



ITEM# 85620

# SPOOL GUN QUICK START GUIDE

## SPOOL PRO™ HORNET SG 250™

**Forney**®

1.



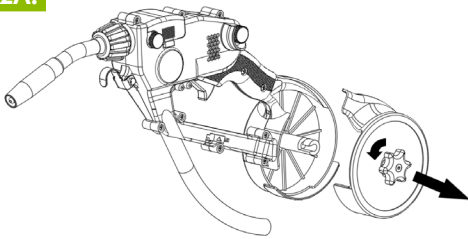
Read user manual

2.

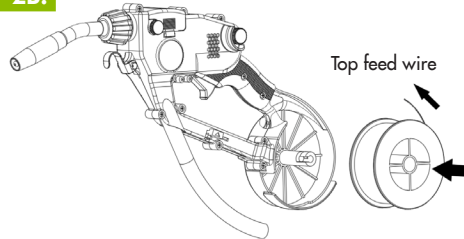
Install the welding wire



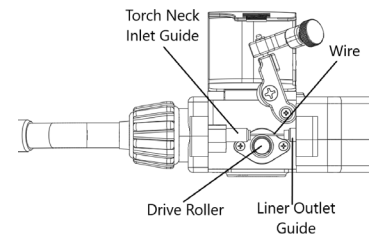
2A.



2B.



2C.



3.

Machine setup

3A.

If using a Forney multi-process (MP) machine, ensure process selector is set to "MIG"

3B.

MIG welding aluminum is a DCEP+ process

3C.

Forney® 220 MP:

Euro-Connect Amphenol Plug Ground Polarity Jumper



3D.

Forney® 190 MP:

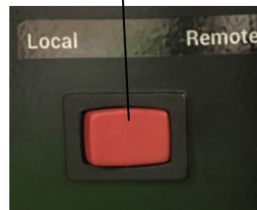
Euro-Connect Ground Amphenol Plug Polarity Change Cable Remote/Local Switch (Set to Remote)



Front of Machine

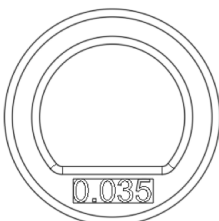


Inside of Cabinet

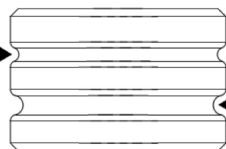


4.

A

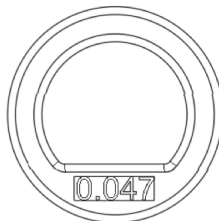


A



B

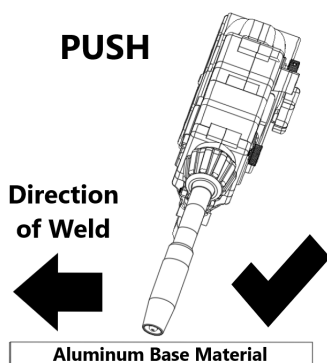
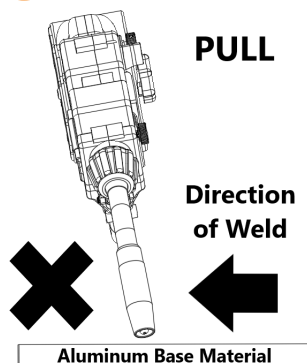
B



The 0.035" groove can also be used with 0.030" wire



## SPOOL GUN TROUBLESHOOTING TIPS



### TIP #1

To prevent burn-back issues, always use contact tips that are one size larger than the selected welding wire. For example, if using 0.030" wire, use an 0.035" contact tip

### TIP #2

When welding aluminum, ALWAYS use 100% pure Argon shielding gas

### TIP #3

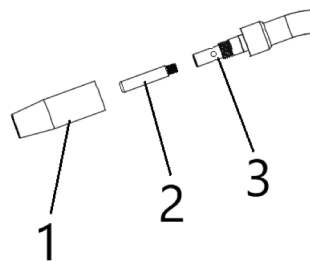
Use a slight push angle when using a spool gun

### Basic MIG Settings for 4XXX Series Aluminum

Material Thickness	Wire Diameter	Voltage (V)	Wire Feed Speed (IPM)	Material Thickness	Wire Diameter	Voltage (V)	Wire Feed Speed (IPM)
22 GA	0.030	13.5	200	1/8"	0.030	25	450
	0.035	13.5	150		0.035	25	410
	0.047	N/A	N/A		0.047	20.5	200
20 GA	0.030	13.5	240	3/16"	0.030	25	500
	0.035	13.5	220		0.035	25	450
	0.047	N/A	N/A		0.047	20.5	220
18 GA	0.030	14.5	290	1/4"	0.030	28.5	550
	0.035	14	220		0.035	27	525
	0.047	N/A	N/A		0.047	27.5	250
16 GA	0.030	15.5	340	3/8"	0.030	29	600
	0.035	15	250		0.035	28	550
	0.047	N/A	N/A		0.047	27.5	260
14 GA	0.030	16.5	370	1/2"	0.030	N/A	N/A
	0.035	15	270		0.035	29	600
	0.047	N/A	N/A		0.047	28	280
12 GA	0.030	17.5	425	3/4"	0.030	N/A	N/A
	0.035	17	325		0.035	N/A	N/A
	0.047	N/A	N/A		0.047	30	290

Always use 100% Pure Argon when welding aluminum

ITEM	Description	Industry Standard #
1	Gas Nozzle	TWECO 23-50
2	0.030" Contact Tip	TWECO 14H-30
2	0.035" Contact Tip	TWECO 14H-35
2	0.045" Contact Tip	TWECO 14H-45
3	Gas Diffuser	TWECO 52FN



FIND MORE INFORMATION AT [FORNEYIND.COM](http://FORNEYIND.COM)

QUESTIONS OR TROUBLE? Contact Forney Industries at 1-800-521-6038 [customerservice@forneyind.com](mailto:customerservice@forneyind.com)  
[forneyind.com](http://forneyind.com)