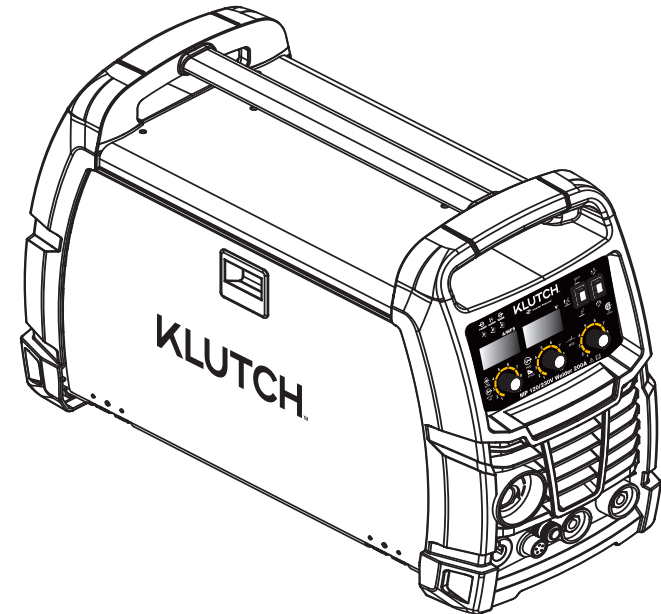


KLUTCH™

MP120/230V Welder 200A



KLUTCH™

Distributed by:

Northern Tool & Equipment Company, Inc.

Burnsville, Minnesota 55306

www.northerntool.com

Made in **China**

⚠ WARNING: Read carefully and understand all ASSEMBLY AND OPERATION INSTRUCTIONS before operating. Failure to follow the safety rules and other basic safety precautions may result in serious personal injury.

Item #5875893

READ & SAVE THESE INSTRUCTIONS

Table of Contents

GENERAL SAFETY INSTRUCTION	2
Description	6
Check the contents with the packing list below.....	6
Specifications and Dimension	7
Know your Welder	8
Installation	9
Operation	12
SPOOL GUN ASSEMBLY	23
Trouble shooting Chart	24
Main Circuit chart	26
Spare Part List	27
Repair Parts List	28
Service Maintenance, Transportation and Storage	29

Operating Instructions and Parts Manual

Please read and save these instructions. Read through this owner's manual carefully before using product. Protect yourself and others by observing all safety information, warnings, and cautions. Failure to comply with instructions could result in personal injury and/or damage to product or property. Please retain instructions for future reference.

GENERAL SAFETY INSTRUCTION

General Safety Information

1.1 Your Welding Environment

- Keep the environment you will be welding in free from flammable materials.
- Always keep a fire extinguisher accessible to your welding environment.
- Always have a qualified person install and operate this equipment.
- Make sure the area is clean, dry and ventilated. Do not operate the welder in humid, wet or poorly ventilated areas.
- Always have your welder maintained by a qualified technician in accordance with local, state and national codes.
- Always be aware of your work environment. Be sure to keep other people, especially children, away from you while welding.
- Keep harmful arc rays shielded from the view of others.
- Mount the welder on a secure bench or cart that will keep the welder secure and prevent it from tipping over or falling.

1.2 Your Welder's Condition

- Check ground cable, power cord and welding cable to be sure the insulation is not damaged. Always replace or repair damaged components before using the welder.
- Check all components to ensure they are clean and in good operating condition before use.

1.3 Use of Your Welder

▲ CAUTION

- Do not operate the welder if the output cable, electrode, MIG gun, wire or wire feed system is wet. Do not immerse them in water. These components and the welder must be completely dry before attempting to use them.
- Follow the instructions in this manual.
 - Keep welder in the off position when not in use.
 - Connect ground lead as close to the area being welded as possible to ensure a good ground.
 - Do not allow any body part to come in contact with the welding wire if you are in contact with the material being welded, ground or electrode from another welder.
 - Do not weld if you are in an awkward position. Always have a secure stance while welding to prevent accidents. Wear a safety harness if working above ground.
 - Do not drape cables over or around your body.
 - Wear a full coverage helmet with appropriate shade (see ANSI Z87.1 safety standard) and safety glasses while welding.

- Wear proper gloves and protective clothing to prevent your skin from being exposed to hot metals, UV and IR rays.
- Do not overuse or overheat your welder. Allow proper cooling time between duty cycles.
- Keep hands and fingers away from moving parts and stay away from the drive rolls.
- Do not point MIG gun at any body part of yourself or anyone else.
- Always use this welder in the rated duty cycle to prevent excessive heat and failure.

1.4 Specific Areas of Danger, Caution or Warning



Electrical Shock

▲ WARNING

Electric arc welders can produce a shock that can cause injury or death. Touching electrically live parts can cause fatal shocks and severe burns. While welding, all metal components connected to

the wire are electrically hot. Poor ground connections are a hazard, so secure the ground lead before welding.

- Wear dry protective apparel: coat, shirt, gloves and insulated footwear.
- Insulate yourself from the work piece. Avoid contacting the work piece or ground.
- Do not attempt to repair or maintain the welder while the power is on.
- Inspect all cables and cords for any exposed wire and replace immediately if found.
- Use only recommended replacement cables and cords.
- Always attach ground clamp to the work piece or work table as close to the weld area as possible.
- Do not touch the welding wire and the ground or grounded work piece at the same time.
- Do not use a welder to thaw frozen pipes.



Fumes and Gases

▲ WARNING

-Fumes emitted from the welding process displace clean air and can result in injury or death.

-Do not breathe in fumes emitted by the welding process. Make sure your breathing air is clean and safe.

- Work only in a well-ventilated area or use a ventilation device to remove welding fumes from the environment where you will be working.
- Do not weld on coated materials (galvanized, cadmium plated or containing zinc, mercury or barium). They will emit harmful fumes that are dangerous to breathe. If necessary use a ventilator, respirator with air supply or remove the coating from the material in the weld area.
- The fumes emitted from some metals when heated are extremely toxic. Refer to the material safety data sheet for the manufacturer's instructions.
- Do not weld near materials that will emit toxic fumes when heated. Vapors from cleaners, sprays and degreasers can be highly toxic when heated.

UV and IR Arc Rays



▲ DANGER

The welding arc produces ultraviolet (UV) and infrared (IR) rays that can cause injury to your eyes and skin. Do not look at the welding arc without proper eye protection.

- Always use a helmet that covers your full face from the neck to top of head and to the back of each ear.
- Use a lens that meets ANSI standards and safety glasses. For welders under 160 Amps output, use a shade 10 lens; for above 160 Amps, use a shade 12. Refer to the ANSI standard Z87.1 for more information.
- Cover all bare skin areas exposed to the arc with protective clothing and shoes. Flame-retardant cloth or leather shirts, coats, pants or coveralls are available for protection.
- Use screens or other barriers to protect other people from the arc rays emitted from your welding.
- Warn people in your welding area when you are going to strike an arc so they can protect themselves.



Fire Hazards

▲ WARNING

Do not weld on containers or pipes that contain or have had flammable, gaseous or liquid combustibles in them. Welding creates sparks and heat that can ignite flammable and explosive materials.

- Do not operate any electric arc welder in areas where flammable or explosive materials are present.
- Remove all flammable materials within 35 feet of the welding arc. If removal is not possible, tightly cover them with fireproof covers.
- Take precautions to ensure that flying sparks do not cause fires or explosions in hidden areas, cracks or areas you cannot see.
- Keep a fire extinguisher close in the case of fire.
- Wear garments that are oil-free with no pockets or cuffs that will collect sparks.
- Do not have on your person any items that are combustible, such as lighters or matches.
- Keep work lead connected as close to the weld area as possible to prevent any unknown, unintended paths of electrical current from causing electrical shock and fire hazards.
- To prevent any unintended arcs, cut wire back to ¼" stick out after welding.



Hot Materials

▲ CAUTION

Welded materials are hot and can cause severe burns if handled improperly.

- Do not touch welded materials with bare hands.
- Do not touch MIG gun nozzle after welding until it has had time to cool down.



Sparks/Flying Debris

▲ CAUTION

Welding creates hot sparks that can cause injury. Chipping slag off

welds creates flying debris.

-Wear protective apparel at all times: ANSI-approved safety glasses or shield, welder's hat and ear plugs to keep sparks out of ears and hair.



Electromagnetic Field

⚠ CAUTION

-Electromagnetic fields can interfere with various electrical and electronic devices such as pacemakers.
-Consult your doctor before using any electric arc welder or cutting

device

- Keep people with pacemakers away from your welding area when welding.
- Do not wrap cable around your body while welding.
- Wrap MIG gun and ground cable together whenever possible.
- Keep MIG gun and ground cables on the same side of your body.



Shielding Gas Cylinders Can Explode

⚠ WARNING

High pressure cylinders can explode if damaged, so treat them carefully.

- Never expose cylinders to high heat, sparks, open flames, mechanical shocks or arcs.
- Do not touch cylinder with MIG gun.
- Do not weld on the cylinder
- Always secure cylinder upright to a cart or stationary object.
- Keep cylinders away from welding or electrical circuits.
- Use the proper regulators, gas hose and fittings for the specific application.
- Do not look into the valve when opening it.
- Use protective cylinder cap whenever possible

1.5 Proper Care, Maintenance and Repair

⚠ DANGER

- Always have power disconnected when working on internal components.
- Do not touch or handle PC board without being properly grounded with a wrist strap. Put PC board in static proof bag to move or ship.
- Do not put hands or fingers near moving parts such as drive rolls of fan

Description

The MP 120/230V Welder 200A series is a DC inverter MIG welder

MP 120/230V Welder 200A uses 1~Phase 120V / 230V,50/60Hz AC power.

A 15 amp time delay fuse or circuit breaker is recommended. 10 A MIG/Flux Welder series is ideal for Do-It-Yourself projects or for light maintenance.MIG weld carbon steel, stainless steel . MP 120/230V Welder 200A is Spool Gun Ready.

The Spool Gun Quick DRAW is available for Optional Purchase. Using the spool gun allows you the capabilities of Welding Aluminum with 4" spools of aluminum wire.

Check the contents with the packing list below.

DC Inverter MIG Welder	1 unit
Grounding cable with clamp	1pcs
Regulator	1pcs
Gas hose	1pcs
Operator's Manual	1set
120 Power Adaptor	1pcs
Contact Tips	2pcs
Drive Roll	1pcs
DC Inverter MIG Welder	1 unit
13ft. TIG torch	1pcs
10ft.welding cable	1pcs

1.3 After unpacking unit, inspect carefully for any damage that may have occurred during transit. Check for loose, missing, or damaged parts. Shipping damage claim must be filed with carrier.

Specifications and Dimension

Description	Specification	
Model	MP 120/230V Welder 200A	
Input power V	120/230	
Frequency Hz	50/60	
Open Circuit Voltage	69V	
Current Input	22A @ 120V	36A @ 230V
Welding Current Range	@ 120V MIG: 30-140A MMA: 30-70A TIG: 20-90A	@ 230V MIG: 30-200A MMA: 30-170A TIG: 20-200A
Rated Duty Cycle	@ 120V MIG: 40% @ 90A MMA: 40% @ 70A TIG: 40% @ 90A	@ 230V MIG: 15% @ 200A MMA: 15% @ 170A TIG: 15% @ 200A
Insulation class	F	
Enclosure protection	IP21S	
Dimension L x W x H -INCH	19.29 x 8.66 x 14.96	
Weight -LBS	30.86	
Shipping Weight -LBS	44.4	

Welding types and specs:

You can choose between solid core welding wire and flux core welding wire for welding.

Suitable for various materials including carbon steel, stainless steel, copper silicon, and aluminum.

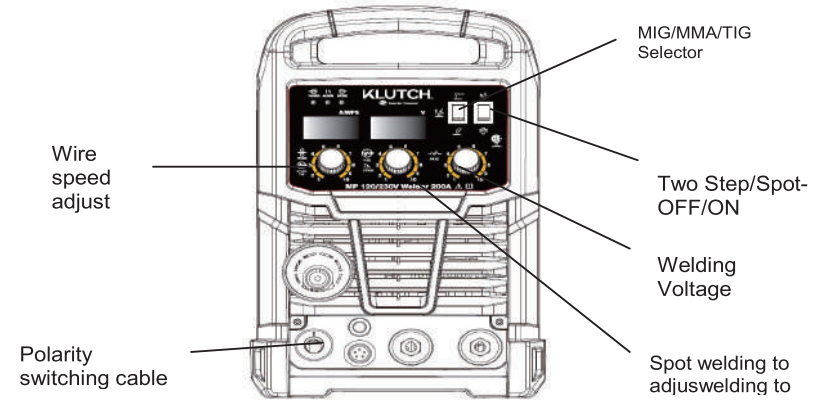
Selection:

Solid Core ("V"): 0.025"/0.030"/0.035" Flux Core("K"): 0.030"/0.035"

"V": Solid core

"K": Flux core

Know your Welder



POWER INDICATOR

When the machine is turned on, the power indicator will be on.

ALARM INDICATOR

When the thermal indicator is on, it shows the machine is overloaded and the internal temperature is too high. Weld output will turn off automatically but the fan will still be working. When the internal temperature is decreased, the overload light will turn off and the machine will be ready to weld.

WELDING VOLTAGE

Set output voltage and wire speed. Refer to the "set up" chart inside the wire feed compartment.

WIRE SPEED ADJUST

Adjusts the wire feeding/amperage speed.

WELDING CURRENT

Welding Current is on the front panel of machine. It is an infinite current output adjustment.

MIG/ STICK SELECTOR

When normal MIG welding, this switch should be turned in "MIG" position, when using the STICK welding.

MIG GUN

The welding wire is driven through the welding cable and MIG gun to the work piece. It is attached to the drive system.

POWER SWITCH

In the "OFF" position no power is being supplied.

In the "ON" position power is supplied to the main transformer and control circuit.

POWER CORD

The power cord connects the welder to the 120 volt power supply. 15amp receptacle to supply power to the welder.

WELDING CABLE

The welding cable are attached to electrode to complete the circuit, allowing the flow of current needed to weld.

GROUNFING CABLE

The ground cable/clamp are attached to the work piece to complete the circuit, allowing the flow of current needed to weld.

GAS HOSE

Used to connect the machine to the regulator.

Installation

1. Power requirement

AC single phase 120V,50/60HZ fused with a 15 amp time delayed fuse or circuit breaker is required.

⚠ WARNING

- High voltage danger from power source! Consult a qualified electrician for proper installation of receptacle. This welder must be grounded while in use to protect the operator from electrical shock.
- Do not remove grounding prong or alter the plug in any way. Do not use any adapters between the welder's power cord and the power source receptacle. Make sure the POWER switch is OFF when connecting your welder's power cord to a properly grounded 120Vac, 50/60Hz, single phase, 15 amp power source.

2. Extension cord

During normal use an extension cord is not necessary. It is strongly recommended that an extension cord should not be used because of the voltage drop they produce.

This drop in voltage can affect the performance of the welder. If you need to use an extension cord it must be a #12 gauge cord at the smallest. Do not use an extension cord over 25 ft. in length.

3. Setting up the work piece

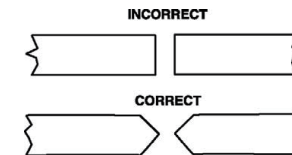
3.1 Welding positions

There are two basic positions, for welding: Flat and Horizontal. Flat welding is generally easier, faster, and allows for better penetration. If possible, the work piece should be positioned so that the bead will run on a flat surface.

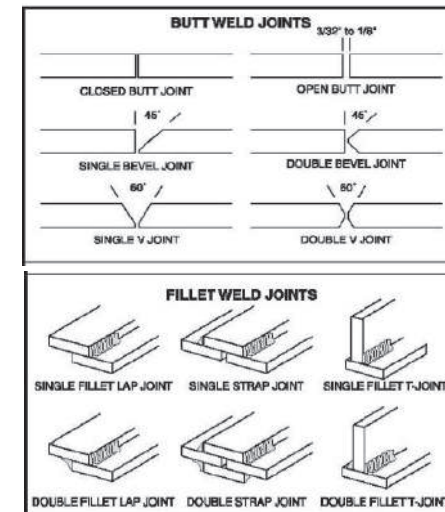
3.2 Preparing the Joint

Before welding, the surface of work piece needs to be free of dirt, rust, scale, oil or paint. Or it will create brittle and porous weld. If the base metal pieces to be joined are thick or heavy, it may be necessary to bevel the edges with a metal grinder. The correct bevel should be around 60 degrees.

See following picture:



Based on different welding position, there are different welding joint, see following images for more information



4. Ground clamp connection

Clear any dirt, rust, scale, oil or paint on the ground clamp. Make certain you have a good solid ground connection. A poor connection at the ground clamp will waste power and heat. Make sure the ground clamp touches the metal.

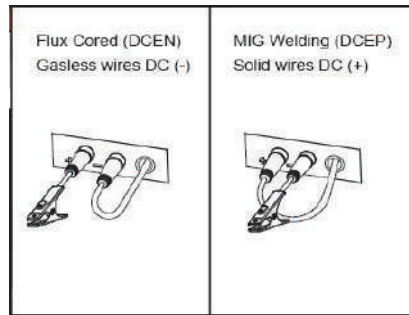
5. Setting the wire tension

⚠ WARNING

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

5.1. Press the trigger on the torch.

5.2. Turn the drive tension adjustment knob clockwise, increasing the drive tension until the wire seems to feed smoothly without slipping.



6. Gas installation

⚠ WARNING

Shielding gas cylinders and high pressure cylinders can explode. If damaged, so treat them carefully.

-Never expose cylinders to high heat, sparks, open flames, mechanical shocks or arcs.

-Do not touch cylinder with MIG gun.

-Do not weld on the cylinder.

-Always secure cylinder upright to a cart or stationary object.

-Keep cylinders away from welding or electrical circuits.

-Use the proper regulators, gas hose and fittings for the specific application.

When MIG (solid) wires are used, the shielding gas is required.

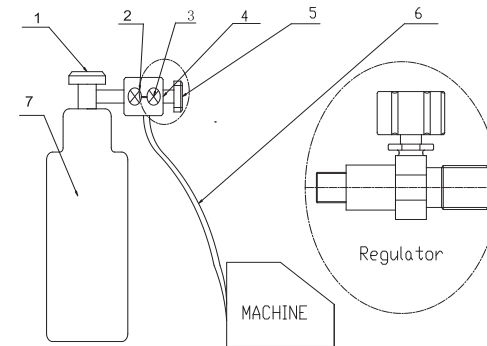
6.1. Polarity changing:

The factory polarity setting is for flux core welding (no shielding gas is required).

At this mode, the MIG gun lead is connect to “-” (negative) polarity and ground cable end is to “+” (positive). If MIG welding with shielding gas the MIG gun lead is to “+”, and ground cable is connected to “-”. Secure leads tight with fasteners. See illustrations below.

6.2. The gas hose, regulator and gas cylinder connection

Attach one end of the gas hose to the gas solenoid valve (gas inlet) located on the back panel of the welder. Attach the other end to the gas regulator which is attached to the shielding gas cylinder. See illustration below



1. Cylinder valve: Controls GAS CYLINDER gas flow.
2. Cylinder pressure gauge
3. Gas flow gauge, set at 20 CFH
4. Regulator
5. Adjustment knob controls gas pressure to the welder.
6. Gas hose
7. Gas cylinder

NOTE:

Slowly open the cylinder valve by turning it counterclockwise until the cylinder pressure gauge registers on the first gauge of the regulator. Turn the adjustment knob clockwise (right) slowly to increase gas flow to 20 cfm. To reduce the gas flow turn the adjustment counterclockwise (left). The gas valve is located on the back panel of the welder and activated by the trigger. Gas flow should be heard when the trigger is activated. No gas flow will result in a harsh arc with excessive spatter, a smooth weld bead will be difficult to obtain. Avoid unnecessary gas loss by closing the tank valve when finished welding.

6.3. Gas selection

Different materials require different shielding gas when MIG welding, refer to the set up chart inside the wire feed compartment.

Mild steel: Use 75% Argon and 25% CO₂ for reduced spatter and reduced penetration for thinner materials. Do NOT USE Argon gas concentrations higher than 75% on steel. The result will be extremely poor penetration, porosity, and brittleness of weld.

Mild Steel: Use CO₂ for deeper penetration but increased spatter.

Stainless steel: Use a mixed gas consisting of Helium, Argon and CO₂.

Operation

⚠ 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 before connecting your welder's power cord to a properly grounded 120, 50/60Hz, single phase, 15 amp power source.

Part1 The MIG welding operation

1. Main control component

Power switch - The power switch supplies electrical current to the welder. Whenever the power switch is in the ON position, the welding circuit is activated. ALWAYS turn the power switch to the OFF position and unplug the welder before performing any maintenance.

Voltage selector - The voltage selector controls the welding heat. This unit has infinite voltage control. Refer to the label inside the welder side door for recommended voltage selector settings for your welding job.

Wire speed control - The wire speed control adjusts the speed at which the wire is fed out of the welding torch. 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.

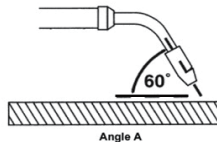
2. Hold the torch

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

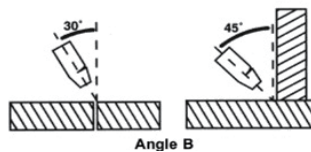
3. Position the torch to the work piece

There are two angles of the torch nozzle in relation to the work piece that must be considered when welding.

3.1. Angle A can be varied, but in most cases the optimum angle will be 60 degrees, the point at which the torch handle is parallel to the work piece. If angle A is increased, penetration will increase. If angle A is decreased, penetration will decrease also.



3.2. Angle B 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.



4. Distance from the work piece

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.

5. 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 or whenever any of the following variables are changed: heat setting, wire diameter, or wire type.

▲ 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, trousers with no cuffs, high topped shoes, and an ANSI approved welding helmet.

- 5.1. Connect the Ground Clamp to 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.
- 5.2. Select a heat setting. Refer to set up chart.
- 5.3. Hold the torch in one hand, allowing the nozzle to rest on the edge of the work piece farthest away from you, and at an angle similar to that which will be used when welding. (See HOLDING THE TORCH if you are uncertain of the angle at which you will be welding).
- 5.4. With your free hand, turn the Wire Speed Dial to maximum and continue to hold onto the knob.
- 5.5. Lower your welding helmet and pull the trigger on the torch to start an arc, then begin to drag the torch toward you while simultaneously turning the Wire Speed Dial counter-clockwise.
- 5.6. 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.

6. Welding Techniques

▲ WARNING

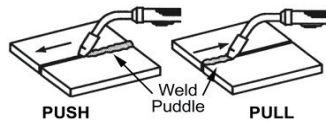
EXPOSURE TO A WELDING ARC IS EXTREMELY HARMFUL TO THE EYES AND SKIN! Prolonged exposure to the welding arc can cause blindness and burns. Never strike an arc or begin welding until you are adequately protected. Wear flameproof welding gloves, a heavy long sleeved shirt, trousers with out cuffs, high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

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

6.1 Moving the torch

Torch travel refers to the movement of the torch along the weld joint and is broken into two elements: Direction and Speed. A solid weld bead requires that the welding torch be moved steadily and at the right speed along the weld joint. Moving the torch too fast, too slow, or erratically will prevent proper fusion or create a lumpy, uneven bead.

Travel direction is the direction the torch is moved along the weld joint in relation to the weld puddle. The torch is either PUSHED into the weld puddle or PULLED away from the weld puddle.



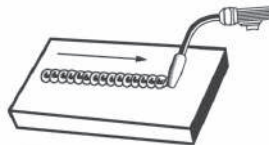
For most welding jobs you will pull the torch along the weld joint to take advantage of the greater weld puddle visibility.

Travel speed is the rate at which the torch 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.

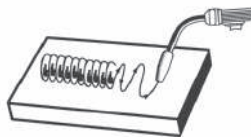
6.2 Types of welding beads

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.

The **STRINGER BEAD** is formed by traveling with the torch in a straight line while keeping the wire and nozzle centered over the weld joint (See following figure)

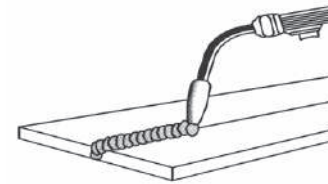


The **WEAVE BEAD** is used when you want to deposit metal over a wider space than would be possible with a stringer bead. It is made by weaving from side to side while moving with the torch. It is best to hesitate momentarily at each side before weaving back the other way.



6.3 Welding position

FLAT POSITION is 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.



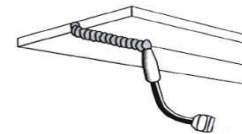
HORIZONTAL POSITION is performed very much the same as the flat weld except that angle B (see **HOLDING THE TORCH**) is such that the wire, directed more toward the metal above the weld joint is to help prevent the weld puddle from running downward while still allowing slow enough travel speed. A good starting point for angle B is about 30 degrees DOWN from being perpendicular to the work piece.



VERTICAL POSITION is easier for many people to pull the torch from top to bottom. It can be difficult to prevent the puddle from running downward. Pushing the torch 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 TORCH**) is usually always kept at zero, but angle A will generally range from 45 to 60 degrees to provide better puddle control.

OVERHEAD POSITION is the most difficult welding position. Angle A (see **HOLDING THE TORCH**) should be maintained at 60 degrees. Maintaining this angle will reduce the chances of molten metal falling into the nozzle.

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.

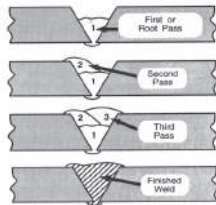


6.4 Multiple pass welding

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.

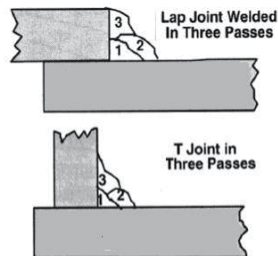
The illustrations in following figure show the sequence for laying multiple pass beads into a single “V” butt joint.



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.

Fillet Weld Joints. Most fillet weld joints, on metals of moderate to heavy thickness, will require multiple pass welds to produce 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.



7. Electrode

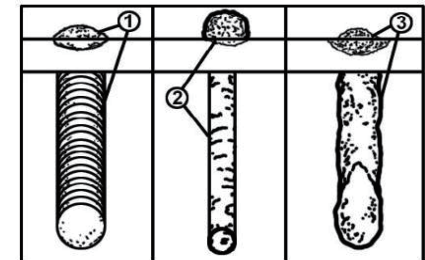
The welding electrode is a rod coated with a layer of flux. When welding, electrical current flows between the electrode (rod) and the grounded metal work piece. The intense heat of the arc between the rod and the grounded metal melts the electrode and the flux. The most popular electrodes are:

- E6011 60,000 PSI tensile strength deep penetrating applications.
- E6013 60,000 PSI tensile strength used for poor fit up applications
- E7014 70,000 PSI tensile strength used for high deposition and fast travel speeds with light penetration
- E7018 70,000 PSI tensile strength, Used for out of position and tacking.

8. Selecting the proper electrode

There is no golden rule that determine the exact rod or heat setting required for every situation. The type and thickness of metal and the position of the work piece determine the electrode type and the amount of heat needed in the welding process. Heavier and thicker metals required more amperage. It is best to practice your welds on scrap metal which matches the metal you intend to work with to determine correct heat setting and electrode choice.

See following some helpful trouble shooting tips to determine if you are using a correct electrode



1. When proper rod is used:

- a. The bead will lay smoothly over the work without ragged edges
- b. The base metal puddle will be as deep as the bead that rises above it
- c. The welding operation will make a crackling sound similar to the sound of eggs frying

2. When a rod too small is used:

- a. The bead will be high and irregular
- b. The arc will be difficult to maintain

3. When the rod is too large is used:

- a. The arc will burn through light metals
- b. The bead will undercut the work
- c. The bead will be flat and porous
- d. Rod may be freeze or stick to work piece

Note: Rate of travel over the work also affects the weld. To ensure proper penetration and enough deposit of rod, the arc must be moved slowly and evenly along the weld seam.

Operation

1. Setting the amperage control

The welder has an infinite output current control. It is capable of welding with

1/16" and 5/64" and 3/32" electrodes.

There is no golden rule that determines the exact amperage required for every situation. It is best to practice your welds on scrap metal which matches the metals you intend to work with to determine correct setting for your job. The electrode type and the thickness of the work piece metal determine the amount of heat needed in the welding process. Heavier and thicker metals require more voltage (amperage), whereas lighter and thinner metals require less voltage (amperage).

2. Welding techniques

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.

2.1 Holding the electrode

The best way to grip the electrode holder is the way that feels most comfortable to you. To position the electrode to the work piece when striking the initial arc it may be necessary to hold the electrode perpendicular to the work piece. Once the arc is started the angle of the electrode in relation to the work piece should be between 10 and 30 degrees. This will allow for good penetration, with minimal spatter.

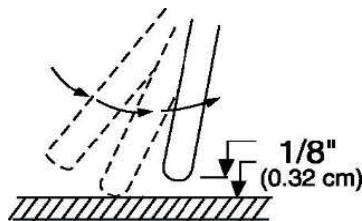
2.2 Striking the arc

▲ WARNING

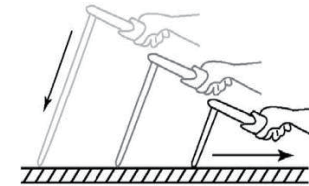
EXPOSURE TO A WELDING ARC IS EXTREMELY HARMFUL TO THE EYES AND SKIN.

- Never strike an arc or begin welding until you have adequate protection.
- Wear flameproof welding gloves, heavy long-sleeved shirt, cuffless trousers, high-topped shoes and a welding helmet or shield.

Scratch the work piece with the end of electrode to start arc and then raise it quickly about 1/8 inch gap between the rod and the work piece. See following picture



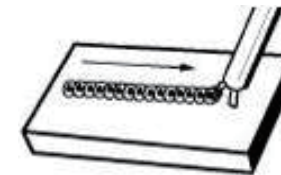
It is important that the gap be maintained during the welding process and it should be neither too wide or too narrow. If too narrow, the rod will stick to the work piece. If too wide, the arc will be extinguished. It needs much practice to maintain the gap. Beginners may usually get sticking or arc extinguishing. When the rod sticks to the work piece, gently rock it back and forth to make them separate. If not, the circuit is short connection, and it will overload the welder. A good arc is accompanied by a crisp, cracking sound. The sound is similar to that made by eggs frying. To lay a weld bead, only 2 movements are required; downward and in the direction the weld is to be laid, as in following figure:



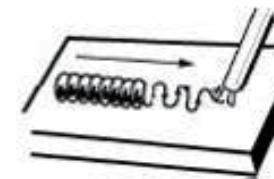
2.3 Types of weld bead

The following paragraphs discuss the most commonly used arc welding beads.

The stringer bead Formed by traveling with the electrode in a straight line while keeping it centered over the weld joint.



The weave bead 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 electrode. It is best to hesitate momentarily at each side before weaving back the other way to improve penetration.



2.4 Welding position

Flat position 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.

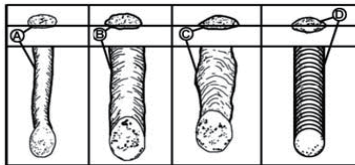


The horizontal position is performed very much the same as the flat weld except that the angle is different such that the electrode, and therefore the arc force, is directed more toward the metal above the weld joint. This more direct angle helps prevent the weld puddle from running downward while still allowing slow enough travel speed to achieve good penetration. A good starting point for your electrode angle is about 30 degrees down from being perpendicular to the work piece.



2.5 Judge a good weld bead

When the trick of establishing and holding an arc has been learned, the next step is learning how to run a good bead. The first attempts in practice will probably fall short of acceptable weld beads. Too long of an arc will be held or the travel speed will vary from slow to fast (see following)



- A. Weld speed is too fast.
- B. Weld speed is too slow.
- C. Arc is too long.
- D. Ideal weld.

A solid weld bead requires that the electrode be moved slowly and steadily along the weld seam. Moving the electrode rapidly or erratically will prevent proper fusion or create a lumpy, uneven bead. To prevent ELECTRIC SHOCK, do not perform any welding while standing, kneeling, or lying directly on the grounded work.

2.6 Finish the bead

As the coating on the outside of the electrode burns off, it forms an envelope of protective gasses around the weld. This prevents air from reaching the molten metal and creating an undesirable chemical reaction. The burning coating, however, forms slag. The slag formation appears as an accumulation of dirty metal scale on the finished weld. Slag should be removed by striking the weld with a chipping hamme.

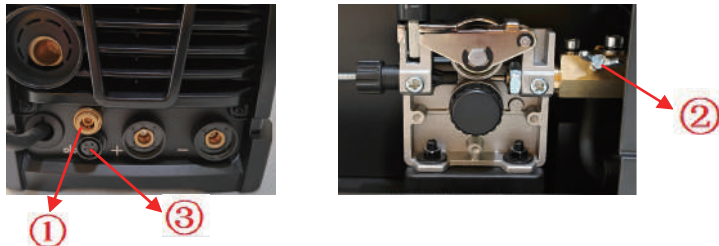
SPOOL GUN ASSEMBLY

1. This unit is set-up to accept the Quick Draw Spool gun only
2. the Quick Draw Spool gun has three connection points at the back of the spool gun(Figure 9)
 - 1) The gas connection is a slide-on quick connector.
 - 2) The weld power connection has a round ring connection.
 - 3) The trigger connection is the 5-Pin enap-on connector.



3. We recommend removing the MIG torch when the Spool Gun is connected to avoid accidental arcing. Loosen the wing nut retaining bolt and slide the MIG torch out of the front of the machine. Disconnect the 5-Pin trigger connection the front of the machine.

4. Carefully slide the gas connector and the weld power connection through the weld cable access opening in the front of the machine (Figure 10).



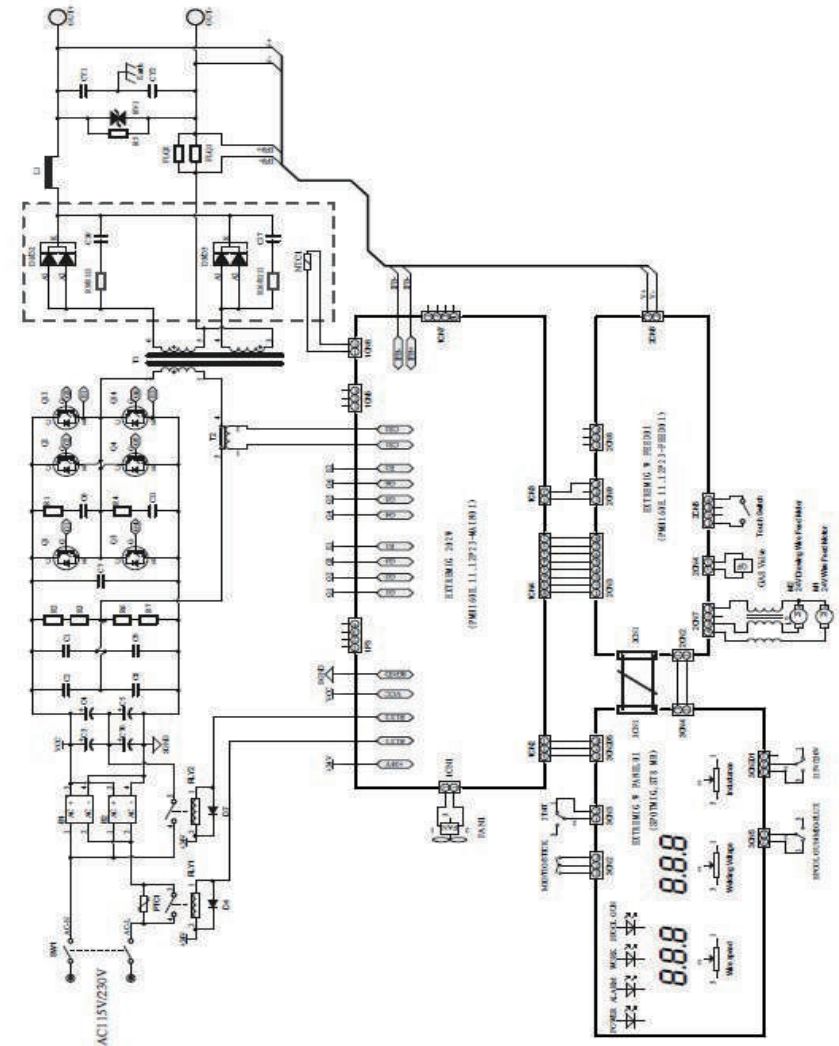
5. Open the wire compartment door.
6. Connect the gas connection quick connector to the gas connector(1) on the back panel of the wire compartment
7. Connect the weld power connection to the bold on the MIG connector(2)
8. Connect the 5-pin trigger connector to the 5-pin receptacle on the front of the machine(3)

Trouble shooting Chart

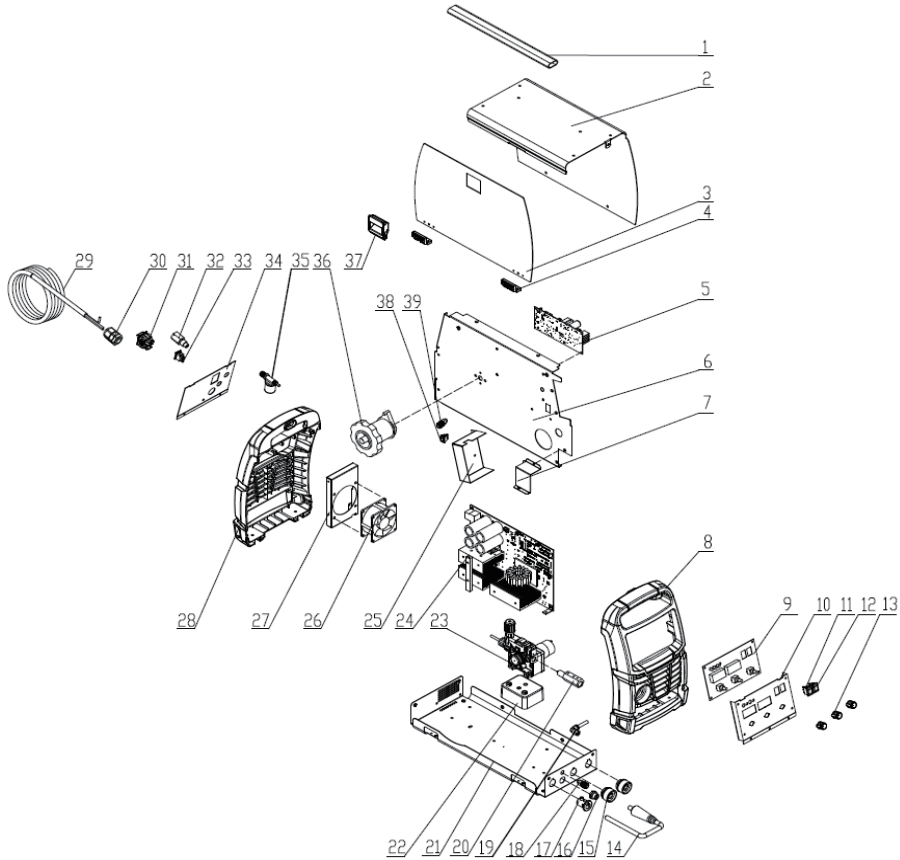
NO	Breakdown	Analysis	Solutions
1	Yellow Indicator is on	Voltage is too high ($\geq 15\%$)	Switch off power source; Check the main supply; Restart welder when power recovers to normal state.
		Voltage is too low ($\leq 15\%$)	
		Bad power ventilation lead to over-heat protection	Improve the ventilation condition.
		Circumstance temperature is too high.	It will automatically recover when the temperature low down.
		Using over the rated duty-cycle.	It will automatically recover when the temperature low down.
2	Wire feeding motor don't work	Potentiometer not in the proper status	Change potentiometer
		Nozzle is blocked up	Change nozzle
		Feed roller is loosen	Firm the bolts
3	Cooling Fan not working or turning very slowly	Switch broken	Replace the switch
		Fan broken	Replace or repair the fan
		Wire broken or falling off	Check the connection

4	Arc is not stable and splash is large	Too large contact tip makes the current unsteady	Change the proper contact tip or roller
		Too thin power cable makes the power astaticism	Change the power cable
		Too low input voltage	Enhance the input voltage
		Wire feeding resistance is too large	Clean or replace the liner and the torch cable had better in the line direction.
5	arc can't be pilot	Earth cable break	Connect earth cable
		Work piece has much greasy dirty or rusty stain	Clean greasy dirty or rusty stain
6	No shielded gas	Torch is not connected well	Connect the torch again
		Gas pipe is pressed or blocked up	Check gas system
		Gas system rubber pipe break	Connect gas system and bind firmly
7	Others		Please connect with our company

Main Circuit chart



Spare Part List



Repair Parts List

NO	CODE	DESCRIPTION	QTY
1	125700032	Handle	1
2	125200084	Endsoure	1
3	125200085	Door	1
4	125300111	Hinge	2
5	125300112	Control PCB	1
6	125300113	Middle Plate	1
7	125200086	Plate Cover	1
8	125200087	Plastic Front Panel	1
9	125200088	Front Control PCB	1
10	125300117	Front PCB Support	1
11	105200453	Welding Mode Switch	1
12	125300118	2T/4T	1
13	125300119	Knob	3
14	125300120	Polarity Cable	1
15	125300121	Dinse	1
16	125300122	5pin Control	1
17	125300096	Cable Clamp	1
18	125200093	Spool Gun Gas Connector	1
19	125300137	Gas Connector	1
20	125300124	Gun Connetor	1
21	125300125	Bottom Plate	1
22	125300126	Wire Feeder Support	1
23	125300127	Wire Feeder	1
24	125200089	Main Control PCB	1
25	125200091	Front Panel Cover	1
26	105800040	Fan	1
27	125200090	Fan Support	1
28	125300133	Plastic Back Panel	1
29	125300134	Power Cable	1
30	125300123	Cable Clamp	1
31	125300136	Power Switch	1
32	125300137	Gas Input	1
33	125200094	120/230V Input Switch	1
34	125300138	Back Plate	1
35	125300139	Gas Valve	1
36	125300140	Wire Spool	1
37	125200248	Latch	1
38	125200092	Spool Gun Function Switch	1
39	125300130	Gas Quick Connector	1set

Service, Maintenance, Transportation and Storage

The welder needs regular maintenance as following: Periodically clean dust, dirt, grease, etc. from your welder. Every six months, or as necessary, remove the cover panel from the welder and air-blow any dust and dirt that may have accumulated inside the welder. Replace power cord, ground cable, ground clamp, or electrode assembly when damaged or worn.

MINOR AND ROUTINE MAINTENANCE

Store in a clean dry facility free from corrosive gas, excess dust and high humidity. Temperature range from 10°F~120°F and the relative humidity not more than 90%. When transporting or storing the welder after use, it is recommended to repack the product as it was received for protection. (Cleaning is required before storage and you must seal the plastic bag in the box for storage.)