WELD EXAMPLES & TROUBLESHOOTING
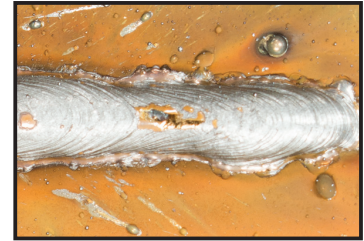
GOOD WELD

- Smooth bead
- Minimal spatter
- Good fusion

CURRENT/WFS TOO HIGH

- Too wide
- Bead too flat
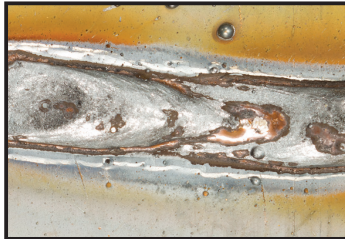
CURRENT TOO LOW

- Lack of fusion

WELD SPEED TOO FAST

- Stringy and lack of fusion

WELD SPEED TOO SLOW
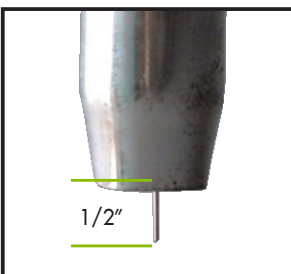

- Melt through

STICK OUT TOO LONG

- Excessive spatter

WELDING TIPS

OPTIMAL STICKOUT

1/2"

- Stickout 1/2" +/- 1/8"
- Short stickout = more current and more penetration
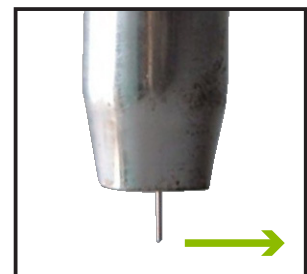
VOLTAGE

- Affects the arc shape
- Less voltage = tighter arc and potentially more spatter

WIRE FEED SPEED (WFS)

- Higher wire feed speed equals more amperage
- Can also affect arc shape and penetration

TRAVEL SPEED

- Affects bead width and height
- Can also affect penetration

	VOLTAGE	WIRE FEED SPEED	TRAVEL SPEED
THIN MATERIAL	Less voltage	Lower wire feed speed	Faster travel speed
THICK MATERIAL	More voltage	Higher wire feed speed	Slower travel speed

WARNING: To prevent fire and serious injury: Keep torch and wire clear of grounded objects while welder is plugged in. Be sure to follow safe welding procedures and wear proper PPE (clothes, welding helmet, safety glasses, welding gloves, boots, etc.).

242 DUAL MIG WELDER QUICK START GUIDE

1 Assemble front handle, trim pieces and wheels. *(Tools needed: screwdriver and snap ring pliers)*
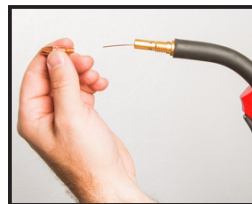
2 Attach gas bottles and regulator hose(s) assembly. *(Tool needed: adjustable wrench)*

3 Install wire spool. Insert wire through both wire liners and clamp it into wire drive. *Make sure drive roll, liner and tip are correct for wire diameter.*
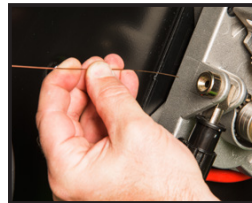
4 Install MIG gun, turn it on, and squeeze trigger until wire comes out.

5 Tighten wire feed tension knob clockwise until wire will bend from feed tension at 2"-3". Verify polarity is set correctly for MIG or Flux-core welding wire.

6 Adjust wire feed speed and voltage per chart on the inside of welder.

7 Dual MIG setup
#1 - Standard MIG
#2 - Spool Gun
Verify gas, switch position and output
(Note: Wire feed speed is adjusted on the spool gun.).