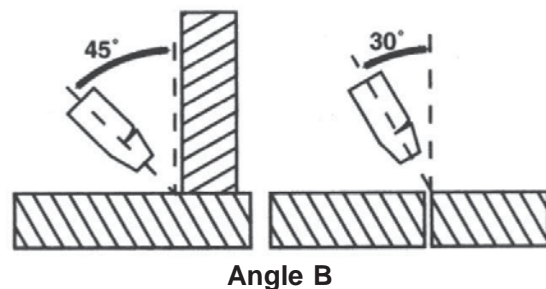


Figure 10. Gun Position, Angle B

The force of the welding arc follows a straight line out of the end of the nozzle. If angle B is changed, so will the direction of arc force and the point at which penetration will be concentrated.

On a butt weld joint, the only reason to vary angle B from perpendicular (straight up) to the work piece would be to improve visibility of the weld puddle. In this case, angle B can be varied anywhere from zero to 45 degrees with 30 degrees working about the best.

On a fillet weld joint, the nozzle is generally positioned in such a manner so as to split the angle between the horizontal and vertical members of the weld joint. In most cases, a fillet weld will be 45 degrees.

Distance from the Work Piece

The end of the welding gun is designed with the contact tip recessed from the end of the nozzle and the nozzle electrically insulated from the rest of the gun. This permits the operator to actually rest the nozzle on the work piece and drag it along while welding. This can be very helpful to beginning welders to steady the gun, allowing the welder to concentrate on welding technique. If the nozzle is held off the work piece, the distance between the nozzle and the work piece should be kept constant and should not exceed 1/4 inch or the arc may begin sputtering, signaling a loss in welding performance

WELDING TECHNIQUES



WARNING

EXPOSURE TO A WELDING ARC IS EXTREMELY HARMFUL TO THE EYES AND SKIN! Prolonged exposure to the welding arc can cause blindness and burns. Never strike an arc or begin welding until you are adequately protected. Wear flameproof welding gloves, a heavy long sleeved shirt, cuffless trousers, high topped shoes and a welding helmet.



WARNING

ELECTRIC SHOCK CAN KILL! To prevent ELECTRIC SHOCK, do not perform any welding while standing, kneeling, or lying directly on the grounded work.

MOVING THE GUN

Gun travel refers to the movement of the gun along the weld joint and is broken into two elements: Direction and Speed. A solid weld bead requires that the welding gun be

moved steadily and at the right speed along the weld joint. Moving the gun too fast, too slow, or erratically will prevent proper fusion or create a lumpy, uneven bead.

1. TRAVEL DIRECTION is the direction the gun is moved along the weld joint in relation to the weld puddle. The gun is either **PUSHED** (see Figure 11) into the weld puddle or **PULLED** away from the weld puddle.

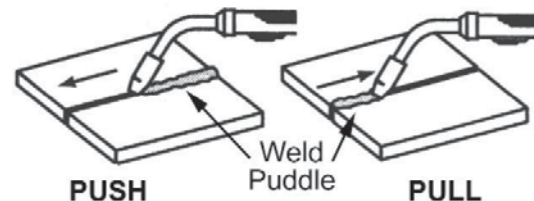


Figure 11. Travel Direction

For most welding jobs you will pull the gun along the weld joint to take advantage of the greater weld puddle visibility.

2. TRAVEL SPEED is the rate at which the gun is being pushed or pulled along the weld joint. For a fixed heat setting, the faster the travel speed, the lower the penetration and the lower and narrower the finished weld bead. Likewise, the slower the travel speed, the deeper the penetration and the higher and wider the finished weld bead.

TYPES OF WELD BEADS

The following paragraphs discuss the most commonly used welding beads.

Once you have the gun in position with the wire lined up on the weld joint, lower your helmet, pull the trigger and the arc will start. In a second or two you will notice a weld puddle form and the base of the bead beginning to build. It is now time to begin to move with the gun. If you are just learning to weld, simply move the gun in a straight line and at a steady speed along the weld joint. Try to achieve a weld with the desired penetration and a bead that is fairly flat and consistent in width.

As you become more familiar with your new welder and better at laying some simple weld beads, you can begin to try some different weld bead types.

There are two basic types of weld beads, the stringer bead and the weave bead.

1. The **STRINGER BEAD** (Figure 12) is formed by traveling with the gun in a straight line while keeping the wire and nozzle centered over the weld joint. This is the easiest type of bead to make.

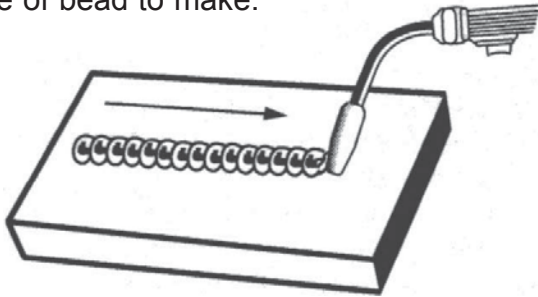


Figure 12. Stringer Bead

2. The **WEAVE BEAD** (Figure 13) is used when you want to deposit metal over a wider space than would be possible with a stringer bead. It is made by weaving from side to side while moving with the gun. It is best to hesitate momentarily at each side before weaving back the other way.

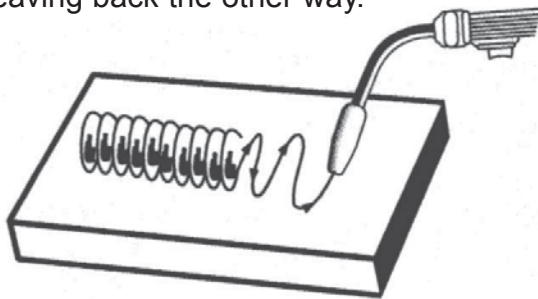


Figure 13. Weave Bead

WELDING POSITIONS

There are four basic welding positions: flat, horizontal, vertical, and overhead.

1. The **FLAT POSITION** (Figure 14) is the easiest of the welding positions and is most commonly used. It is best if you can weld in the flat position if at all possible as good results are easier to achieve.

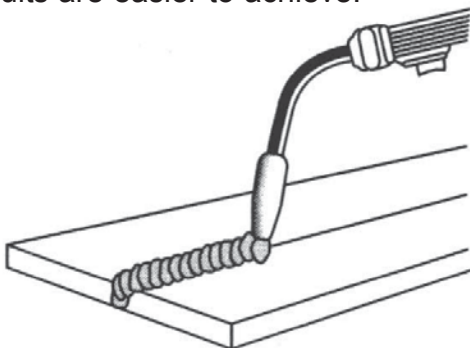


Figure 14. Flat Position

2. The **HORIZONTAL POSITION** (Figure 15) is next in difficulty level. It is performed very much the same as the flat weld except that angle B (see **HOLDING THE GUN** - p.19) is such that the wire, and therefore the arc force, is directed more toward the metal above the weld joint. This is to help prevent the weld puddle from running downward while still allowing slow enough travel speed to achieve good penetration. A good starting point for angle B is about 30 degrees **DOWN** from being perpendicular to the work piece.

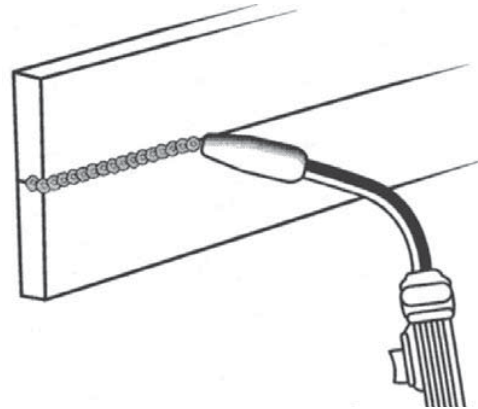


Figure 15. Horizontal Position

3. The **VERTICAL POSITION** (Figure 16) is the next most difficult position. Pulling the gun from top to bottom may be easier for many people, but in some instances it can be difficult to prevent the puddle from running downward. Pushing the gun from bottom to top may provide better puddle control and allow slower rates of travel speed to achieve deeper penetration. When vertical welding, angle B (see **HOLDING THE GUN** - p.19) is usually always kept at zero, but angle A will generally range from 45 to 60 degrees to provide better puddle control.

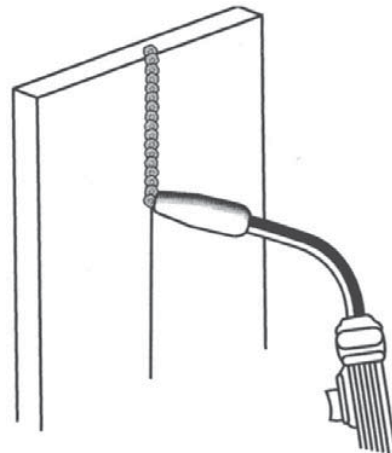


Figure 16. Vertical Position



WARNING

Hot slag can cause fires and serious injury from burns! Be sure to wear protective clothing and eye gear when using the Overhead Position.

4. The OVERHEAD POSITION (Figure 17) is the most difficult welding position because gravity is pulling at the weld puddle trying to make it drip off the work piece. Angle A (see HOLDING THE GUN - p.19) should be maintained at 60 degrees, the same as in the flat position. Maintaining this angle will reduce the chances of molten metal falling into the nozzle should it drip from the weld puddle. Angle B should be held at zero degrees so that the wire is aiming directly into the weld joint. If you experience excessive dripping of the weld puddle, select a lower heat setting. Also, the weave bead tends to work better than the stringer bead when welding overhead.

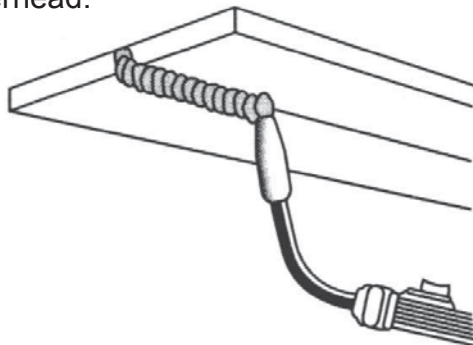


Figure 17. Overhead Position

MULTIPLE PASS WELDING

Butt Weld Joints. When butt welding thicker materials, you will need to prepare the edges of the material to be joined by grinding a bevel on the edge of one or both pieces of the metal being joined. When this is done, a V is created between the two pieces of metal, that will have to be welded closed. In most cases more than one pass or bead will need to be laid into the joint to close the V. Laying more than one bead into the same weld joint is known as a multiple-pass weld.

The illustrations in Figure 18 show the sequence for laying multiple pass beads into a single V butt joint.

NOTE: WHEN USING SELF-SHIELDING FLUX-CORE WIRE it is very important to thoroughly chip and brush the slag off each completed weld bead before making another pass or the next pass will be of poor quality.

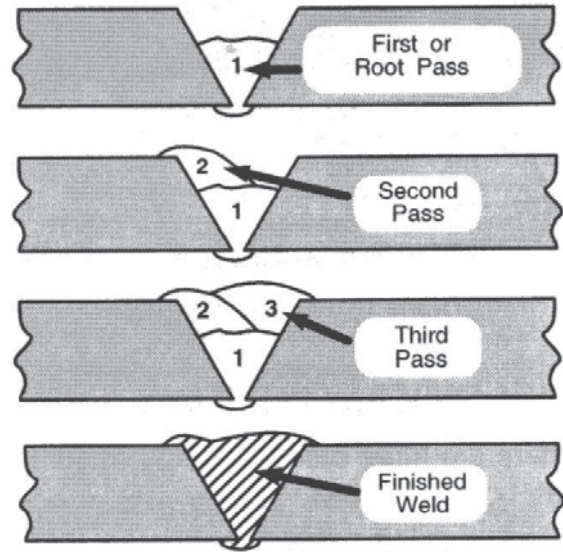


Figure 18. Butt Joints

Fillet Weld Joints. Most fillet weld joints, on metals of moderate to heavy thickness, will require multiple pass welds to produce a strong joint. The illustrations in Figure 19 show the sequence of laying multiple pass beads into a T fillet joint and a lap fillet joint.

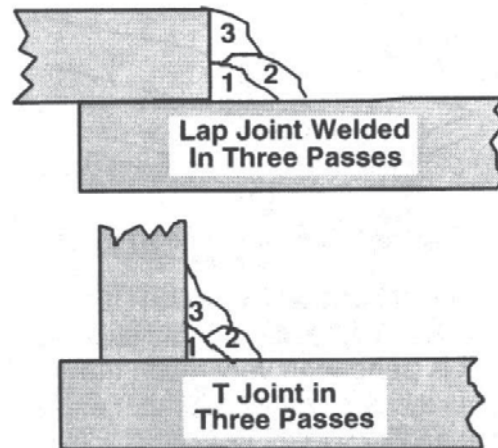


Figure 19. Fillet Weld Joints

SPECIAL WELDING METHODS

SPOT WELDING

The purpose of a spot weld is to join pieces of metal together with a spot of weld instead of a continuous weld bead. There are three methods of spot welding: Burn-Through,

Punch and Fill, and Lap (see Figure 20). Each has advantages and disadvantages depending on the specific application as well as personal preference.

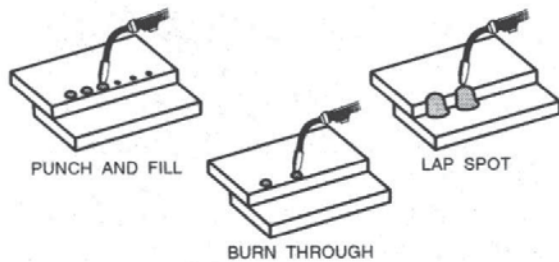


Figure 20. Spot Welding

1. The BURN-THROUGH METHOD welds two overlapped pieces of metal together by burning through the top piece and into the bottom piece.

With the burn-through method, larger wire diameters tend to work better than smaller diameters because they have greater current carrying capabilities allowing the arc to burn through very quickly while leaving a minimal amount of filler metal build up. Wire diameters that tend to work best, with the burn-through method, are 0.030 inch diameter solid wire or 0.035 inch self-shielding flux-core wire.

Do not use 0.024 inch diameter solid or 0.030 inch self-shielding flux-core wires when using the burn-through method unless the metal is VERY thin or excessive filler metal build-up and minimal penetration is acceptable.

Always select the HIGH heat setting with the burn-through method and tune in the wire speed prior to making a spot weld.

2. The PUNCH AND FILL METHOD produces a weld with the most finished appearance of the three spot weld methods. In this method, a hole is punched or drilled into the top piece of metal and the arc is directed through the hole to penetrate into the bottom piece. The puddle is allowed to fill up the hole leaving a spot weld that is smooth and flush with the surface of the top piece.

Select the wire diameter, heat setting, and

tune in the wire speed as if you were welding the same thickness material with a continuous bead.

3. The LAP SPOT METHOD directs the welding arc to penetrate the bottom and top pieces, at the same time, right along each side of the lap joint seam.

Select the wire diameter, heat setting, and tune in the wire speed as if you were welding the same thickness material with a continuous bead.

SPOT WELDING INSTRUCTIONS

1. Select the wire diameter and heat setting recommended above for the method of spot welding you intend to use.
2. Tune in the wire speed as if you were going to make a continuous weld.
3. Hold the nozzle piece completely perpendicular to and about 1/4 inch off the work piece.
4. Pull the trigger on the gun and release it when it appears that the desired penetration has been achieved.
5. Make practice spot welds on scrap metal, varying the length of time you hold the trigger, until a desired spot weld is made.
6. Make spot welds on the actual work piece at desired locations.

MAINTENANCE

GENERAL

This welder has been engineered to give many years of trouble-free service providing that a few very simple steps are taken to properly maintain it.

1. Keep the wire drive compartment lid closed at all times unless the wire needs to be changed or the drive tension needs adjusting.
2. Keep all consumables (contact tips, nozzles, and gun liner) clean and replace when necessary. See **CONSUMABLE MAINTENANCE** and **TROUBLESHOOTING** later in this section for detailed information.
3. Replace power cord, ground cable, ground clamp, or gun assembly when damaged or worn.
4. Periodically clean dust, dirt, grease, etc. from your welder. Every six months, or as necessary, remove the side panels from the welder and air-blow any dust and dirt that may have accumulated inside the welder.



WARNING

Electric shock can kill! To reduce the risk of electric shock, always unplug the welder from its ac power source before removing side panels.

CONSUMABLE MAINTENANCE

IT IS VERY IMPORTANT TO MAINTAIN THE CONSUMABLES TO AVOID THE NEED FOR PREMATURE REPLACEMENT OF THE GUN ASSEMBLY.

The **GUN LINER** is intended to provide an unrestricted path for the welding wire to flow through the gun assembly. Over time the liner will accumulate dust, dirt, and other debris. Replacement is necessary when these accumulations begin to restrict the free flow of wire through the gun assembly.

MAINTAINING THE CONTACT TIP

The purpose of the **CONTACT TIP** is to transfer welding current to the welding wire while allowing the wire to pass through it smoothly.

Always use a contact tip stamped with the same diameter as the wire it will be used with.

Note: Due to inherent variances in flux-cored welding wire, it may be necessary to use a contact tip one size larger than your flux core wire if wire jams occur.

1. If the wire burns back into the tip, remove the tip from the gun and clean the hole running through it with an oxygen-acetylene torch tip cleaner or tip drill.
2. Over time, the hole in the contact tip will become worn by the wire passing through it. The more worn this hole becomes, the less efficient is the transfer of welding current to the wire and eventually arc breakage and difficult arc starting will result. Replace contact tips when signs of wear become apparent.

MAINTAINING THE NOZZLE

The nozzle directs the shielding gas to the weld puddle, determines the size of the shielding area, and prevents the electrically hot contact tip from contacting the work piece.

CAUTION

KEEP THE NOZZLE CLEAN! During the welding process, spatter and slag will build up inside the nozzle and must be cleaned out periodically. Failure to clean and/or replace the nozzle in a timely fashion **WILL CAUSE DAMAGE TO THE FRONT-END OF THE GUN ASSEMBLY.**

For best results, coat the inside of a new, or freshly cleaned nozzle with anti stick spray or gel.

1. Stop welding and clean any accumulated slag or spatter from the nozzle every 5 to 10 minutes of welding time.
2. When welding overhead, if any molten metal drips from the weld puddle and falls into the nozzle, **STOP WELDING IMMEDIATELY** and clean the nozzle.
3. If the slag cannot be thoroughly cleaned from the nozzle, **REPLACE THE NOZZLE!**

Failure to keep the nozzle adequately cleaned can result in the following problems: A **SHORTED** nozzle results when spatter buildup bridges the insulation in the nozzle, allowing welding current to flow through it as well as the contact tip. When shorted, a nozzle will steal welding current from the wire whenever it contacts the grounded work piece. This causes erratic welds and reduced penetration. In addition, a shorted nozzle overheats the end of the gun, which can **DAMAGE** the front-end of the gun.

A **RESTRICTED** nozzle is created when enough slag builds up in the nozzle to affect the direction, concentration, and/or rate of the shielding gas flow. This problem can cause porous, brittle welds and reduce penetration.

TESTING FOR A SHORTED NOZZLE

Arcing between the nozzle and the work piece **ALWAYS** means the nozzle is shorted, but this can be hard to detect through the lens of a welding helmet. The following testing method is another way to tell if a nozzle is shorted.

With the welder unplugged from the ac power source, touch the probes of an ohmmeter or continuity tester to the end of the contact tip and the outside of the nozzle. If there is any continuity at all, the nozzle **IS** shorted. Clean or replace as needed.

REPLACE A GUN LINER

When installing a new gun liner, care must be taken not to kink or otherwise damage the gun liner. See Figure 21 for the drive assembly and Figure 22 for the gun assembly.

1. Turn OFF welder POWER SWITCH and unplug welder from power supply.
2. Open the welder side panel.
3. Loosen the tension arm and lift it up off the drive roller.
4. Turn the wire spool counter-clockwise (be sure to hold onto the wire itself while turning the spool or the wire will unspool itself when it becomes free of the gun liner), and remove wire from gun assembly.
5. Lay gun cable and gun handle straight out in front of unit.

6. Remove gun liner holding clamp by removing two self tapping screws and two bolts with nuts.
7. Take gun handle halves apart by removing five phillips head screws.
8. Remove gas hose from fast coupler fitting on Gas Valve. Depress lip on fast coupler fitting back towards fitting and pull gas hose out.
9. Remove Fast Coupler Fitting from Gas Valve using a 9 millimeter wrench.
10. Firmly hold the brass fitting on the end of the gun liner with a wrench and rotate Gas Valve counterclockwise to unscrew fitting.
Note: Rotate Gas Valve – Do not rotate brass fitting or gun liner twist inside gun cable and may cause damage to gun cable.
11. The Live Wire Terminal is held in place on the Gas Valve by the brass fitting on the end of the gun liner. When the brass fitting is removed, slide the Live Wire Terminal off of the brass fitting.
12. Firmly grip the gun cable and pull the gun liner all the way out.
13. Install the new gun liner into gun cable, starting from the end where the welding gun will be mounted, and feeding the liner all the way through the gun cable to the wire feed roller.
Note: It may be helpful to apply a small amount of liquid soap to the end of the gun liner to decrease resistance during installation process.
14. Slide the eyelet of the Live Wire Terminal onto the threaded end of the gun liner brass fitting.
15. Firmly hold the brass fitting on the end of the gun liner with a wrench and rotate Gas Valve clockwise to screw it onto fitting.
Note: Rotate Gas Valve – Do not rotate brass fitting or gun liner will twist inside gun cable and may cause damage to gun cable.
16. Return all components to the handle casing and realign them as they were originally.
17. With both halves of the handle case in place, tighten the five phillips head screws.
18. Using wire cutters, trim the new gun liner to approximately 3/16 inch beyond the

edge of the Cable Holding Clamp. (The goal is to make sure that the end of the gun liner will be visible after the Cable Holding Clamp is assembled. This will make installing the welding wire much easier.)

19. Reinstall the welding wire according to specifications in INSTALL THE WELDING WIRE section.
20. Close side panel.
21. Plug welder into power supply and turn POWER SWITCH to ON position.

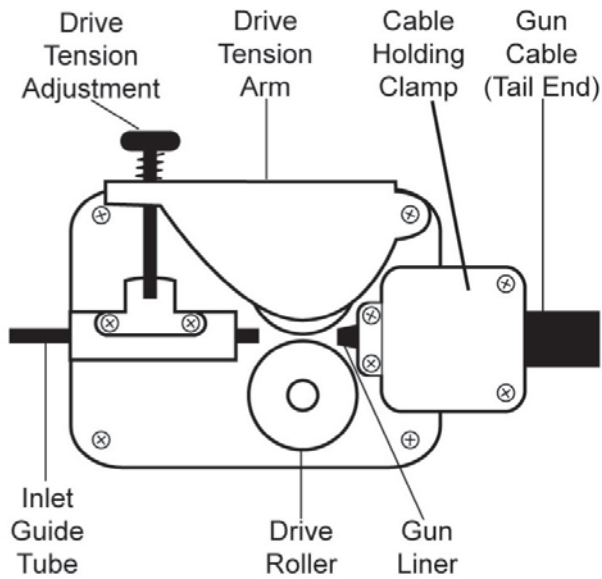


Figure 21. Drive Assembly

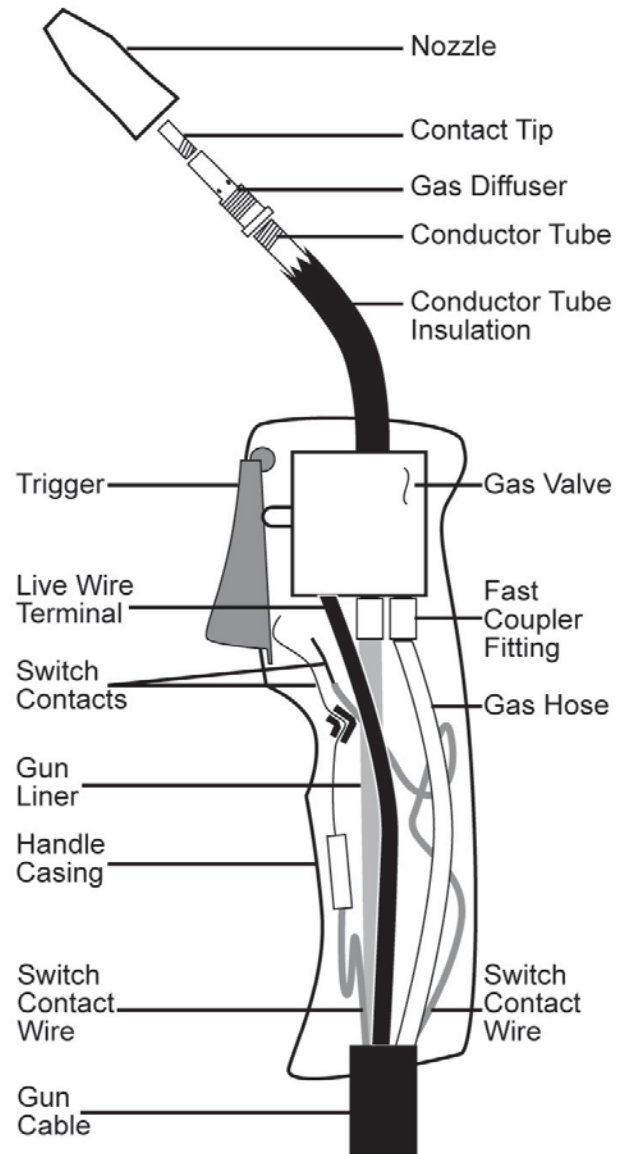


Figure 22. Gun Assembly

TROUBLESHOOTING

The following TROUBLESHOOTING information is provided as a guide to help resolve some of the more common problems that could be encountered.

Table 4 is a troubleshooting table provided to help you determine a possible remedy when you are having a problem with your welder. This table does not provide all possible solutions, only those possibilities considered to likely be common faults. The table consists of a TROUBLE or symptom, a POSSIBLE CAUSE for the symptom, and a POSSIBLE REMEDY for that symptom.

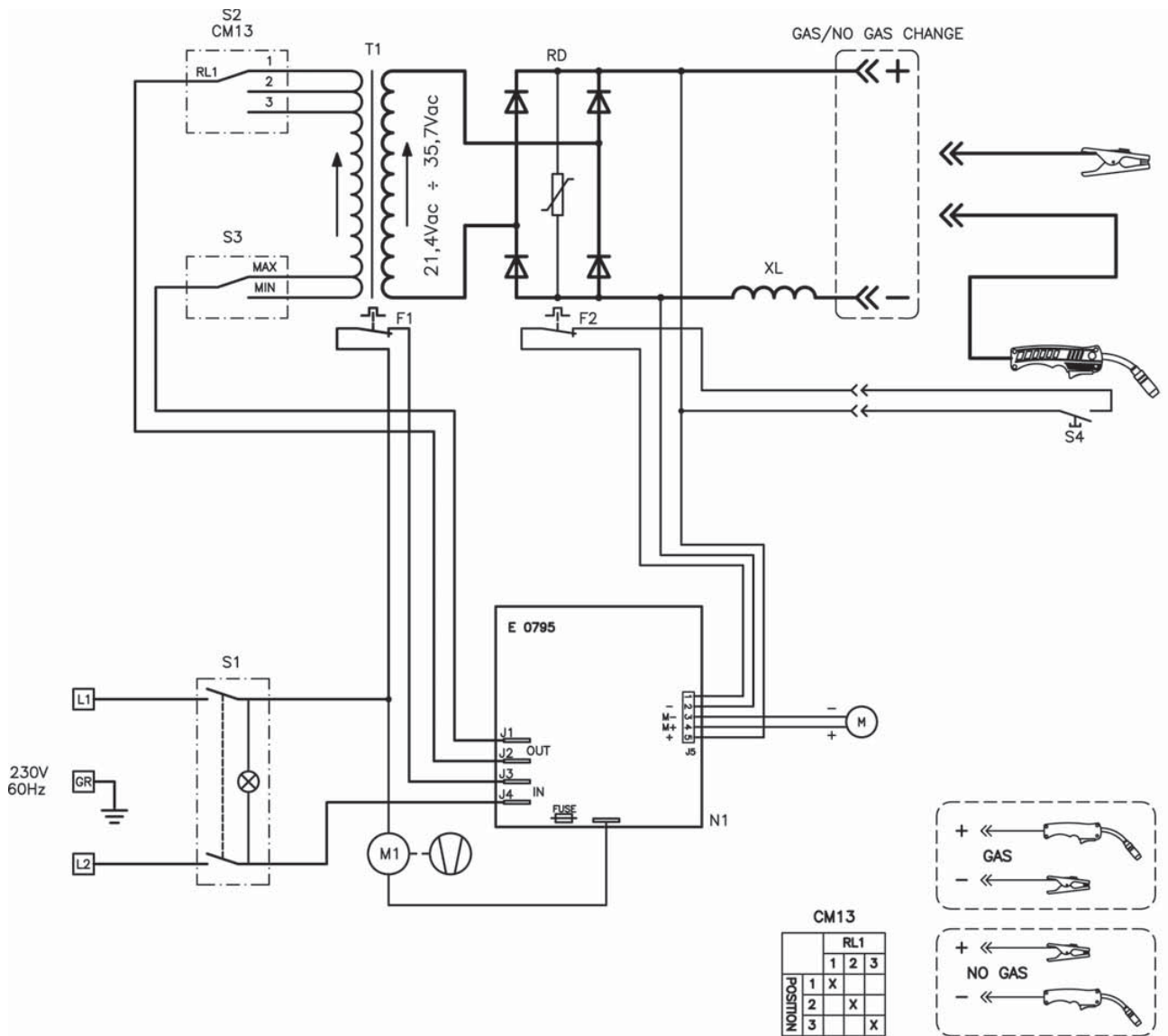
PREVENTIVE MAINTENANCE

Except for internal and external cleaning, cleaning the nozzle, and occasionally retightening screws, there is no periodic maintenance recommended for your welder.

TABLE 4 – TROUBLESHOOTING

TROUBLE	POSSIBLE CAUSE	POSSIBLE REMEDY
Dirty, porous, brittle weld	<ol style="list-style-type: none"> 1. Plugged welding nozzle 2. No shielding gas 3. Wrong type of gas 4. Dirty or rusty welding wire 	<ol style="list-style-type: none"> 1. Clean or replace nozzle. 2. Tank empty, flow restricted or regulator set too low. 3. See SELECTING SHIELDING gas section of manual. 4. Replace spool of wire.
Wire feed works but no arc	<ol style="list-style-type: none"> 1. Bad ground or loose connection 2. Bad connection to gun or faulty gun 	<ol style="list-style-type: none"> 1. Check ground and connections. Tighten as necessary. 2. Check connection to gun or replace gun.
Arc works but no feeding wire	<ol style="list-style-type: none"> 1. Faulty wire speed control assembly 2. No tension on drive roller 3. Faulty drive motor (RARE!) 	<ol style="list-style-type: none"> 1. Replace wire speed control assembly. 2. Adjust the drive tension. 3. Replace drive motor.
Nothing works except fan	<ol style="list-style-type: none"> 1. Faulty trigger on gun 2. Exceeded duty cycle; thermal protector opened 3. Faulty transformer (RARE!) 	<ol style="list-style-type: none"> 1. Replace gun trigger. 2. Let welder cool at least 10 minutes (observe and maintain proper duty cycle.) 3. Replace transformer.
Low output or nonpenetrating weld	<ol style="list-style-type: none"> 1. Loose connection inside machine 2. Too long improper extension cord 3. Wrong type or size wire 4. Poor ground connection 5. Wrong size contact tip 6. Loose gun connection or faulty gun assembly 7. Wrong welding polarity set 8. Dirty or rusty welding wire 	<ol style="list-style-type: none"> 1. Blow inside of machine out with compressed air. Clean and tighten all connections. 2. See EXTENSION CORDS section of manual. 3. Use correct size wire. 4. Reposition clamp and check cable to clamp connection. 5. Use correct size contact tip. 6. Tighten gun replace gun. 7. Change to proper polarity. 8. Replace spool of wire.
Wire is jamming or “birdnesting” at the drive roller	<ol style="list-style-type: none"> 1. Too much tension on drive roller 2. Gun liner worn damaged 3. Contact tip is clogged or damaged 4. Liner stretched or is too long 	<ol style="list-style-type: none"> 1. Adjust drive tension. (See INSTALL THE WELDING WIRE) 2. Replace gun liner. 3. Replace contact tip. 4. Trim liner to proper length.
Wire burns back to contact tip	<ol style="list-style-type: none"> 1. Gun liner worn or damaged 2. Liner stretched or is too long 3. Wrong size contact tip 4. Contact tip is clogged or damaged 	<ol style="list-style-type: none"> 1. Replace gun liner. 2. Trim liner to proper length. 3. Use correct size contact tip. 4. Replace contact tip.
Ground clamp and/or ground cable gets hot	Bad connection from cable to clamp	Tighten connection or replace cable.
Gun nozzle arcs to work surface	Slag building inside nozzle or nozzle is shorted	Clean or replace nozzle as needed.

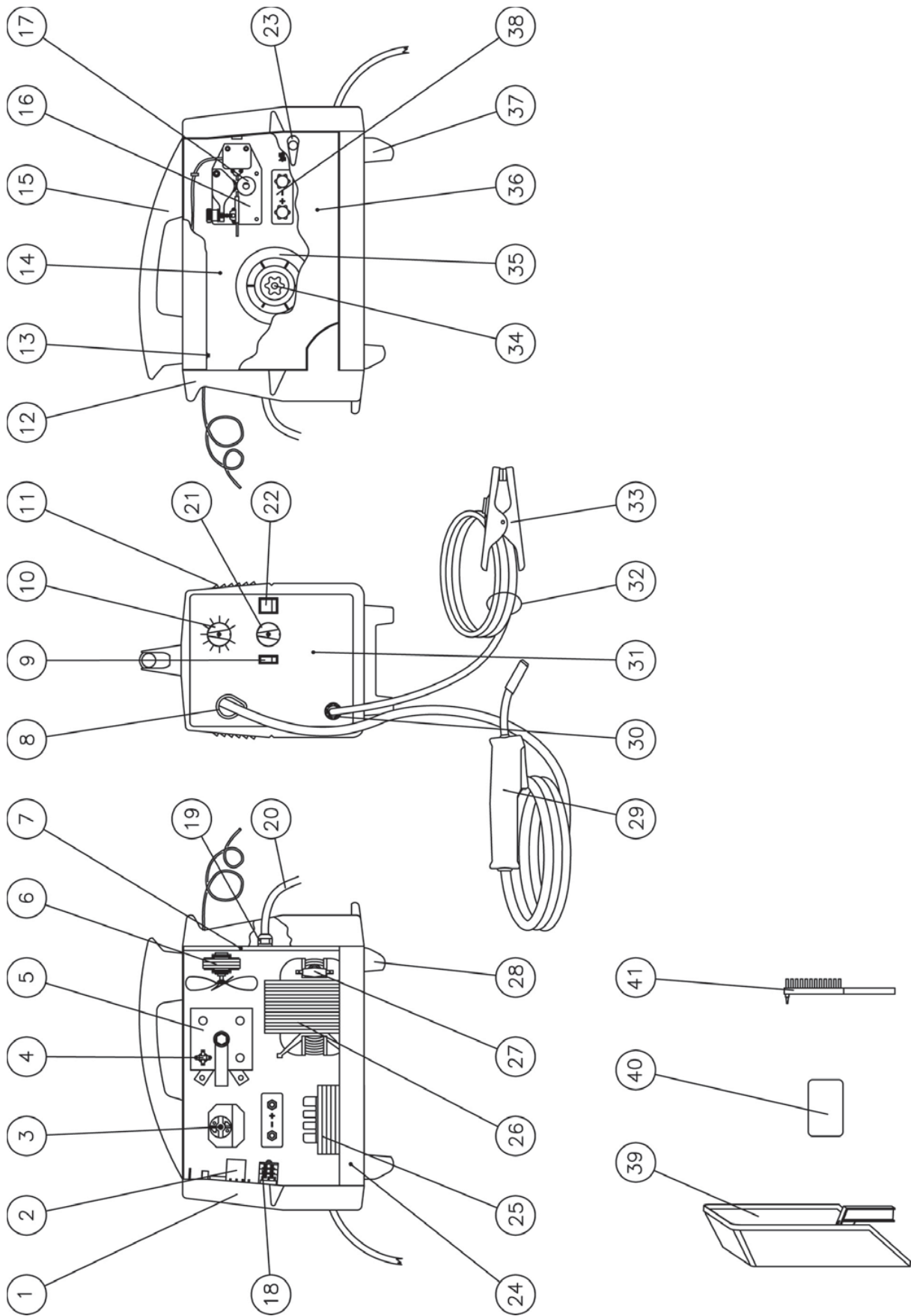
WIRE FEED WELDER WIRING DIAGRAM



F1-F2	THERMOSTAT	THERMOSTATE	THERMOSTAT	TERMOSTATOS	TERMOSTATI
M	WIRE FEEDING MOTOR	DRAHTVORSCHUB MOTOR	MOTEUR D'ENTRAÎNEMENT DU FIL	EQUIPO ARRASTRA HILO	MOTORE TRAINA FILO
M1	FAN	VENTILATOR	VENTILATEUR	VENTILADOR	VENTILATORE
N1	P.C. BOARD	ELEKTRONIK-PLATTE	FICHE ELECTRONIQUE	CIRCUITO ELECTRONICO	SCHEDA ELETTRONICA
RD	RECTIFIER	GLEICHRICHTER	REDRESSEUR	RECTIFICADOR	PONTE RADDRIZZATORE
S1	ON - OFF	ON - OFF	ON - OFF	INTERRUPTOR ON - OFF	ON - OFF
S2-S3	SWITCH	UMSCHALTER	COMMUTATEUR	CONMUTADOR	COMMUTATORE
S4	TORCH TRIGGER	BRENNER SCHALTER	BOUTON TORCHE	PULSADOR DE LA ANTORCHA	PULSANTE TORCIA
T1	TRANSFORMER	TRANSFORMATOR	TRANSFORMATEUR	TRANSFORMADOR	TRASFORMATORE
XL	CHOKE	IMPEDANZ	IMPEDANCE	IMPEDANCIA	IMPEDENZA

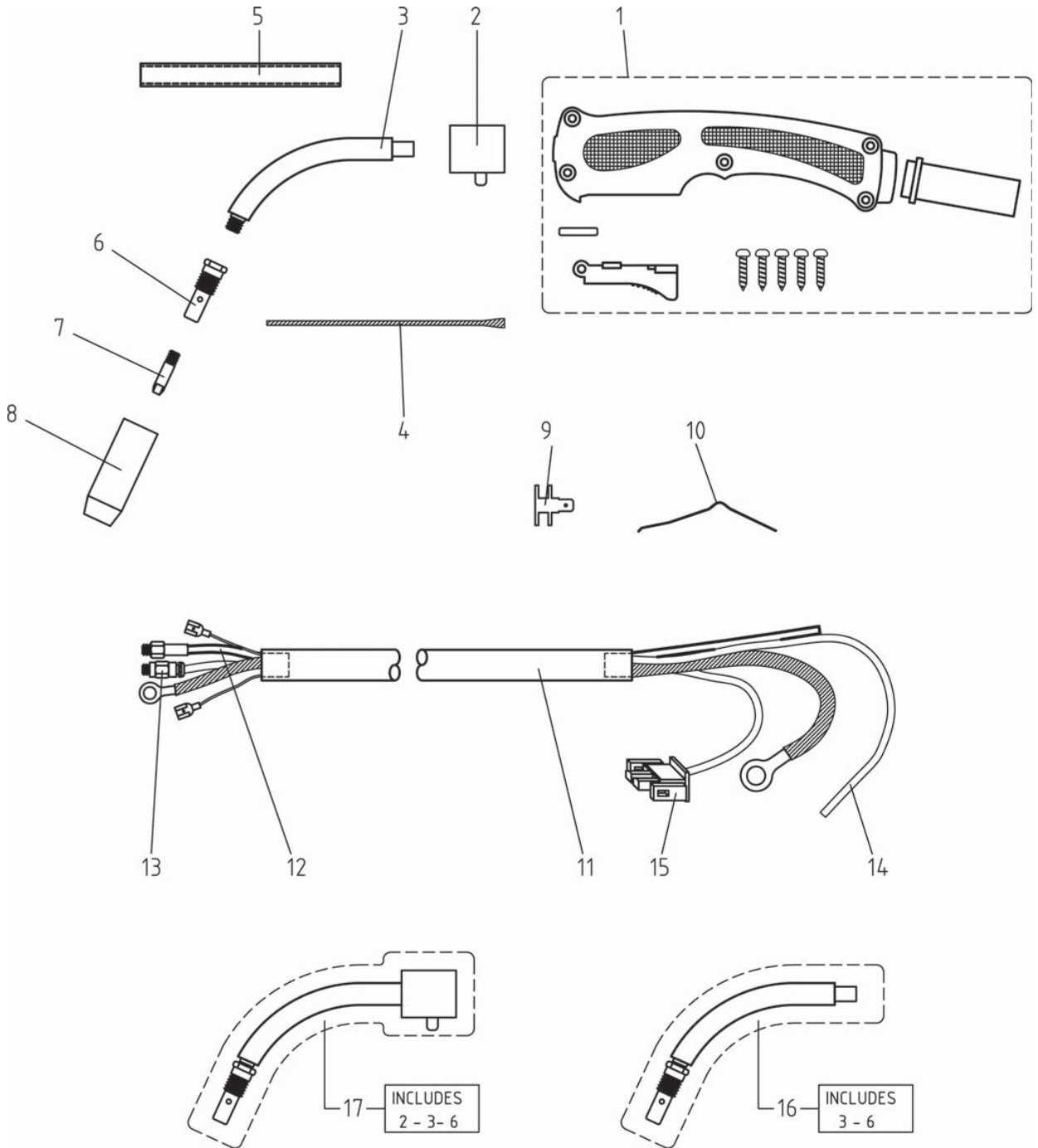
WIRE FEED WELDER PARTS LIST

FIG #	OEM #	FORNEY #	DESCRIPTION	QTY
01	21690175	85233	FRONT PLASTIC TRIM	1
02	22710037	85261	E0795 P.C. BOARD 220/240V + FUSE "CSA"	1
03	04600145	85207	MOTOR D.37 + PINION	1
04	22210014	85233	THERMOSTAT 100° 10A	1
05	22400038	85258	RECTIFIER PMS 8/4/1 F	1
06	04600286	85210	FAN & FAN MOTOR ASSY. 220V 60HZ	1
07	05000183		BACK PANEL +SCREEN+LABEL	1
08	21690458	85230	TORCH GROMMET (D.40 O	1
09	22200038	85249	HIGH/LOW POWER SWITCH 16A 250V	1
10	04600323	85211	KNOB FOR POTENTIOMETER ø38, WIRE	1
11	05000171	85220	UPPER PANEL W/SCREEN+LABEL	1
12	21690176	85234	REAR PLASTIC TRIM	1
13	21690178	85236	ACCESS PANEL HINGE	2
14	05000163	85212	DIVIDING PANEL +LABEL	1
15	21600021	85227	PLASTIC HANDLE	1
16	44400016	85268	BLACK WIRE FEEDER D.37 ROL.06-08	1
17	33805001	85267	WIRE FEED ROLL .024-.030 KNURLED	1
17	33805027	85269	WIRE FEED ROLL .030-.040 NYLON	1
18	22205164	85251	SWITCH 17A CM 13 CS017M0	1
19	21605036	85293	CABLE CLAMP PG21 BLAC	1
20	20220120	85226	POWER CABLE 3X12AWG 2.5M + 50A 6-50P	1
21	21690179	85237	SWITCH KNOB ø38	1
22	22200039	85250	GREEN PILOT LIGHT SWITCH 16A-250V	1
23	21690177	85235	SIDE PANEL CLIP	1
24	33700138	85287	LOWER PANEL	1
25	44135018	85282	CHOKE 40X40 AL	1
26	44120178	85278	TRANSFORMER 60HZ 220V 40X85 AL	1
27	22210016	85254	THERMOSTAT 127° 16A	1
28	21610015	85232	REAR PLASTIC FOOT	1
29	23000054	85263	TORCH AND CABLE ASSY. COMPLETE 2.2 M	1
30	21605010	85230	CABLE CLAMP FOR HOLE ø20	1
31	05000167	85216	FRONT PANEL W/SCREEN PRINTING	1
32	43210120	85276	EARTH CABLE 10GR.MM² M2	1
33	22110025	85246	EARTH CLAMP 300 A	1
34	04600002	85200	COMPLETE SPOOL HOLDER	1
35	21910046		FLUX CORED WIRE SPOOL .035 1/2LB.	1
36	05000170	85219	SIDE PANEL W/SCREEN PRINTING+LABEL	1
37	21610014	85231	FRONT PLASTIC FOOT	1
38	04600114	85204	KIT GAS/NO GAS CHANGE BOARD	1
39	21905041	85243	PLASTIC MASK 50X105	1
40	21905007	85241	ADIACTINIC GLASS 75X98 ART.471 DIN 11	1
41	21905039	85242	HAMMER - BRUSH	1



WIRE FEED WELDER GUN PARTS LIST

FIG #	OEM #	FORNEY #	DESCRIPTION	QTY
01	04600163	85296	HANDLE ASSY., BLUE	1
02	23005332	85190	GAS VALVE	1
03	23005145	85191	SWAN NECK WITH INSULATING COVER	1
04	23005091	85377	SWAN NECK LINER	1
05	23005285	85192	ISOLATING COVER FOR NECK	2
06	23005146	85295	TW1 TORCH DIFFUSER	1
07	23005018	60170	0.024 CONTACT TIP	1
07	23005019	60171	0.030 CONTACT TIP	1
07	23005020	60172	0.035 CONTACT TIP	1
08	23005147	85316	TORCH GAS NOZZLE	1
09	21200010	85313	FAST-ON CONTACT 6,3X0,8	1
10	33800032	85193	TORCH CONTACT SPRING	1
11	30900021	85194	RUBBER OUTER SLEEVE ø17,5 + HOSES	1
12	23005254	85317	STEEL LINER 1.4X4BLUE 2,2M W/END FITT	1
12A	30900002	85195	PLASTIC WIRE LINER 1,5X4 2,5M	1
13	22910001	85307	FAST CONNECTION FOR HOSE ø4 M6X0,75	1
13A	22910001	85307	END FITTING ø4 M6X0,75 FOR PLASTIC LIR	1
14	30900020	85195	TORCH GAS HOSE ø2X4 4,6M	1
15	04600063	85196	KIT 2 PINS MALE CONNECTOR + 2 CONT.	1
16	23005148	85376	NECK+OUTER INSULATION+DIFFUSER	1
17	23005318	85308	ALUMINIUM GAS VALVE + NECK + DIFF.	1



SUGGESTED SETTINGS

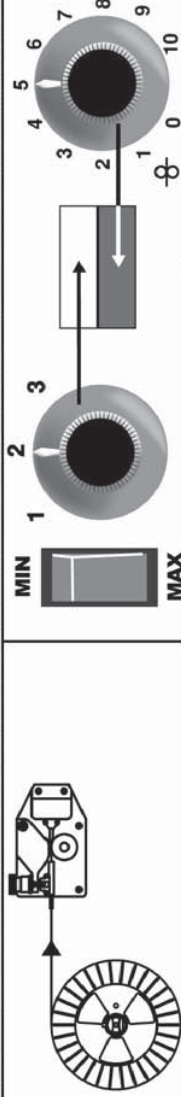


After installing new wire spool, make sure welding wire is inserted into torch hose liner and wire tension knob is correctly adjusted before pulling welding torch trigger

SET UP – SUGGESTED SETTING GUIDE

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These settings are suggested for initial set up. Variables including input voltage, wire and shielding gas will affect welding arc characteristics. Fine tune the arc to match travel speed and torch angle by adjusting the wire speed to achieve a smooth sounding arc.



PROCEDURE	WELDING WIRE	GAS	WIRE DIRECTION		VOLTAGE STEP		WIRE FEED SPEED	
			MIN	MAX	MIN	MAX	MIN	MAX
GASLESS DC (-)	.030 in (0,8 mm) Flux-Core Wire	NONE	24 gauge .024 in 0.61 mm	22 gauge .030 in 0.76mm	18 gauge .045 in 1.2mm	16 gauge .062 in 1.5mm	12 gauge .105 in 2.6mm	0.25 in 6.3mm
	.035 in (0,9 mm) Flux-Core Wire	NONE	-	MAX-1	MIN-2	MAX-2	MIN-3	MAX-3
	.024 in (0,6 mm) Steel Wire	C25 (75%Argon, 25% CO ₂)	MIN-1	MAX-1	MIN-2	MAX-2	MIN-3	MAX-3
MIG DC (+)	.030 in (0,8 mm) Steel Wire	C25 (75%Argon, 25% CO ₂)	2	MAX-1	MIN-2	MAX-2	MIN-3	MAX-3
	.035 in (0,9 mm) Steel Wire	C25 (75%Argon, 25% CO ₂)	-	MAX-1	MIN-2	MAX-2	MIN-3	MAX-3
		C25 (75%Argon, 25% CO ₂)	-	MAX-1	MIN-2	MAX-2	MIN-3	MAX-3

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