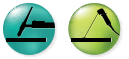


Forney® 180 ST+ STICK/TIG WELDER



ITEM# 321	APPLICATIONS: DIY/Garage Farm/Ranch Maintenance / Repair Light Industrial Welding Contractors	PROCESS: DC Stick (SMAW) Pulsed DC Stick (SMAW) DC TIG (GTAW)* Pulsed DC TIG (GTAW) INPUT POWER: 1 Ph -50/60Hz INPUT VOLTAGE: 120V/240V	OUTPUT AMPERAGE RANGE: 120V – 10 – 80A 240V – 10 – 180A	WELDING CAPACITY: 120V – 1/4" Mild Steel 240V – 3/8" Mild Steel WEIGHT: 11.9 lbs. (5.4 kg)



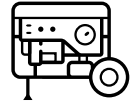
ITEM# 321

INCLUDES:

- ITEM# 321 180 ST+ welder
- 8' (2.4m) electrode holder & clamp
- 8' (2.4m) ground clamp & cable
- 240V to 120V adapter
- 6' (1.83m) power cord

GENERATOR FRIENDLY:

- 120V - 4,000W continuous output
- 240V - 10,500W continuous output



ITEM#	Process	Input Power	Amperage Range	Output/Stick Duty-Cycle	Output / TIG Duty-Cyle	Weight	Dimensions
321	DC Stick (SMAW)	120V - 50/60Hz	10A - 80A	30% @ 80A	80A @ 30%	11.9 lbs (5.4 kg)	L: 15" (380mm) W: 10.75" (285mm) H: 6.25" (159mm)
	DC TIG (GTAW)	240V - 50-60Hz	10A - 180A	25% @ 180A	180A @ 30%		

- Lightweight – at 11.9 pounds you can go anywhere easily
- Generator Friendly – extremely stable arc, even on a power generator
- Easy Start – Built-in hot start makes every strike easy
- Dual-Voltage – 120V and 240V makes it easy for you to find the right power for the job
- TIG Welder – DC lift arc TIG welding
- Powerful – with 180A you can weld up to 3/8"

THE FORNEY 180 ST+ IS YOUR SOLUTION FOR PORTABLE WELDING POWER

SP® CC/DC/1ph



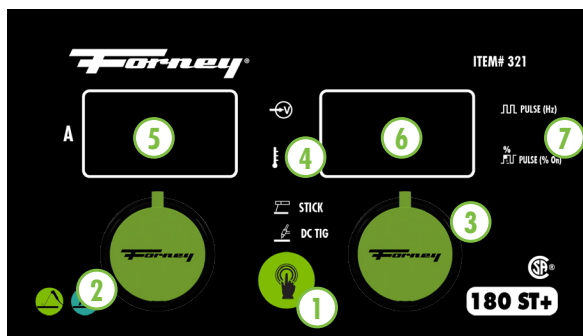
FORNEY INDUSTRIES

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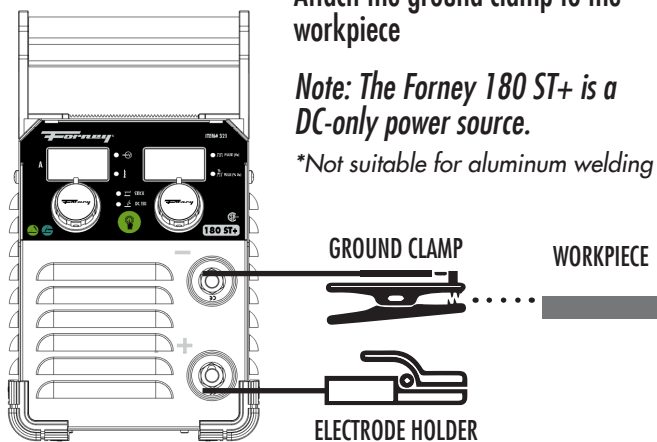


CONTROL PANEL



- | | |
|------------------------------|-----------------------------------|
| 1. Process selector button | 5. Amperage Display |
| 2. Amperage adjustment knob | 6. Pulse Setting Display |
| 3. Pulse adjustment knob | 7. Pulse Setting Indicator Lights |
| 4. Over temp indicator light | |

TYPICAL SET-UP



Attach the ground clamp to the workpiece

Note: The Forney 180 ST+ is a DC-only power source.

**Not suitable for aluminum welding*

ELECTRODE CHART

Excellent performance for most E6010, E6011, E7014 & E7018 electrodes.

Note: E6010: General welding acceptable but not recommended for open root pipe or long arc applications.

	DIAMETER		AMPS
	Inch	Millimeter	Amps
E6010 & E6011	3/32	2.4	30-75
	1/8	3.2	35-125
	5/32	4.0	80-160
E6013	1/16	1.6	10-50
	3/32	2.4	40-90
	1/8	3.2	50-130
	5/32	4.0	90-180
E7014	3/32	2.4	40-90
	1/8	3.2	60-130
	5/32	4.0	90-180
E7018	3/32	2.4	50-80
	1/8	3.2	80-160
	5/32	4.0	90-180

POLARITY CHART

ELECTRODE	DC	PENETRATION
E6010	EP	DEEP
E6011	EP	DEEP
E6013	EP-EN	SHALLOW
E7014	EP-EN	MEDIUM
E7018	EP-EN	MEDIUM
NICKEL	EP	SHALLOW
STAINLESS STEEL	EP	SHALLOW

EP = Electrode Positive • EN = Electrode Negative

ACCESSORIES (Not Included)

ITEM#	DESCRIPTION
85659	Air Cooled 150A 17FV Series (Flex & Valve) TIG Torch 12.5' with Dinse adapter
85364	Argon/CO2 Flow meter, CGA580 Inlet Connection
85669	Electrode Holder and lead (replacement part)
85667	Ground Clamp and lead (replacement part)
93097	Deluxe Electrode Storage Container
70600	Chipping Hammer, Spring Handle

Distributed by: