



OM-284833G

2025-01

Processes



MIG (GMAW) Welding



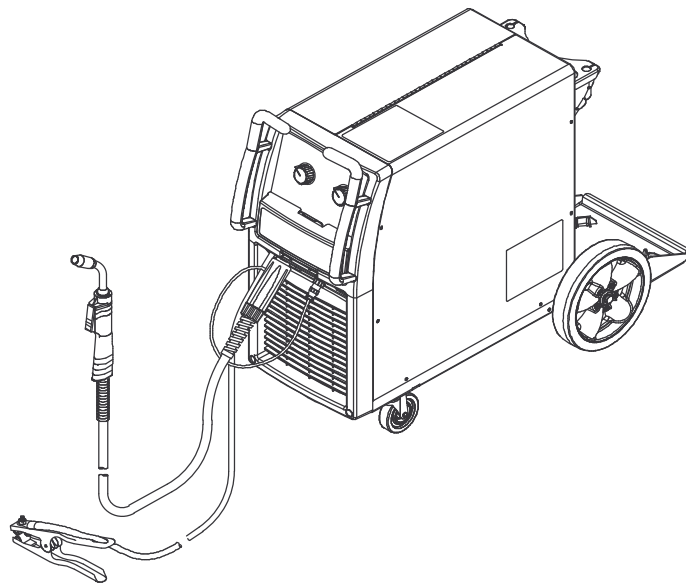
Flux Cored (FCAW) Welding

Description



Arc Welding Power Source And Wire Feeder

IronMan™ 240



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OWNER'S MANUAL

From Hobart to You

Thank you and congratulations on choosing Hobart. Now you can get the job done and get it done right. We know you don't have time to do it any other way.

This Owner's Manual is designed to help you get the most out of your Hobart products. Please take time to read the Safety Precautions. They will help you protect yourself against potential hazards on the worksite. We've made installation and operation quick and easy. With Hobart, you can count on years of reliable service with proper maintenance. And if for some reason the unit needs repair, there's a Troubleshooting section that will help you figure out what the problem is. The parts list will then help you to decide the exact part you may need to fix the problem. Warranty and service information for your particular model are also provided.

Hobart Welders manufactures a full line of welders and welding-related equipment. For information on other quality Hobart products, contact your local Hobart distributor to receive the latest full line catalog or individual specification sheets. **To locate your nearest distributor or service agency call 1-800-332-3281, or visit us at www.HobartWelders.com on the web.**



For Technical Help call 1-800-332-3281.

Register your product at www.HobartWelders.com



Hobart is registered to the ISO 9001 Quality System Standard.




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SECTION 1 – SAFETY PRECAUTIONS – READ BEFORE USING

 Protect yourself and others from injury—read, follow, and save these important safety precautions and operating instructions.

1-1. Symbol Usage

 **DANGER!** – Indicates a hazardous situation which, if not avoided, will result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.

 Indicates a hazardous situation which, if not avoided, could result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.


NOTICE – Indicates statements not related to personal injury.


 Indicates special instructions.




This group of symbols means Warning! Watch Out! ELECTRIC SHOCK, MOVING PARTS, and HOT PARTS hazards. Consult symbols and related instructions below for necessary actions to avoid these hazards.

1-2. Arc Welding Hazards

 The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard. The safety information given below is only a summary of the more complete safety information found in the Principal Safety Standards. Read and follow all Safety Standards.

 Only qualified persons should install, operate, maintain, and repair this equipment. A qualified person is defined as one who, by possession of a recognized degree, certificate, or professional standing, or who by extensive knowledge, training and experience, has successfully demonstrated the ability to solve or resolve problems relating to the subject matter, the work, or the project and has received safety training to recognize and avoid the hazards involved.

 During operation, keep everybody, especially children, away.



ELECTRIC SHOCK can kill.

Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on.

The input power circuit and machine internal circuits are also live when power is on. In semiautomatic or automatic wire welding, the wire, wire reel, drive roll housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is a hazard.

- Do not touch live electrical parts.
- Wear dry, hole-free insulating gloves and body protection.
- Insulate yourself from work and ground using dry insulating mats or covers big enough to prevent any physical contact with the work or ground.
- Do not use AC weld output in damp, wet, or confined spaces, or if there is a danger of falling.
- Do not store or use equipment in standing water.
- Use AC output ONLY if required for the welding process.
- If AC output is required, use remote output control if present on unit.
- Additional safety precautions are required when any of the following electrically hazardous conditions are present: in damp locations or while wearing wet clothing; on metal structures such as floors, gratings, or scaffolds; when in cramped positions such as sitting, kneeling, or lying; or when there is a high risk of unavoidable or accidental contact with the workpiece or ground. For these conditions, use the following equipment in order presented: 1) a semiautomatic DC constant voltage (wire) welder, 2) a DC manual

(stick) welder, or 3) an AC welder with reduced open-circuit voltage. In most situations, use of a DC, constant voltage wire welder is recommended. And, do not work alone!

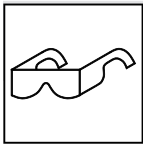
- Disconnect input power or stop engine before installing or servicing this equipment. Lockout/tagout input power according to OSHA 29 CFR 1910.147 (see Safety Standards).
- Properly install, ground, and operate this equipment according to its Owner's Manual and national, state, and local codes.
- Always verify the supply ground—check and be sure that input power cord ground wire is properly connected to ground terminal in disconnect box or that cord plug is connected to a properly grounded receptacle outlet.
- When making input connections, attach proper grounding conductor first—double-check connections.
- Keep cords dry, free of oil and grease, and protected from hot metal and sparks.
- Frequently inspect input power cord and ground conductor for damage or bare wiring—replace immediately if damaged—bare wiring can kill.
- Turn off all equipment when not in use.
- Do not use worn, damaged, undersized, or repaired cables.
- Do not drape cables over your body.
- If earth grounding of the workpiece is required, ground it directly with a separate cable.
- Do not touch electrode if you are in contact with the work, ground, or another electrode from a different machine.
- Use only well-maintained equipment. Repair or replace damaged parts at once. Maintain unit according to manual.
- Do not touch electrode holders connected to two welding machines at the same time since double open-circuit voltage will be present.
- Wear a safety harness if working above floor level.
- Keep all panels and covers securely in place.
- Clamp work cable with good metal-to-metal contact to workpiece or worktable as near the weld as practical.
- Insulate work clamp when not connected to workpiece to prevent contact with any metal object.
- Do not connect more than one electrode or work cable to any single weld output terminal. Disconnect cable for process not in use.
- Use GFCI protection when operating auxiliary equipment in damp or wet locations.



HOT PARTS can burn.

- Do not touch hot parts bare handed.
- Allow cooling period before working on equipment.
- To handle hot parts, use proper tools and/or wear heavy, insulated welding gloves and clothing to

prevent burns.



FLYING METAL OR DIRT can injure eyes.

- Welding, chipping, wire brushing, and grinding cause sparks and flying metal. As welds cool, they can throw off slag.
- Wear approved safety glasses with side shields even under your welding helmet.



FUMES AND GASES can be hazardous.

Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

- Keep your head out of the fumes. Do not breathe the fumes.
- Ventilate the work area and/or use local forced ventilation at the arc to remove welding fumes and gases. The recommended way to determine adequate ventilation is to sample for the composition and quantity of fumes and gases to which personnel are exposed.
- If ventilation is poor, wear an approved air-supplied respirator.
- Read and understand the Safety Data Sheets (SDSs) and the manufacturer's instructions for adhesives, coatings, cleaners, consumables, coolants, degreasers, fluxes, and metals.
- Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Always have a trained watchperson nearby. Welding fumes and gases can displace air and lower the oxygen level causing injury or death. Be sure the breathing air is safe.
- Do not weld in locations near degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapors to form highly toxic and irritating gases.
- Do not weld on coated metals, such as galvanized, lead, or cadmium plated steel, unless the coating is removed from the weld area, the area is well ventilated, and while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes if welded.



BUILDUP OF GAS can injure or kill.

- Shut off compressed gas supply when not in use.
- Always ventilate confined spaces or use approved air-supplied respirator.



ARC RAYS can burn eyes and skin.

Arc rays from the welding process produce intense visible and invisible (ultraviolet and infrared) rays that can burn eyes and skin. Sparks fly off from the weld.

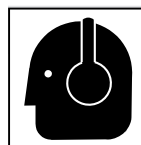
- Wear an approved welding helmet fitted with a proper shade of filter lenses to protect your face and eyes from arc rays and sparks when welding or watching (see ANSI Z49.1 and Z87.1 listed in Safety Standards).
- Wear approved safety glasses with side shields under your helmet.
- Use protective screens or barriers to protect others from flash, glare, and sparks; warn others not to watch the arc.
- Wear body protection made from leather or flame-resistant clothing (FRC). Body protection includes oil-free clothing such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap.



WELDING can cause fire or explosion.

Welding on closed containers, such as tanks, drums, or pipes, can cause them to blow up. Sparks can fly off from the welding arc. The flying sparks, hot workpiece, and hot equipment can cause fires and burns. Accidental contact of electrode to metal objects can cause sparks, explosion, overheating, or fire. Check and be sure the area is safe before doing any welding.

- Remove all flammables within 35 ft (10.7 m) of the welding arc. If this is not possible, tightly cover them with approved covers.
- Do not weld where flying sparks can strike flammable material.
- Protect yourself and others from flying sparks and hot metal.
- Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas.
- Watch for fire, and keep a fire extinguisher nearby.
- Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.
- Do not cut or weld on tire rims or wheels. Tires can explode if heated. Repaired rims and wheels can fail. See OSHA 29 CFR 1910.177 listed in Safety Standards.
- Do not weld on containers that have held combustibles, or on closed containers such as tanks, drums, or pipes unless they are properly prepared according to AWS F4.1 (see Safety Standards).
- Do not weld where the atmosphere can contain flammable dust, gas, or liquid vapors (such as gasoline).
- Connect work cable to the work as close to the welding area as practical to prevent welding current from traveling long, possibly unknown paths and causing electric shock, sparks, and fire hazards.
- Do not use welder to thaw frozen pipes.
- Remove stick electrode from holder or cut off welding wire at contact tip when not in use.
- Wear body protection made from leather or flame-resistant clothing (FRC). Body protection includes oil-free clothing such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap.
- Remove any combustibles, such as a butane lighter or matches, from your person before doing any welding.
- After completion of work, inspect area to ensure it is free of sparks, glowing embers, and flames.
- Use only correct fuses or circuit breakers. Do not oversize or bypass them.
- Follow requirements in OSHA 1910.252 (a) (2) (iv) and NFPA 51B for hot work and have a fire watcher and extinguisher nearby.
- Read and understand the Safety Data Sheets (SDSs) and the manufacturer's instructions for adhesives, coatings, cleaners, consumables, coolants, degreasers, fluxes, and metals.



NOISE can damage hearing.

Noise from some processes or equipment can damage hearing.

- Wear approved ear protection if noise level is high.



ELECTRIC AND MAGNETIC FIELDS (EMF) can affect Implanted Medical Devices.

- Wearers of Pacemakers and other Implanted Medical Devices should keep away.
- Implanted Medical Device wearers should consult their doctor and the device manufacturer before going near arc welding, spot welding, gouging, plasma arc cutting, or induction heating operations.



CYLINDERS can explode if damaged.

Compressed gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Since gas cylinders are normally part of the welding process, be sure to treat them carefully.

- Protect compressed gas cylinders from excessive heat, mechanical shocks, physical damage, slag, open flames, sparks, and arcs.
- Install cylinders in an upright position by securing to a stationary support or cylinder rack to prevent falling or tipping.
- Keep cylinders away from any welding or other electrical circuits.
- Never drape a welding torch over a gas cylinder.
- Never allow a welding electrode to touch any cylinder.

- Never weld on a pressurized cylinder—explosion will result.
- Use only correct compressed gas cylinders, regulators, hoses, and fittings designed for the specific application; maintain them and associated parts in good condition.
- Turn face away from valve outlet when opening cylinder valve. Do not stand in front of or behind the regulator when opening the valve.
- Keep protective cap in place over valve except when cylinder is in use or connected for use.
- Use the proper equipment, correct procedures, and sufficient number of persons to lift, move, and transport cylinders.
- Read and follow instructions on compressed gas cylinders, associated equipment, and Compressed Gas Association (CGA) publication P-1 listed in Safety Standards.

1-3. Additional Hazards For Installation, Operation, And Maintenance



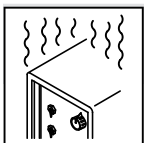
FIRE OR EXPLOSION hazard.

- Do not install or place unit on, over, or near combustible surfaces.
- Do not install unit near flammables.
- Do not overload building wiring—be sure power supply system is properly sized, rated, and protected to handle this unit.



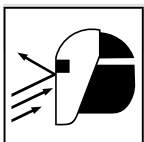
FALLING EQUIPMENT can injure.

- Use lifting eye to lift unit only, NOT running gear, gas cylinders, or any other accessories.
- Use correct procedures and equipment of adequate capacity to lift and support unit.
- If using lift forks to move unit, be sure forks are long enough to extend beyond opposite side of unit.
- Keep equipment (cables and cords) away from moving vehicles when working from an aerial location.
- Follow the guidelines in the Applications Manual for the Revised NIOSH Lifting Equation (Publication No. 94-110) when manually lifting heavy parts or equipment.



OVERUSE can cause OVERHEATING.

- Allow cooling period; follow rated duty cycle.
- Reduce current or reduce duty cycle before starting to weld again.
- Do not block or filter airflow to unit.



FLYING SPARKS can injure.

- Wear a face shield to protect eyes and face.
- Shape tungsten electrode only on grinder with proper guards in a safe location wearing proper face, hand, and body protection.
- Sparks can cause fires—keep flammables away.



STATIC (ESD) can damage PC boards.

- Put on grounded wrist strap BEFORE handling boards or parts.
- Use proper static-proof bags and boxes to store, move, or ship PC boards.



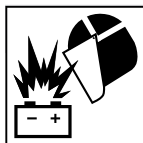
MOVING PARTS can injure.

- Keep away from moving parts.
- Keep away from pinch points such as drive rolls.



WELDING WIRE can injure.

- Do not press gun trigger until instructed to do so.
- Do not point gun toward any part of the body, other people, or any metal when threading welding wire.



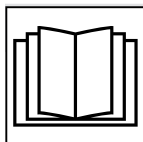
BATTERY EXPLOSION can injure.

- Do not use welder to charge batteries or jump start vehicles unless it has a battery charging feature designed for this purpose.



MOVING PARTS can injure.

- Keep away from moving parts such as fans.
- Keep all doors, panels, covers, and guards closed and securely in place.
- Have only qualified persons remove doors, panels, covers, or guards for maintenance and troubleshooting as necessary.
- Reinstall doors, panels, covers, or guards when maintenance is finished and before reconnecting input power.



READ INSTRUCTIONS.

- Read and follow all labels and the Owner's Manual carefully before installing, operating, or servicing unit. Read the safety information at the beginning of the manual and in each section.
- Use only genuine replacement parts from the manufacturer.
- Perform installation, maintenance, and service according to the Owner's Manuals, industry standards, and national, state, and local codes.



H.F. RADIATION can cause interference.

- High-frequency (H.F.) can interfere with radio navigation, safety services, computers, and communications equipment.
- Have only qualified persons familiar with electronic equipment perform this installation.
- The user is responsible for having a qualified electrician promptly correct any interference problem resulting from the installation.
- If notified by the FCC about interference, stop using the equipment at once.
- Have the installation regularly checked and maintained.
- Keep high-frequency source doors and panels tightly shut, keep spark gaps at correct setting, and use grounding and shielding to minimize the possibility of interference.



ARC WELDING can cause interference.

- Electromagnetic energy can interfere with sensitive electronic equipment such as microprocessors, computers, and computer-driven equipment such as robots.
- Be sure all equipment in the welding area is electromagnetically compatible.

- To reduce possible interference, keep weld cables as short as possible, close together, and down low, such as on the floor.
- Locate welding operation 100 meters from any sensitive electronic equipment.
- Be sure this welding machine is installed and grounded according to this manual.
- If interference still occurs, the user must take extra measures such as moving the welding machine, using shielded cables, using line filters, or shielding the work area.

1-4. California Proposition 65 Warnings

⚠ WARNING – This product can expose you to chemicals including lead, which are known to the state of California to cause cancer and birth defects or other reproductive harm.

For more information, go to www.P65Warnings.ca.gov.

1-5. Principal Safety Standards

Safety in Welding, Cutting, and Allied Processes, American Welding Society standard ANSI Standard Z49.1. Website: www.aws.org.

Safe Practice For Occupational And Educational Eye And Face Protection, ANSI Standard Z87.1, from American National Standards Institute. Website: safetyequipment.org.

Safe Practices for the Preparation of Containers and Piping for Welding and Cutting, American Welding Society Standard AWS F4.1. Website: www.aws.org.

National Electrical Code, NFPA Standard 70 from National Fire Protection Association. Website: www.nfpa.org.

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1 from Compressed Gas Association. Website: www.cganet.com.

Safety in Welding, Cutting, and Allied Processes, CSA Standard W117.2 from Canadian Standards Association. Website: www.csagroup.org.

Standard for Fire Prevention During Welding, Cutting, and Other Hot Work, NFPA Standard 51B from National Fire Protection Association. Website: www.nfpa.org.

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910.177 Subpart N, Part 1910 Subpart Q, and Part 1926, Subpart J. Website: www.osha.gov.

OSHA Important Note Regarding the ACGIH TLV, Policy Statement on the Uses of TLVs and BEIs. Website: www.osha.gov.

Applications Manual for the Revised NIOSH Lifting Equation from the National Institute for Occupational Safety and Health (NIOSH). Website: www.cdc.gov/NIOSH.

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1-6. EMF Information

Electric current flowing through any conductor causes localized electric and magnetic fields (EMF). The current from arc welding (and allied processes including spot welding, gouging, plasma arc cutting, and induction heating operations) creates an EMF field around the welding circuit. EMF fields can interfere with some medical implants, e.g. pacemakers. Protective measures for persons wearing medical implants have to be taken. For example, restrict access for passers –by or conduct individual risk assessment for welders. All welders should use the following procedures in order to minimize exposure to EMF fields from the welding circuit:

1. Keep cables close together by twisting or taping them, or using a cable cover.
2. Do not place your body between welding cables. Arrange cables to one side and away from the operator.
3. Do not coil or drape cables around your body.

4. Keep head and trunk as far away from the equipment in the welding circuit as possible.
5. Connect work clamp to workpiece as close to the weld as possible.
6. Do not work next to, sit or lean on the welding power source.
7. Do not weld whilst carrying the welding power source or wire feeder.

About Implanted Medical Devices:

Implanted Medical Device wearers should consult their doctor and the device manufacturer before performing or going near arc welding, spot welding, gouging, plasma arc cutting, or induction heating operations. If cleared by your doctor, then following the above procedures is recommended.

SECTION 2 – CONSIGNES DE SÉCURITÉ - LIRE AVANT UTILISATION

⚠ Pour écarter les risques de blessure pour vous-même et pour autrui — lire, appliquer et ranger en lieu sûr ces consignes relatives aux précautions de sécurité et au mode opératoire.

2-1. Symboles utilisés

⚠ **DANGER!** – Indique une situation dangereuse qui si on l'évite pas peut donner la mort ou des blessures graves. Les dangers possibles sont montrés par les symboles joints ou sont expliqués dans le texte.

⚠ Indique une situation dangereuse qui si on l'évite pas peut donner la mort ou des blessures graves. Les dangers possibles sont montrés par les symboles joints ou sont expliqués dans le texte.

AVIS – Indique des déclarations pas en relation avec des blessures personnelles.

👉 Indique des instructions spécifiques.



Ce groupe de symboles veut dire Avertissement! Attention! DANGER DE CHOC ELECTRIQUE, PIECES EN MOUVEMENT, et PIECES CHAUDES. Reportez-vous aux symboles et aux directives ci-dessous afin de connaître les mesures à prendre pour éviter tout danger.

2-2. Dangers relatifs au soudage à l'arc

⚠ Les symboles représentés ci-dessous sont utilisés dans ce manuel pour attirer l'attention et identifier les dangers possibles. En présence de ce symbole, prendre garde et suivre les instructions afférentes pour éviter tout risque. Les consignes de sécurité présentées ci-après ne font que résumer l'information contenue dans les Normes de sécurité principales. Lire et suivre toutes les Normes de sécurité.

⚠ L'installation, l'utilisation, l'entretien et les réparations ne doivent être confiés qu'à des personnes qualifiées. Une personne qualifiée est définie comme celle qui, par la possession d'un diplôme reconnu, d'un certificat ou d'un statut professionnel, ou qui, par une connaissance, une formation et une expérience approfondies, a démontré avec succès sa capacité à résoudre les problèmes liés à la tâche, le travail ou le projet et a reçu une formation en sécurité afin de reconnaître et d'éviter les risques inhérents.

⚠ Au cours de l'utilisation, tenir toute personne à l'écart et plus particulièrement les enfants.



UNE DÉCHARGE ÉLECTRIQUE peut entraîner la mort.

Le contact d'organes électriques sous tension peut provoquer des accidents mortels ou des brûlures graves. Le circuit de l'électrode et de la pièce est sous tension lorsque le courant est délivré à la sortie. Le circuit d'alimentation et les circuits internes de la machine sont également sous tension lorsque l'alimentation est sur Marche. Dans le mode de soudage avec du fil, le fil, le dérouleur, le bloc de commande du rouleau et toutes les parties métalliques en contact avec le fil sont sous tension électrique. Un équipement installé ou mis à la terre de manière incorrecte ou impropre constitue un danger.

- Ne pas toucher aux pièces électriques sous tension.
- Porter des gants isolants et des vêtements de protection secs et sans trous.
- S'isoler de la pièce à couper et du sol en utilisant des housses ou des tapis assez grands afin d'éviter tout contact physique avec la pièce à couper ou le sol.
- Ne pas utiliser de sortie de soudage CA dans des zones humides ou confinées ou s'il y a un risque de chute.
- Ne stockez pas et n'utilisez pas l'équipement dans de l'eau stagnante.
- Se servir d'une source électrique à courant électrique UNIQUEMENT si le procédé de soudage le demande.
- Si l'utilisation d'une source électrique à courant électrique s'avère nécessaire, se servir de la fonction de télécommande si l'appareil en est équipé.

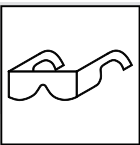
- D'autres consignes de sécurité sont nécessaires dans les conditions suivantes : risques électriques dans un environnement humide ou si l'on porte des vêtements mouillés ; sur des structures métalliques telles que sols, grilles ou échafaudages ; en position coincée comme assise, à genoux ou couchée ; ou s'il y a un risque élevé de contact inévitable ou accidentel avec la pièce à souder ou le sol. Dans ces conditions, utiliser les équipements suivants, dans l'ordre indiqué : 1) un poste à souder DC à tension constante (à fil), 2) un poste à souder DC manuel (électrode) ou 3) un poste à souder AC à tension à vide réduite. Dans la plupart des situations, l'utilisation d'un poste à souder DC à fil à tension constante est recommandée. En outre, ne pas travailler seul !
- Couper l'alimentation ou arrêter le moteur avant de procéder à l'installation, à la réparation ou à l'entretien de l'appareil. Déverrouiller l'alimentation selon la norme OSHA 29 CFR 1910.147 (voir normes de sécurité).
- Brancher correctement la mise à la terre et utiliser cet appareil conformément à son manuel d'utilisateur et aux codes nationaux, provinciaux et municipaux.
- Toujours vérifier la mise à la terre — vérifier et assurez-vous que le conducteur de mise à la terre du cordon d'alimentation est bien raccordé à la borne de mise à la terre dans le boîtier de déconnexion ou que la fiche du cordon est raccordée à une prise correctement mise à la terre.
- En effectuant les raccordements d'entrée, fixer d'abord le conducteur de mise à la terre approprié et contre-vérifier les connexions.
- Les câbles doivent être exempts d'humidité, d'huile et de graisse; protégez-les contre les étincelles et les pièces métalliques chaudes.
- Vérifier fréquemment le cordon d'alimentation et le conducteur de mise à la terre afin de s'assurer qu'il n'est pas altéré ou dénudé -, le remplacer immédiatement s'il l'est -. Un fil dénudé peut entraîner la mort.
- L'équipement doit être hors tension lorsqu'il n'est pas utilisé.
- Ne pas utiliser des câbles usés, endommagés, de grosseur insuffisante ou mal épissés.
- Ne pas enrôler les câbles autour du corps.
- Si la pièce soudée doit être mise à la terre, le faire directement avec un câble distinct.
- Ne pas toucher l'électrode quand on est en contact avec la pièce, la terre ou une électrode provenant d'une autre machine.
- Ne pas toucher des porte électrodes connectés à deux machines en même temps à cause de la présence d'une tension à vide doublée.
- N'utiliser qu'un matériel en bon état. Réparer ou remplacer sur-le-champ les pièces endommagées. Entretien l'appareil conformément à ce manuel.

- Porter un harnais de sécurité si l'on doit travailler au-dessus du sol.
- S'assurer que tous les panneaux et couvercles sont correctement en place.
- Fixer le câble de retour de façon à obtenir un bon contact métal-métal avec la pièce à souder ou la table de travail, le plus près possible de la soudure.
- Isoler la pince de masse quand pas mis à la pièce pour éviter le contact avec tout objet métallique.
- Ne pas raccorder plus d'une électrode ou plus d'un câble de masse à une même borne de sortie de soudage. Débrancher le câble pour le procédé non utilisé.
- Utiliser une protection différentielle lors de l'utilisation d'un équipement auxiliaire dans des endroits humides ou mouillés.



LES PIÈCES CHAUDES peuvent provoquer des brûlures.

- Ne pas toucher des parties chaudes à mains nues.
- Prévoir une période de refroidissement avant de travailler à l'équipement.
- Ne pas toucher aux pièces chaudes, utiliser les outils recommandés et porter des gants de soudage et des vêtements épais pour éviter les brûlures.



DES PIÈCES DE METAL ou DES SALETES peuvent provoquer des blessures dans les yeux.

- Le soudage, l'écaillage, le passage de la pièce à la brosse en fil de fer, et le meulage génèrent des étincelles et des particules métalliques volantes. Pendant la période de refroidissement des soudures, elles risquent de projeter du laitier.
- Porter des lunettes de sécurité avec écrans latéraux ou un écran facial.



LES FUMÉES ET LES GAZ peuvent être dangereux.

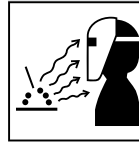
Le soudage génère des fumées et des gaz. Leur inhalation peut être dangereux pour votre santé.

- Eloigner votre tête des fumées. Ne pas respirer les fumées.
- À l'intérieur, ventiler la zone et/ou utiliser une ventilation forcée au niveau de l'arc pour l'évacuation des fumées et des gaz de soudage. Pour déterminer la bonne ventilation, il est recommandé de procéder à un prélèvement pour la composition et la quantité de fumées et de gaz auxquelles est exposé le personnel.
- Si la ventilation est médiocre, porter un respirateur anti-vapeurs approuvé.
- Lire et comprendre les fiches de données de sécurité et les instructions du fabricant concernant les adhésifs, les revêtements, les nettoyants, les consommables, les produits de refroidissement, les dégraissants, les flux et les métaux.
- Travailler dans un espace fermé seulement s'il est bien ventilé ou en portant un respirateur à alimentation d'air. Demander toujours à un surveillant dûment formé de se tenir à proximité. Des fumées et des gaz de soudage peuvent déplacer l'air et abaisser le niveau d'oxygène provoquant des blessures ou des accidents mortels. S'assurer que l'air de respiration ne présente aucun danger.
- Ne pas souder dans des endroits situés à proximité d'opérations de dégraissage, de nettoyage ou de pulvérisation. La chaleur et les rayons de l'arc peuvent réagir en présence de vapeurs et former des gaz hautement toxiques et irritants.
- Ne pas souder des métaux munis d'un revêtement, tels que l'acier galvanisé, plaqué en plomb ou au cadmium à moins que le revêtement n'ait été enlevé dans la zone de soudure, que l'endroit soit bien ventilé, et en portant un respirateur à alimentation d'air. Les revêtements et tous les métaux renfermant ces éléments peuvent dégager des fumées toxiques en cas de soudage.



LES ACCUMULATIONS DE GAZ risquent de provoquer des blessures ou même la mort.

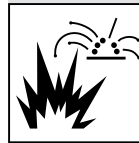
- Fermer l'alimentation du gaz comprimé en cas de non utilisation.
- Veiller toujours à bien aérer les espaces confinés ou se servir d'un respirateur d'adduction d'air homologué.



LES RAYONS DE L'ARC peuvent provoquer des brûlures dans les yeux et sur la peau.

Le rayonnement de l'arc du procédé de soudage génère des rayons visibles et invisibles intenses (ultraviolets et infrarouges) susceptibles de provoquer des brûlures dans les yeux et sur la peau. Des étincelles sont projetées pendant le soudage.

- Porter un casque de soudage approuvé muni de verres filtrants appropriés pour protéger visage et yeux pendant le soudage (voir ANSI Z49.1 et Z87.1 énumérés dans les normes de sécurité).
- Porter des lunettes de sécurité avec écrans latéraux même sous votre casque.
- Avoir recours à des écrans protecteurs ou à des rideaux pour protéger les autres contre les rayonnements les éblouissements et les étincelles ; prévenir toute personne sur les lieux de ne pas regarder l'arc.
- Porter une protection corporelle en cuir ou des vêtements ignifuges (FRC). La protection du corps comporte des vêtements sans huile, comme des gants de cuir, une chemise solide, des pantalons sans revers, des chaussures hautes et une casquette.



LE SOUDAGE peut provoquer un incendie ou une explosion.

Le soudage effectué sur des conteneurs fermés tels que des réservoirs, tambours ou des conduites peut provoquer leur éclatement. Des étincelles peuvent être projetées de l'arc de soudure. La projection d'étincelles, des pièces chaudes et des équipements chauds peut provoquer des incendies et des brûlures. Le contact accidentel de l'électrode avec des objets métalliques peut provoquer des étincelles, une explosion, un surchauffement ou un incendie. Avant de commencer le soudage, vérifier et s'assurer que l'endroit ne présente pas de danger.

- Déplacer toutes les substances inflammables à une distance de 10,7 m de l'arc de soudage. En cas d'impossibilité les recouvrir soigneusement avec des protections homologuées.
- Ne pas souder dans un endroit où des étincelles peuvent tomber sur des substances inflammables.
- Se protéger et d'autres personnes de la projection d'étincelles et de métal chaud.
- Des étincelles et des matériaux chauds du soudage peuvent facilement passer dans d'autres zones en traversant de petites fissures et des ouvertures.
- Surveiller tout déclenchement d'incendie et tenir un extincteur à proximité.
- Le soudage effectué sur un plafond, plancher, paroi ou séparation peut déclencher un incendie de l'autre côté.
- Ne pas couper ou souder des jantes ou des roues. Les pneus peuvent exploser s'ils sont chauffés. Les jantes et les roues réparées peuvent défailir. Voir OSHA 29 CFR 1910.177 énuméré dans les normes de sécurité.
- Ne pas effectuer le soudage sur des conteneurs fermés tels que des réservoirs, tambours, ou conduites, à moins qu'ils n'aient été préparés correctement conformément à AWS F4.1 (voir les Normes de Sécurité).
- Ne pas souder là où l'air ambiant pourrait contenir des poussières, gaz ou émanations inflammables (vapeur d'essence, par exemple).

- Brancher le câble de masse sur la pièce le plus près possible de la zone de soudage pour éviter le transport du courant sur une longue distance par des chemins inconnus éventuels en provoquant des risques d'électrocution, d'étincelles et d'incendie.
- Ne pas utiliser le poste de soudage pour dégeler des conduites gelées.
- En cas de non utilisation, enlever la baguette d'électrode du porte-électrode ou couper le fil à la pointe de contact.
- Porter une protection corporelle en cuir ou des vêtements ignifuges (FRC). La protection du corps comporte des vêtements sans huile, comme des gants de cuir, une chemise solide, des pantalons sans revers, des chaussures hautes et une casquette.
- Avant de souder, retirer toute substance combustible de vos poches telles qu'un allumeur au butane ou des allumettes.
- Une fois le travail achevé, assurez-vous qu'il ne reste aucune trace d'étincelles incandescentes ni de flammes.
- Utiliser exclusivement des fusibles ou coupe-circuits appropriés. Ne pas augmenter leur puissance; ne pas les ponter.
- Suivre les recommandations dans OSHA 1910.252 (a) (2) (iv) et NFPA 51B pour les travaux à chaud et avoir de la surveillance et un extincteur à proximité.
- Lire et comprendre les fiches de données de sécurité et les instructions du fabricant concernant les adhésifs, les revêtements, les nettoyeurs, les consommables, les produits de refroidissement, les dégraisseurs, les flux et les métaux.



Le BRUIT peut endommager l'ouïe.

Le bruit des processus et des équipements peut affecter l'ouïe.

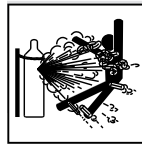
- Porter des protections approuvées pour les oreilles si le niveau sonore est trop élevé.



Les CHAMPS ÉLECTROMAGNÉTIQUES (CEM) peuvent affecter les implants médicaux.

- Les porteurs de stimulateurs cardiaques et autres implants médicaux doivent rester à distance.

- Les porteurs d'implants médicaux doivent consulter leur médecin et le fabricant du dispositif avant de s'approcher de la zone où se déroule le soudage à l'arc, du soudage par points, du gougeage, de la découpe plasma ou une opération de chauffage par induction.



Si des BOUTEILLES sont endommagées, elles pourront exploser.

Des bouteilles de gaz comprimé protecteur contiennent du gaz sous haute pression. Si une bouteille est endommagée, elle peut exploser. Du fait que les bouteilles de gaz font normalement partie du procédé de soudage, les manipuler avec précaution.

- Protéger les bouteilles de gaz comprimé d'une chaleur excessive, des chocs mécaniques, des dommages physiques, du laitier, des flammes ouvertes, des étincelles et des arcs.
- Placer les bouteilles debout en les fixant dans un support stationnaire ou dans un porte-bouteilles pour les empêcher de tomber ou de se renverser.
- Tenir les bouteilles éloignées des circuits de soudage ou autres circuits électriques.
- Ne jamais placer une torche de soudage sur une bouteille à gaz.
- Une électrode de soudage ne doit jamais entrer en contact avec une bouteille.
- Ne jamais souder une bouteille pressurisée - risque d'explosion.
- Utiliser seulement des bouteilles de gaz comprimé, régulateurs, tuyaux et raccords convenables pour cette application spécifique; les maintenir ainsi que les éléments associés en bon état.
- Tourner le dos à la sortie de vanne lors de l'ouverture de la vanne de la bouteille. Ne pas se tenir devant ou derrière le régulateur lors de l'ouverture de la vanne.
- Maintenir le chapeau de protection sur la soupape, sauf en cas d'utilisation ou de branchement de la bouteille.
- Utilisez les équipements corrects, les bonnes procédures et suffisamment de personnes pour soulever, déplacer et transporter les bouteilles.
- Lire et suivre les instructions sur les bouteilles de gaz comprimé, l'équipement connexe et le dépliant P-1 de la CGA (Compressed Gas Association) mentionné dans les principales normes de sécurité.

2-3. Symboles de dangers supplémentaires en relation avec l'installation, le fonctionnement et la maintenance



Risque D'INCENDIE OU D'EXPLOSION.

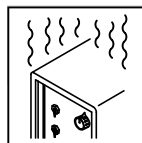
- Ne pas placer l'appareil sur, au-dessus ou à proximité de surfaces inflammables.
- Ne pas installer l'appareil à proximité de produits inflammables
- Ne pas surcharger l'installation électrique – s'assurer que l'alimentation est correctement dimensionnée et protégée avant de mettre l'appareil en service.



LA CHUTE DE L'ÉQUIPEMENT peut provoquer des blessures.

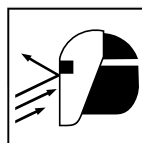
- Utiliser l'anneau de levage uniquement pour soulever l'appareil, NON PAS les organes de roulement, les bouteilles de gaz ou tout autre accessoire.
- Utilisez les procédures correctes et des équipements d'une capacité appropriée pour soulever et supporter l'appareil.
- En utilisant des fourches de levage pour déplacer l'unité, s'assurer que les fourches sont suffisamment longues pour dépasser du côté opposé de l'appareil.

- Tenir l'équipement (câbles et cordons) à distance des véhicules mobiles lors de toute opération en hauteur.
- Suivre les consignes du Manuel des applications pour l'équation de levage NIOSH révisée (Publication N°94-110) lors du levage manuel de pièces ou équipements lourds.



L'EMPLOI EXCESSIF peut SURCHAUFFER L'ÉQUIPEMENT.

- Laisser l'équipement refroidir ; respecter le facteur de marche nominal.
- Réduire le courant ou le cycle opératoire avant de recommencer le soudage.
- Ne pas obstruer les passages d'air du poste.



LES ÉTINCELLES PROJÉTÉES peuvent provoquer des blessures.

- Porter un écran facial pour protéger le visage et les yeux.

- Affûter l'électrode au tungstène uniquement à la meuleuse dotée de protecteurs. Cette manœuvre est à exécuter dans un endroit sûr lorsque l'on porte l'équipement homologué de protection du visage, des mains et du corps.
- Les étincelles risquent de causer un incendie - éloigner toute substance inflammable.



LES CHARGES ÉLECTROSTATIQUES peuvent endommager les circuits imprimés.

- Établir la connexion avec la barrette de terre AVANT de manipuler des cartes ou des pièces.
- Utiliser des pochettes et des boîtes antistatiques pour stocker, déplacer ou expédier des cartes de circuits imprimés.



Les PIÈCES MOBILES peuvent causer des blessures.

- Ne pas s'approcher des organes mobiles.
- Ne pas s'approcher des points de coincement tels que des rouleaux de commande.



LES FILS DE SOUDAGE peuvent provoquer des blessures.

- Ne pas appuyer sur la gachette avant d'en avoir reçu l'instruction.
- Ne pas diriger le pistolet vers soi, d'autres personnes ou toute pièce mécanique en engageant le fil de soudage.



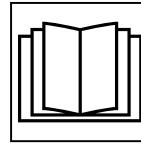
L'EXPLOSION DE LA BATTERIE peut provoquer des blessures.

- Ne pas utiliser l'appareil de soudage pour charger des batteries ou faire démarrer des véhicules à l'aide de câbles de démarrage, sauf si l'appareil dispose d'une fonctionnalité de charge de batterie destinée à cet usage.



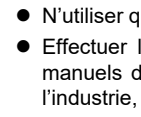
Les PIÈCES MOBILES peuvent causer des blessures.

- S'abstenir de toucher des organes mobiles tels que des ventilateurs.
- Maintenir fermés et verrouillés les portes, panneaux, recouvrements et dispositifs de protection.
- Lorsque cela est nécessaire pour des travaux d'entretien et de dépannage, faire retirer les portes, panneaux, recouvrements ou dispositifs de protection uniquement par du personnel qualifié.
- Remettre les portes, panneaux, recouvrements ou dispositifs de protection quand l'entretien est terminé et avant de rebrancher l'alimentation électrique.

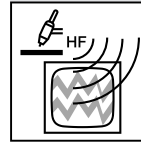


LIRE LES INSTRUCTIONS.

- Lire et appliquer les instructions sur les étiquettes et le Mode d'emploi avant l'installation, l'utilisation ou l'entretien de l'appareil. Lire les informations de sécurité au début du manuel et dans chaque section.

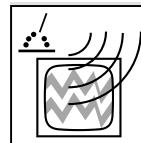


- N'utiliser que des pièces de remplacement provenant du fabricant.
- Effectuer l'installation, l'entretien et toute intervention selon les manuels d'utilisateurs, les normes nationales, provinciales et de l'industrie, ainsi que les codes municipaux.



LE RAYONNEMENT HAUTE FRÉQUENCE (H.F.) risque de provoquer des interférences.

- Le rayonnement haute fréquence (H.F.) peut provoquer des interférences avec les équipements de radio-navigation et de communication, les services de sécurité et les ordinateurs.
- Demander seulement à des personnes qualifiées familiarisées avec des équipements électroniques de faire fonctionner l'installation.
- L'utilisateur est tenu de faire corriger rapidement par un électricien qualifié les interférences résultant de l'installation.
- Si le FCC signale des interférences, arrêter immédiatement l'appareil.
- Effectuer régulièrement le contrôle et l'entretien de l'installation.
- Maintenir soigneusement fermés les portes et les panneaux des sources de haute fréquence, maintenir les éclateurs à une distance correcte et utiliser une terre et un blindage pour réduire les interférences éventuelles.



LE SOUDAGE À L'ARC risque de provoquer des interférences.

- L'énergie électromagnétique risque de provoquer des interférences pour l'équipement électronique sensible tel que les ordinateurs et l'équipement commandé par ordinateur tel que les robots.
- Veiller à ce que tout l'équipement de la zone de soudage soit compatible électromagnétiquement.
- Pour réduire la possibilité d'interférence, maintenir les câbles de soudage aussi courts que possible, les grouper, et les poser aussi bas que possible (ex. par terre).
- Veiller à souder à une distance de 100 mètres de tout équipement électronique sensible.
- Veiller à ce que ce poste de soudage soit posé et mis à la terre conformément à ce mode d'emploi.
- En cas d'interférences après avoir pris les mesures précédentes, il incombe à l'utilisateur de prendre des mesures supplémentaires telles que le déplacement du poste, l'utilisation de câbles blindés, l'utilisation de filtres de ligne ou la pose de protecteurs dans la zone de travail.

2-4. Proposition californienne 65 Avertissements

⚠ AVERTISSEMENT – Ce produit peut vous exposer à des produits chimiques tels que le plomb, reconnus par l'État de Californie comme cancérigènes et sources de malformations ou d'autres troubles de la reproduction.

Pour plus d'informations, consulter www.P65Warnings.ca.gov.

2-5. Principales normes de sécurité

Safety in Welding, Cutting, and Allied Processes, American Welding Society standard ANSI Standard Z49.1. Website: www.aws.org.

Safe Practice For Occupational And Educational Eye And Face Protection, ANSI Standard Z87.1, from American National Standards Institute. Website: safetyequipment.org.

Safe Practices for the Preparation of Containers and Piping for Welding and Cutting, American Welding Society Standard AWS F4.1. Website: www.aws.org.

National Electrical Code, NFPA Standard 70 from National Fire Protection Association. Website: www.nfpa.org.

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1 from Compressed Gas Association. Website: www.cganet.com.

Safety in Welding, Cutting, and Allied Processes, CSA Standard W117.2 from Canadian Standards Association. Website: www.csa-group.org.

Standard for Fire Prevention During Welding, Cutting, and Other Hot Work, NFPA Standard 51B from National Fire Protection Association. Website: www.nfpa.org.

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910.177

Subpart N, Part 1910 Subpart Q, and Part 1926, Subpart J. Website: www.osha.gov.

OSHA Important Note Regarding the ACGIH TLV, Policy Statement on the Uses of TLVs and BEIs. Website: www.osha.gov.

Applications Manual for the Revised NIOSH Lifting Equation from the National Institute for Occupational Safety and Health (NIOSH). Website: www.cdc.gov/NIOSH.

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2-6. Informations relatives aux CEM

Le courant électrique qui traverse tout conducteur génère des champs électromagnétiques (CEM) à certains endroits. Le courant issu d'un soudage à l'arc (et de procédés connexes, y compris le soudage par points, le gougeage, le découpage plasma et les opérations de chauffage par induction) crée un champ électromagnétique (CEM) autour du circuit de soudage. Les champs électromagnétiques produits peuvent causer interférence à certains implants médicaux, p. ex. les stimulateurs cardiaques. Des mesures de protection pour les porteurs d'implants médicaux doivent être prises: par exemple, des restrictions d'accès pour les passants ou une évaluation individuelle des risques pour les soudeurs. Tous les soudeurs doivent appliquer les procédures suivantes pour minimiser l'exposition aux CEM provenant du circuit de soudage:

1. Rassembler les câbles en les torsadant ou en les attachant avec du ruban adhésif ou avec une housse.
2. Ne pas se tenir au milieu des câbles de soudage. Disposer les câbles d'un côté et à distance de l'opérateur.





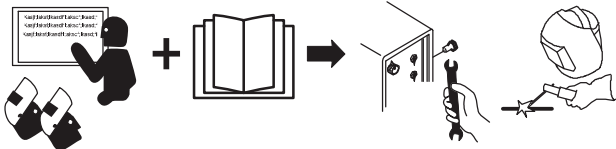
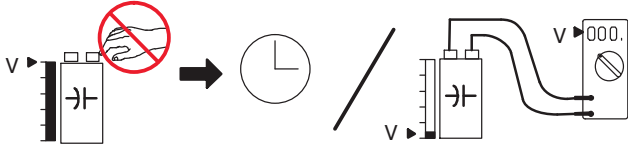
3. Ne pas courber et ne pas entourer les câbles autour de votre corps.
4. Maintenir la tête et le torse aussi loin que possible du matériel du circuit de soudage.
5. Connecter la pince sur la pièce aussi près que possible de la soudure.
6. Ne pas travailler à proximité d'une source de soudage, ni s'asseoir ou se pencher dessus.
7. Ne pas souder tout en portant la source de soudage ou le dévidoir.

En ce qui concerne les implants médicaux :



Les porteurs d'implants doivent d'abord consulter leur médecin avant de s'approcher des opérations de soudage à l'arc, de soudage par points, de gougeage, du coupage plasma ou de chauffage par induction. Si le médecin approuve, il est recommandé de suivre les procédures précédentes.





SECTION 3 – DEFINITIONS







3-1. Additional Safety Symbol Definitions

	<p>Warning! Watch Out! There are possible hazards as shown by the symbols.</p>
	<p>Drive rolls can injure fingers. Welding wire and drive parts are at welding voltage during operation - keep hands and metal objects away.</p>
	<p>Beware of electric shock from wiring.</p>
	<p>When power is applied failed parts can explode or cause other parts to explode.</p>
	<p>Become trained and read the instructions before working on the machine or welding.</p>
	<p>Hazardous voltage remains on input capacitors after power is turned off. Do not touch fully charged capacitors. Always wait 5 minutes after power is turned off before working on unit, AND check input capacitor voltage, and be sure it is near 0 before touching any parts.</p>

3-2. Miscellaneous Symbols And Definitions

U₀	Rated No Load Voltage (OCV)
≡	Direct Current (DC)
U₁	Primary Voltage
U₂	Conventional Load Voltage
I₂	Rated Welding Current
	Input Power or Input Voltage
	Gas Input
IP	Internal Protection Rating

1 	Single Phase
	Circuit Breaker
+	Positive
-	Negative
X	Duty Cycle
	Line Connection
	Increase
Hz	Hertz

	Single Phase Static Frequency Converter-Transformer-Rectifier
A	Amperage
V	Voltage
	Gas Metal Arc Welding (GMAW)
	Gas Metal Arc Welding (GMAW) MIG / Gun Control
	Self-Shielded Flux Cored Arc Welding (FCAW)
	Wire Feed Spool Gun
	Gas Postflow

SECTION 4 – SPECIFICATIONS

4-1. Serial Number And Rating Label Location

The serial number and rating information for this product is located on the back of unit. Use rating label to determine input power requirements and/or rated output. For future reference, write serial number in space provided on back cover of this manual.

4-2. Software Licensing Agreement

The End User License Agreement and any third-party notices and terms and conditions pertaining to third-party software can be found at <https://www.hobartwelders.com/eula> and are incorporated by reference herein.

4-3. Information About Default Weld Parameters And Settings

NOTICE – Each welding application is unique. Although certain Miller Electric products are designed to determine and default to certain typical welding parameters and settings based upon specific and relatively limited application variables input by the end user, such default settings are for reference purposes only; and final weld results can be affected by other variables and application-specific circumstances. The appropriateness of all parameters and settings should be evaluated and modified by the end user as necessary based upon application-specific requirements. The end user is solely responsible for selection and coordination of appropriate equipment, adoption or adjustment of default weld parameters and settings, and ultimate quality and durability of all resultant welds. Miller Electric expressly disclaims any and all implied warranties including any implied warranty of fitness for a particular purpose.

4-4. Welding Power Source Specifications

Rated Welding Output	Amperage Range	Maximum Open-Circuit Voltage DC	Amperes Input At Rated Load Output, 60 Hz, Single Phase			
			208 VAC	240 VAC	KVA	KW
280 A, 28.2 volts DC, 30% Duty Cycle	30-280 A	40	62.4	55.3	13.13	11.26
250 A, 26.5 volts DC, 40% Duty Cycle	30-280 A	40	61.4	54.2	12.6	9.4
200 A, 24.0 volts DC, 60% Duty Cycle	30-280 A	40	53.9	47.5	11.4	7.1
150 A, 21.5 volts DC, 100% Duty Cycle	30-280 A	40	44.9	38.4	9.22	4.98

Wire Type and Diameter				Wire Feed Speed	Dimensions	Net Weight Without Gun
Solid Steel	Stainless Steel	Flux Cored	Aluminum*			
.023 - .045 in. (0.6 - 1.2 mm)	.023 - .045 in. (0.6 - 1.2 mm)	.030 - .045 in. (0.8 - 1.2 mm)	.030 - .047 in. (0.8 - 1.2 mm)	50-700 IPM (1.3-17.8 m/min)	H: 30 in. (762 mm) W: 19 in. (483 mm) D: 40 in. (1016 mm)	205 lb (93 kg)

*Spoolrunner 200 required for welding aluminum

4-5. Environmental Specifications

A. IP Rating

IP Rating
IP21
This equipment is designed for indoor use and is not intended to be used or stored outside.

B. Temperature Specifications

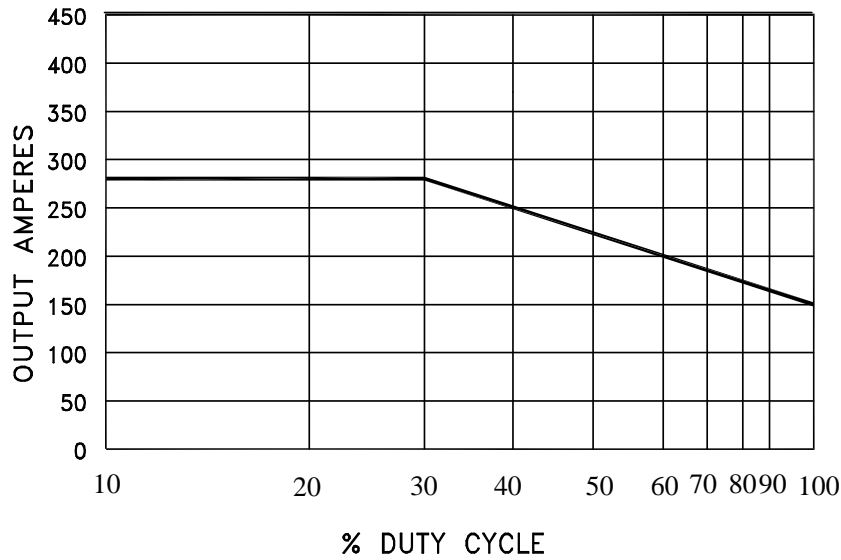
Operating Temperature Range*	Storage/Transportation Temperature Range
-4 to 104°F (-20 to 40°C)	-22 to 122°F (-30 to 50°C)

*Output is derated at temperatures above 104°F (40°C).

4-6. Duty Cycle And Overheating



MIG OUTPUT DUTY CYCLE

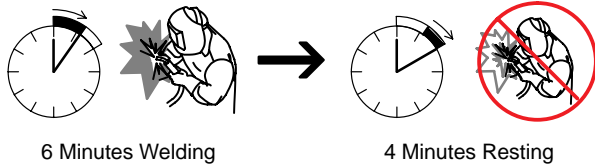


Duty Cycle is percentage of 10 minutes that unit can weld at rated load without overheating.

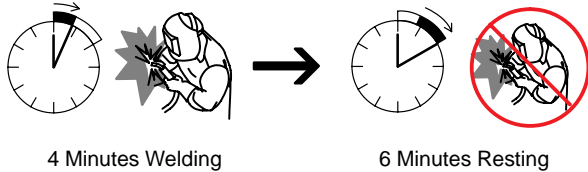
If unit overheats, Thermistor (RT1) opens, output stops, and cooling fan runs. Wait fifteen minutes for unit to cool. Reduce amperage or voltage, or duty cycle before welding.

NOTICE – Exceeding duty cycle can damage unit and void warranty.

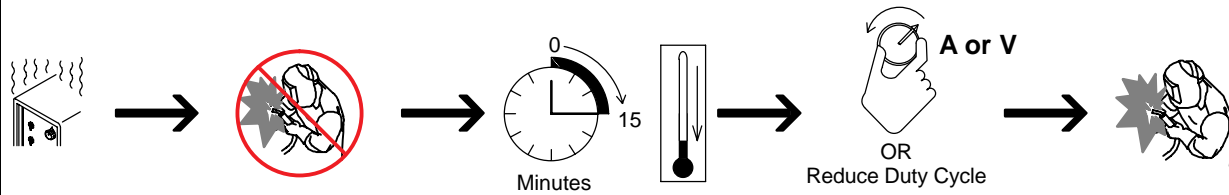
60% Duty Cycle at 200 Amperes



40% Duty Cycle at 250 Amperes



Overheating

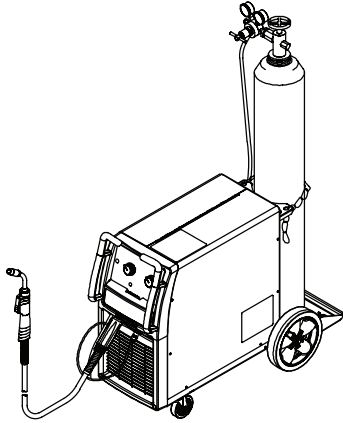



SECTION 5 – INSTALLATION

5-1. Selecting A Location



Movement



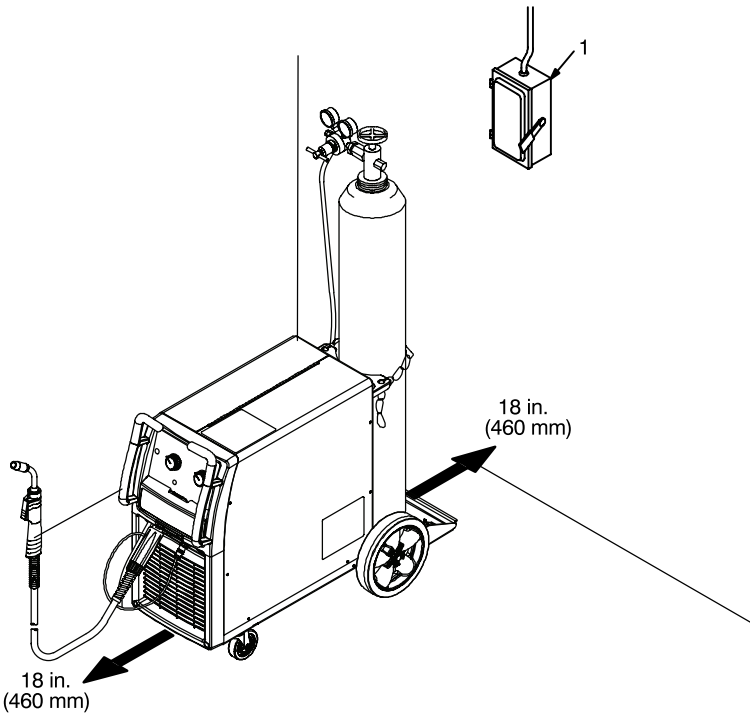
 Do not move or operate unit where it could tip.

 Special installation may be required where gasoline or volatile liquids are present - see NEC Article 511 or CEC Section 20.

1 Line Disconnect Device

Locate unit near correct input power supply.

Location And Airflow



5-2. Selecting Cable Sizes*

NOTICE – The Total Cable Length in Weld Circuit (see table below) is the combined length of both weld cables. For example, if the power source is 100 ft (30 m) from the workpiece, the total cable length in the weld circuit is 200 ft (2 cables x 100 ft). Use the 200 ft (60 m) column to determine cable size.

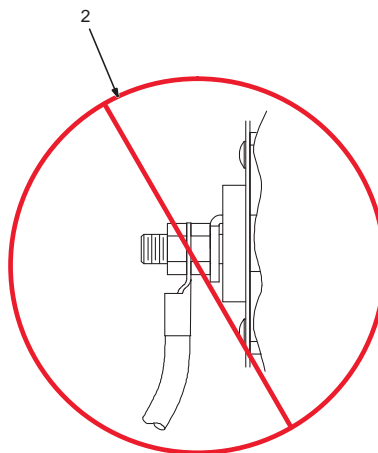
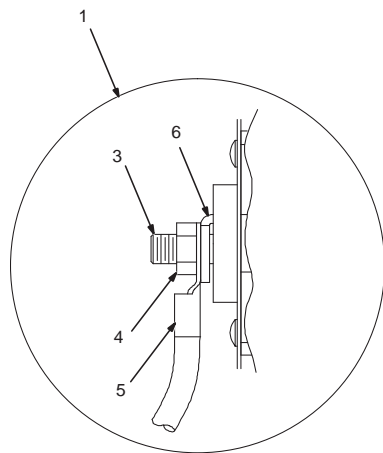
	Weld Cable Size** and Total Cable (Copper) Length in Weld Circuit Not Exceeding***							
	100 ft (30 m) or Less		150 ft (45 m)	200 ft (60 m)	250 ft (70 m)	300 ft (90 m)	350 ft (105 m)	400 ft (120 m)
Welding Amperes	10 - 60% Duty Cycle AWG (mm ²)	60 - 100% Duty Cycle AWG (mm ²)	10 - 100% Duty Cycle AWG (mm ²)					
100	4 (20)	4 (20)	4 (20)	3 (30)	2 (35)	1 (50)	1/0 (60)	1/0 (60)
150	3 (30)	3 (30)	2 (35)	1 (50)	1/0 (60)	2/0 (70)	3/0 (95)	3/0 (95)
200	3 (30)	2 (35)	1 (50)	1/0 (60)	2/0 (70)	3/0 (95)	4/0 (120)	4/0 (120)
250	2 (35)	1 (50)	1/0 (60)	2/0 (70)	3/0 (95)	4/0 (120)	2x2/0 (2x70)	2x2/0 (2x70)
300	1 (50)	1/0 (60)	2/0 (70)	3/0 (95)	4/0 (120)	2x2/0 (2x70)	2x3/0 (2x95)	2x3/0 (2x95)
350	1/0 (60)	2/0 (70)	3/0 (95)	4/0 (120)	2x2/0 (2x70)	2x3/0 (2x95)	2x3/0 (2x95)	2x4/0 (2x120)

* This chart is a general guideline and may not suit all applications. If cable overheats, use next size larger cable.

**Weld cable size (AWG) is based on either a 4 volts or less drop or a current density of at least 300 circular mils per ampere. () = mm² for metric use.

***For distances longer than those shown in this guide, see AWS Fact Sheet No. 39, Welding Cables, available from the American Welding Society at <http://www.aws.org>.

5-3. Connecting Weld Output Cables

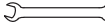


⚠ Turn off power before connecting to weld output terminals.

⚠ Failure to properly connect weld cables may cause excessive heat and start a fire, or damage your machine.

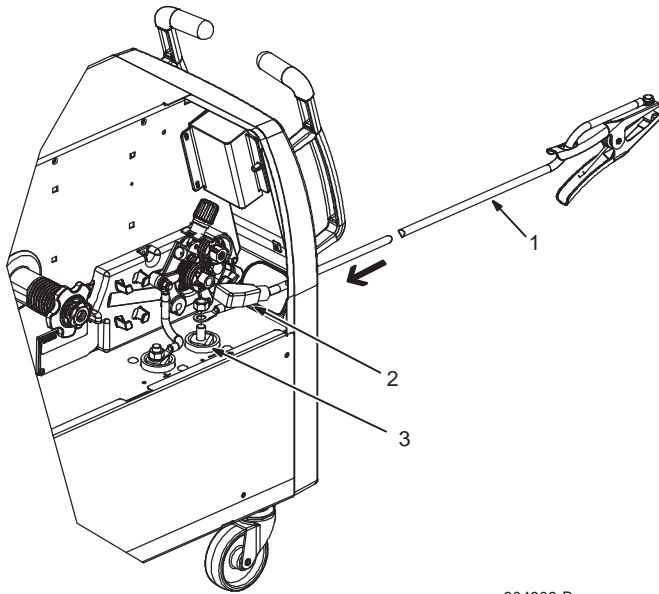
👉 Do not place anything between weld cable terminal and copper bar. Make sure that the surfaces of the weld cable terminal and copper bar are clean.

- 1 Correct Weld Cable Connection
- 2 Incorrect Weld Cable Connection
- 3 Weld Output Terminal
- 4 Supplied Weld Output Terminal Nut
- 5 Weld Cable Terminal
- 6 Copper Bar


 3/4 in. (19 mm)

Remove supplied nut from weld output terminal. Slide weld cable terminal onto weld output terminal and secure with nut so that weld cable terminal is tight against copper bar.

5-4. Installing Work Cable And Clamp



804909-B

 Turn off power before connecting to weld output terminals.

 Do not use worn, damaged, undersized, or repaired cables.

1 Work Cable


2 Boot

Route cable through front panel opening. Slide boot onto work cable.

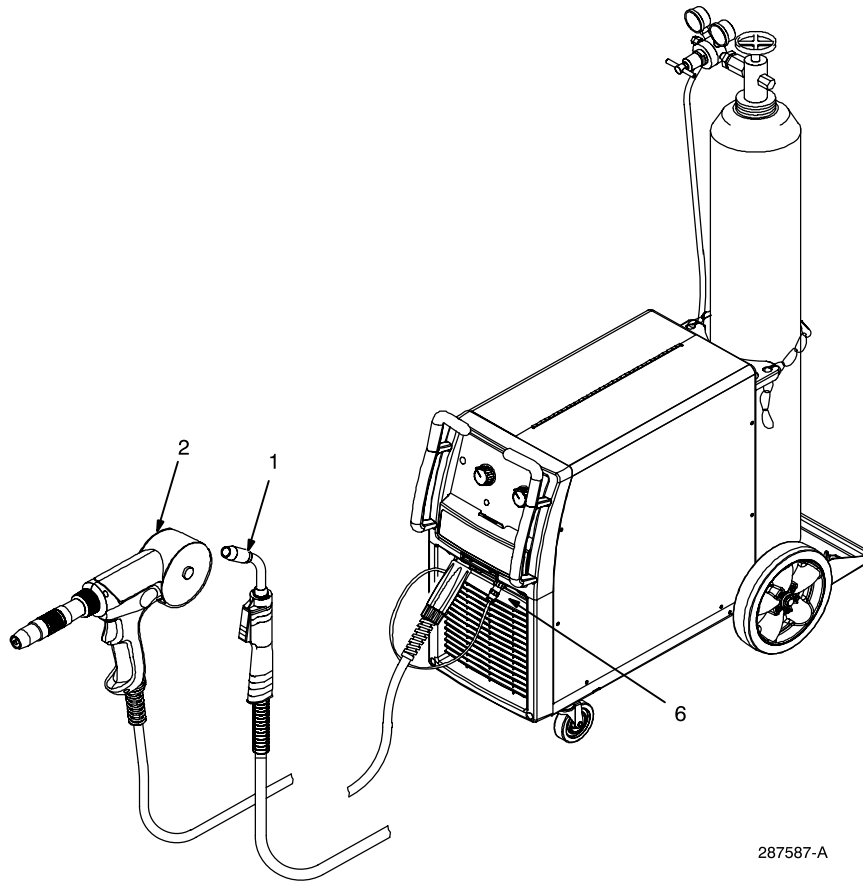
3 Negative (-) Output Terminal

Connect cable to terminal and cover connection with boot.

Close door.

 3/4 in.

5-5. Connecting MIG Gun/Spool Gun to IronMan 240



- 1 MIG Gun
- 2 Spool Gun
- 3 Drive Assembly
- 4 Gun End
- 5 Gun Securing Knob

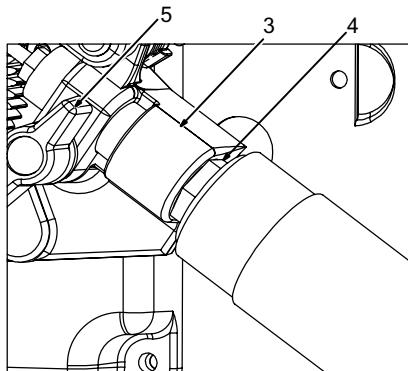
Loosen gun securing knob. Insert gun end through opening until it bottoms against the drive assembly. Tighten the gun securing knob.

- 6 Gun Trigger Plug

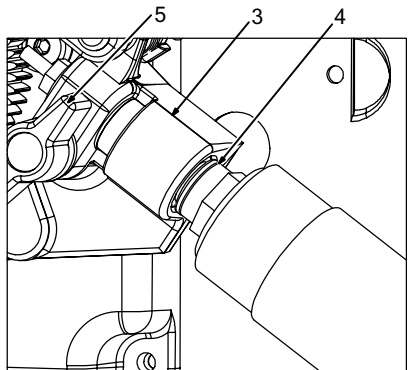
Insert plug into receptacle, and tighten threaded collar.

287587-A

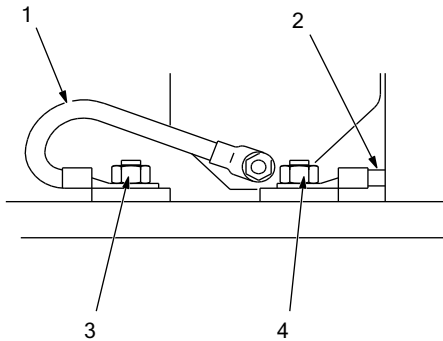
Correct



Incorrect



5-6. Setting Gun Polarity For Wire Type



3/4 in.

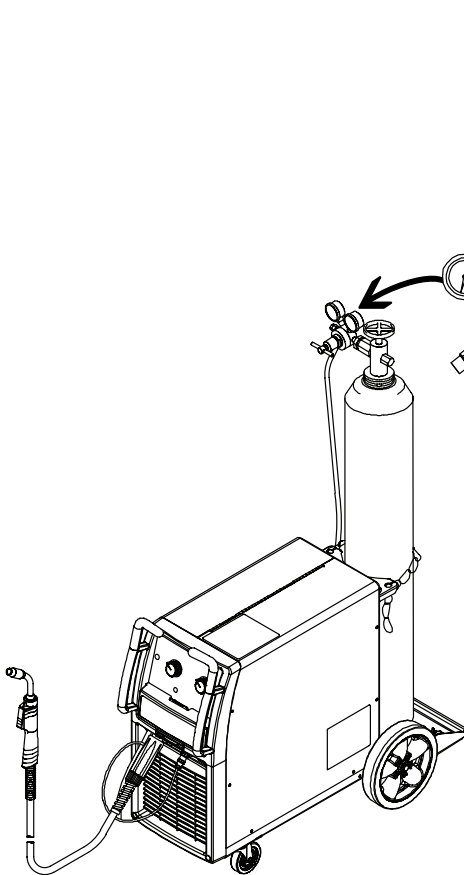
- 1 Wire Drive Assembly Lead
- 2 Work Clamp Lead
- 3 + Positive Terminal
- 4 - Negative Terminal

Shown as shipped — **Electrode Positive (DCEP)**: For solid steel, stainless steel, aluminum, or flux core with gas wires (GMAW).

Electrode Negative (DCEN): Reverse lead connections at terminals from that shown for gasless flux core wires (FCAW). Drive assembly becomes negative.

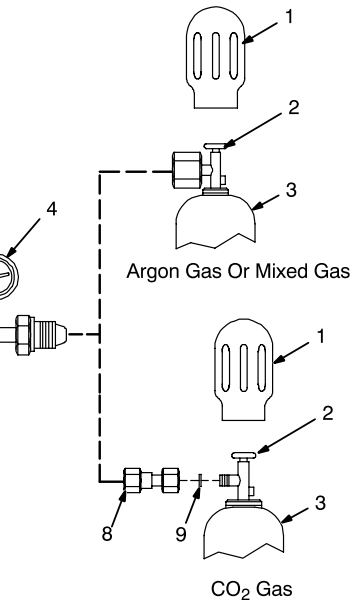
Always read and follow manufacturer's recommended polarity.

5-7. Installing Gas Supply



Ref. 804654-A / Ref. 804912-A

5/8, 1-1/8 in.



Obtain gas cylinder and chain to running gear, wall, or other stationary support so cylinder cannot fall and break off valve.

- 1 Cap
- 2 Cylinder Valve

Remove cap, stand to side of valve, and open valve slightly. Gas flow blows dust and dirt from valve. Close valve.

- 3 Cylinder
- 4 Regulator/Flowmeter

Install so face is vertical.

- 5 Regulator/Flowmeter Gas Hose Connection
- 6 Welding Power Source Gas Hose Connection

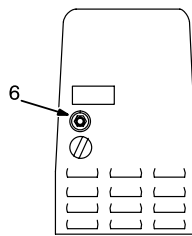
Connect customer supplied gas hose between regulator/flowmeter gas hose connection, and fitting on rear of welding power source.

- 7 Flow Adjust

Typical flow rate is 25-45 cfh (cubic feet per hour). Check wire manufacturer's recommended flow rate.

- 8 CO2 Adapter (Customer Supplied)
- 9 O-Ring (Customer Supplied)

Install adapter with O-ring between regulator/flowmeter and CO₂ cylinder.



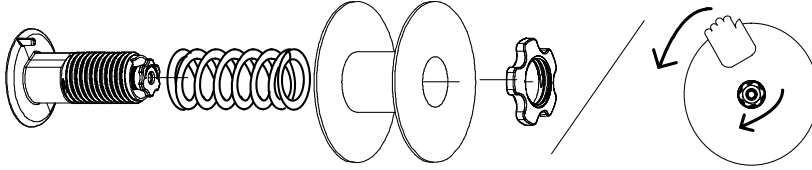
Rear Panel

5-8. Installing Wire Spool And Adjusting Hub Tension

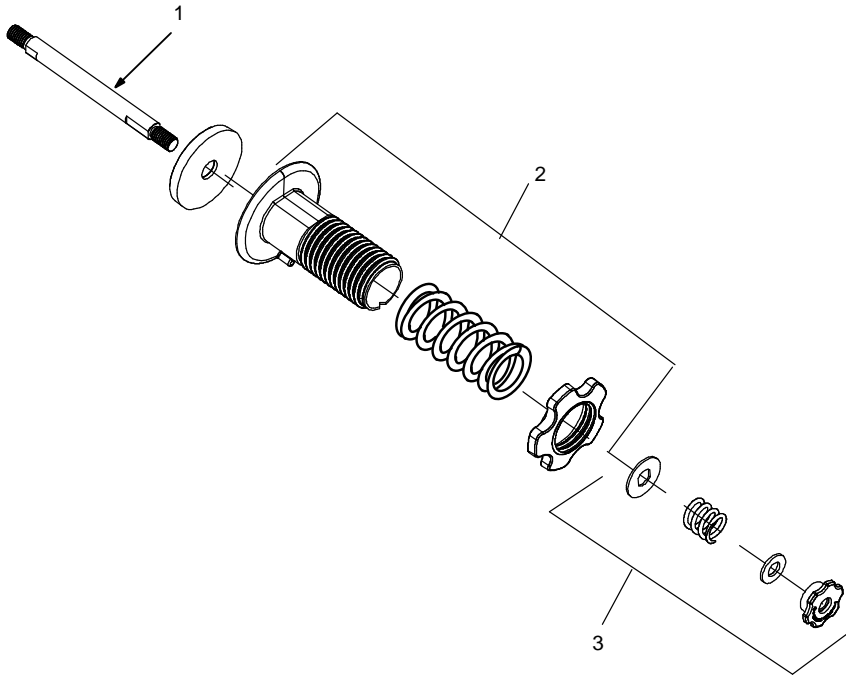


Installing 8 in. (203 mm) Wire Spool

Hand tighten knob clockwise. When a slight force is needed to turn spool, tension is set



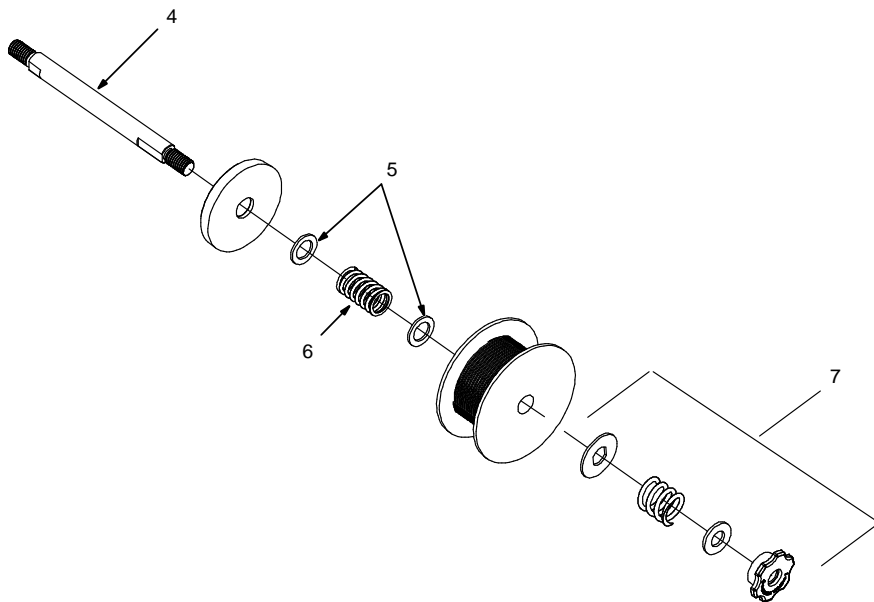
Removing 8 in. (203 mm) Spool Hub And Spool Nut



- 1 Spindle
- 2 Spool Hub, Spring, And Nut — For 8 in. (203 mm) Spool Only
- 3 Spindle Hardware

Remove spindle hardware and retain. Remove spool hub, spring, and spool nut and retain for future use.

Installing 4 in. (102 mm) Wire Spool



- 4 Spindle
- 5 Washer, Flat
Order two additional flat washers (Part No. 605941).
- 6 Spring, Compression
Order one additional spring (Part No. 186437).

7 Spindle Hardware
Install Spindle hardware on spindle in exact order as shown and tighten slightly.

5-9. Positioning Jumper Links

284705- A

284705-A / 804911-A

Philips Screwdriver #1

3/8 in.

Check input voltage available at site.

- Jumper Links Access Door

Open door.

- Jumper Link Label

Check label - only one is on unit.

- Input Voltage Jumper Links

Move jumper links to match input voltage.

Close and secure access door.

5-10. Electrical Service Guide

⚠ Failure to follow these electrical service guide recommendations could create an electric shock or fire hazard. These recommendations are for an individual branch circuit sized for the rated output and duty cycle of one welding power source. In individual branch circuit installations, the National Electrical Code (NEC) allows the receptacle or conductor rating to be less than the rating of the circuit protection device. All components of the circuit must be physically compatible. See NEC articles 210.21, 630.11, and 630.12.

	60 Hz 1-Phase	
Rated Supply Voltage (V)	208	240
Rated Maximum Supply Current I_{1max} (A)	62.4	55.3
Rated Effective Supply Current I_{1eff} (A)	44.9	38.4
Maximum Recommended Standard Fuse Rating In Amperes¹		
Time Delay Fuses²	70	60
Normal Operating Fuses³	90	80
Maximum Recommended Supply Conductor Length In Feet (Meters)⁴	79 (24)	105 (32)
Raceway Installation		
Minimum Supply Conductor Size In AWG (mm²)⁵	8 (10)	8 (10)
Minimum Grounding Conductor Size In AWG (mm²)⁵	8 (10)	8 (10)

Reference: 2023 National Electrical Code (NEC) (including article 630)

1 If a circuit breaker is used in place of a fuse, choose a circuit breaker with time-current curves comparable to the recommended fuse.

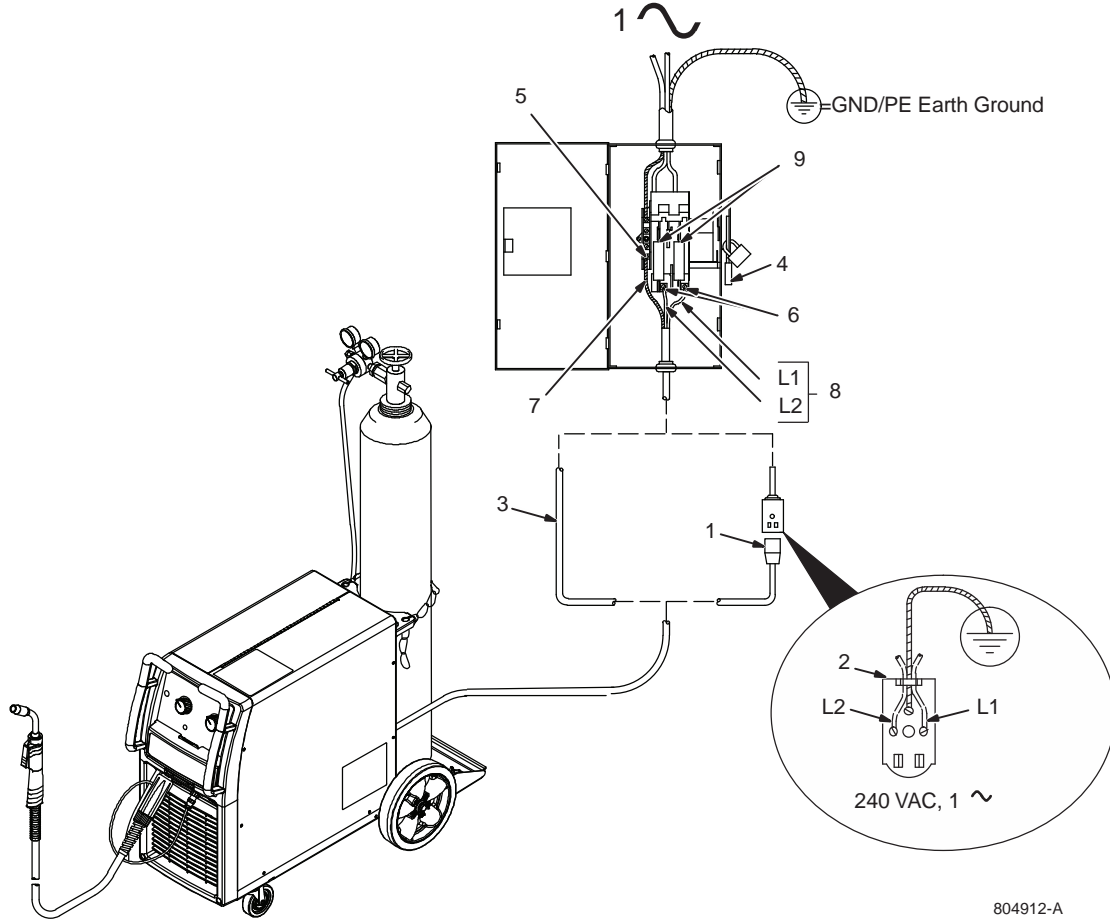
2 "Time-Delay" fuses are UL class "RK5" . See UL 248.

3 "Normal Operating" (general purpose - no intentional delay) fuses are UL class "K5" (up to and including 60 amps), and UL class "H" (65 amps and above). See UL 248.

4 Maximum total length of copper supply conductors in entire installation, raceway and/or flexible cord.

5 Raceway conductor data in this section specifies conductor size (excluding flexible cord or cable) between the panelboard and the equipment per NEC Table 310.16 and is based on allowable ampacities of insulated copper conductors having a temperature rating of 75°C (167°F) with not more than three single current-carrying conductors in a raceway.

5-11. Connecting Input Power



804912-A

⚠ Installation must meet all National and Local Codes—have only qualified persons make this installation.

⚠ Disconnect and lockout/tagout input power before connecting input conductors from unit. Follow established procedures regarding the installation and removal of lockout/tagout devices.

⚠ Always connect green or green/yellow conductor to supply grounding terminal first, and never to a line terminal.

See rating label on unit and check input voltage available at site.

1 Plug (NEMA Type 6-50P)

2 Receptacle [NEMA Type 6-50R (Customer Supplied)]

3 Input Power Cord

Connect directly to line disconnect device if hard wiring is required.

4 Disconnect Device (switch shown in the OFF position)

5 Disconnect Device Grounding Terminal

6 Disconnect Device Line Terminals

7 Green Or Green/Yellow Grounding Conductor

8 Black And White Input Conductor (L1 And L2)

Connect green or green/yellow grounding conductor to disconnect device grounding terminal first.

Connect input conductors L1 and L2 to disconnect device line terminals.

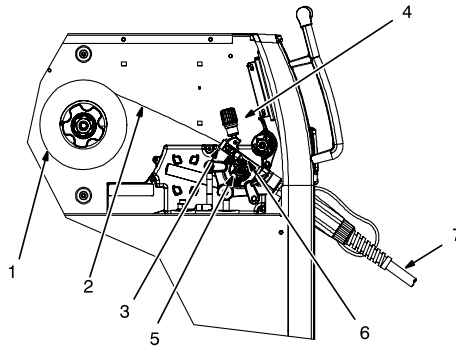
9 Over-Current Protection

Select type and size of over-current protection using Electrical Service Guide (fused disconnect switch shown).

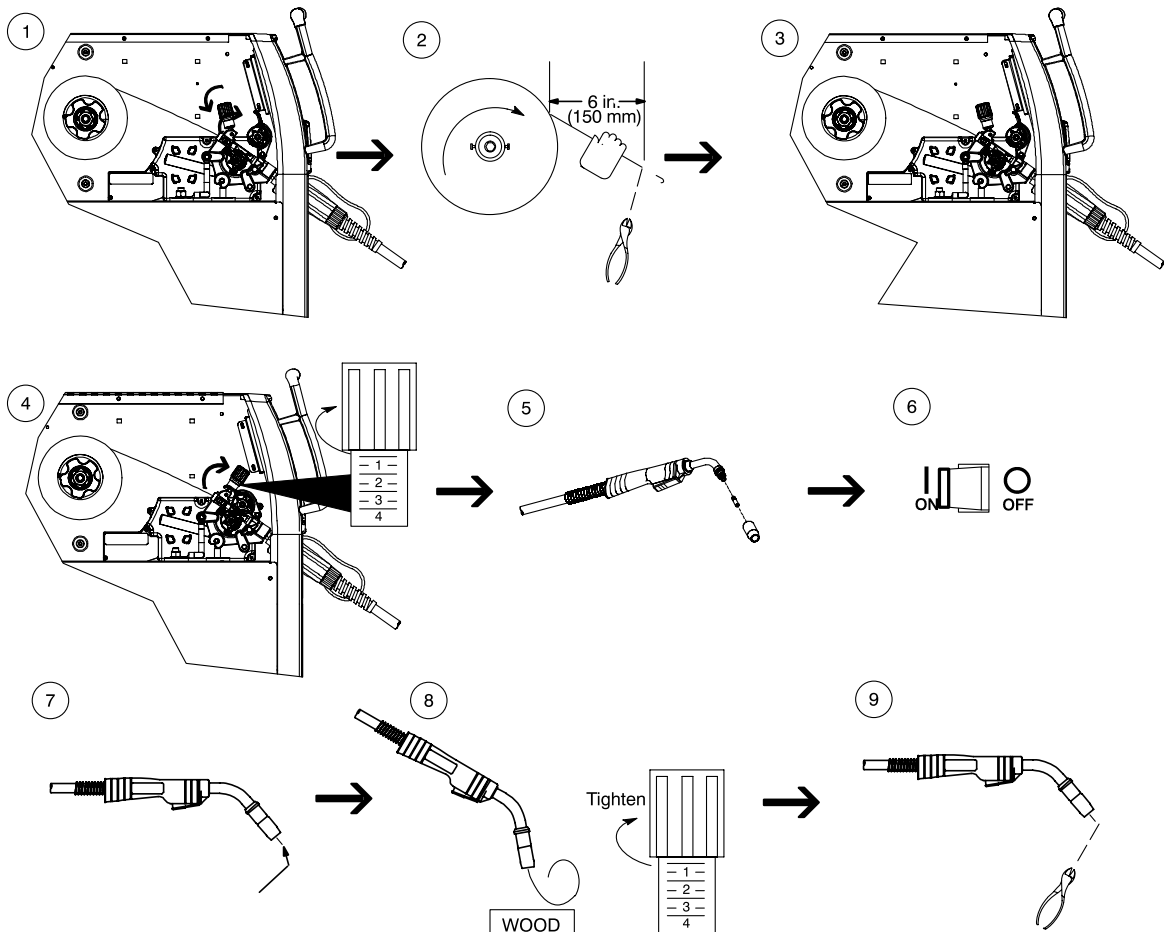
Connect plug to receptacle if hard wiring method is not used.

Close and secure door on disconnect device. Follow established lockout/tagout procedures to put unit in service.

5-12. Threading Welding Wire



Ref. 804913-B



- 1 Wire Spool
- 2 Welding Wire
- 3 Inlet Wire Guide
- 4 Pressure Adjustment Knob
- 5 Drive Roll
- 6 Outlet Wire Guide
- 7 Gun Conduit Cable

Lay gun cable out straight.

Step 1. Open pressure assembly.

Step 2. Pull and hold wire; cut off end.

Hold wire tightly to keep it from unraveling.

Step 3. Push wire through guides into gun; continue to hold wire.

Step 4. Close and tighten pressure assembly, and let go of wire.

Use pressure indicator to set a desired drive roll pressure.

Step 5. Remove gun nozzle and contact tip.

Step 6. Turn power on.

Step 7. Press gun trigger until wire comes out of gun. Reinstall contact tip and nozzle.

Step 8. Feed wire onto a non-conductive surface (e.g. wood) to check drive roll pressure. Tighten knob enough to prevent slipping.

Step 9. Cut off wire. Close and latch door.

5-13. Weld Parameters

Selecting Wire, Gas and Control Settings

Material	Suggested Wire Types and Polarity	Suggested Shielding Gases	Wire Sizes (Diameters)
STEEL	Solid Wire ER70s-6 DCEP	100% CO ₂	0.024"
			0.030"
			0.035"
			0.045"
STEEL	Flux-Cored E71T-11 DCEN	No shielding gas required.	0.030"
			0.035"
			0.045"

Material	Suggested Wire Types and Polarity	Suggested Shielding Gases	Wire Sizes (Diameters)
STEEL	Solid Wire ER70s-6 DCEP	75% Ar/25% CO ₂	0.024"
			0.030"
			0.035"
			0.045"
	Solid Wire ER70s-6 DCEP	90% Ar/10% CO ₂	0.030"
			0.035"
0.045"			

Material	Suggested Wire Types and Polarity	Suggested Shielding Gases	Wire Sizes (Diameters)
STAINLESS STEEL	Stainless Steel ER 308, ER 308L, ER 308LSi DCEP	98% Ar/2% CO ₂	0.030"
			0.035"
ALUMINUM with SpoolRunner™ 200 Spoolgun	Aluminum ER4043 DCEP	100% Ar	0.030"
			0.035"
	Aluminum ER5356 DCEP	100% Ar	0.047"
			0.035"
0.047"			

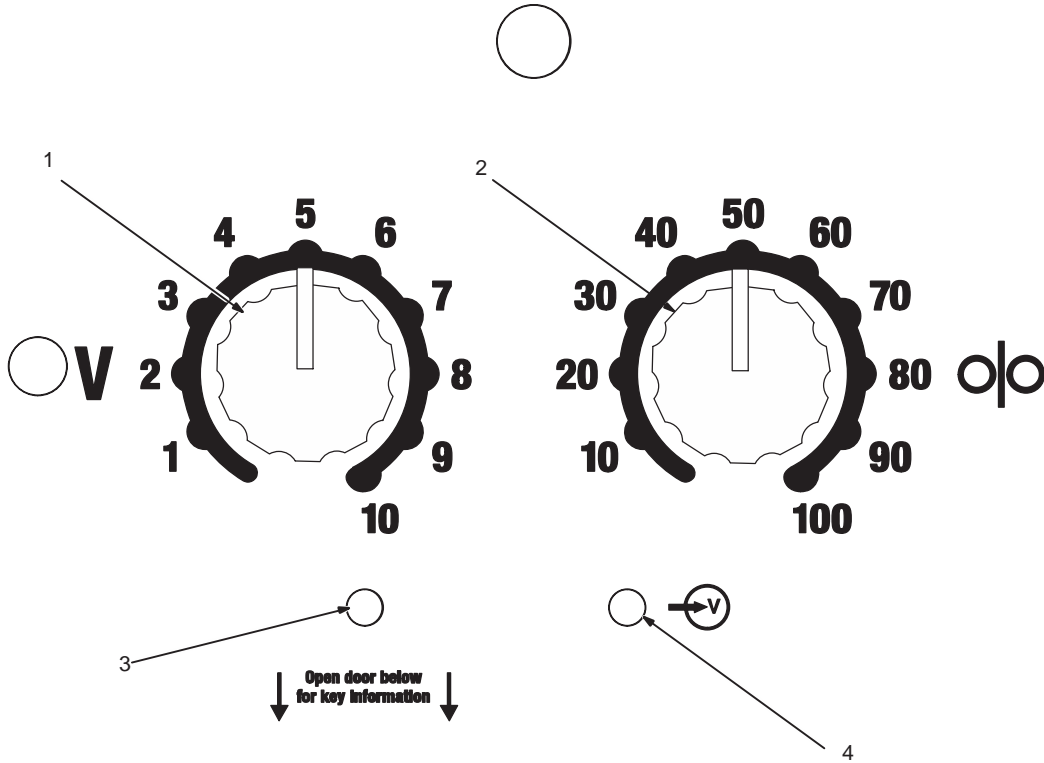
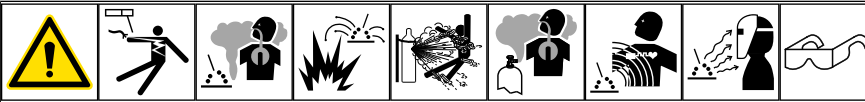
24 ga. (0.5mm)	22 ga. (0.8mm)	18 ga. (1.2mm)	16 ga. (1.6mm)	14 ga. (2.0mm)	1/8" (3.2mm)	3/16" (4.8mm)	1/4" (6.4mm)	3/8" (9.5mm)	1/2" (12.7mm)
2.3/15	3/21	3.4/28	3.9/40	4.5/53	5.1/70	5.6/75	—	—	—
—	—	1.5/15	2.5/18	2.8/25	3.2/35	4/40	4.5/45	7.5/65	—
—	—	1.5/17	2.1/21	3.1/22	3.5/22	4.1/31	5/40	6.6/49	—
—	—	—	1.7/13	2.5/20	3.3/22	4/28	4.3/29	6.5/36	7.3/45
—	—	1/22	1.3/26	2/35	3.2/35	4/41	5/53	—	—
—	—	—	1.5/15	2/17	3.5/23	4/30	5.5/40	6/50	—
—	—	—	—	0.9/14	1.8/14	3.2/21	3.6/28	5/38	7.8/41

24 ga. (0.5mm)	22 ga. (0.8mm)	18 ga. (1.2mm)	16 ga. (1.6mm)	14 ga. (2.0mm)	1/8" (3.2mm)	3/16" (4.8mm)	1/4" (6.4mm)	3/8" (9.5mm)	1/2" (12.7mm)
1.1/20	1.8/28	1.9/35	2/40	4.5/80	—	—	—	—	—
0.8/15	1/15	1/20	1.5/20	2/25	2.5/30	2.8/35	4/50	5/60	—
—	—	1.2/20	2/20	2/25	2.6/35	3/40	4.2/50	7.5/55	—
—	—	—	1.5/20	1.9/22	2.3/25	2.5/25	4/30	8.5/45	9/50
0/15	0/18	1/20	1/25	1.5/30	2.7/40	3.2/50	4/55	5/70	—
—	—	0.8/18	2/30	2.5/35	3/40	4/42	4.5/50	8/65	—
—	—	—	1.7/21	2.2/21	2.4/28	3/28	7.2/40	7.5/43	8/45

24 ga. (0.5mm)	22 ga. (0.8mm)	18 ga. (1.2mm)	16 ga. (1.6mm)	14 ga. (2.0mm)	1/8" (3.2mm)	3/16" (4.8mm)	1/4" (6.4mm)	3/8" (9.5mm)	1/2" (12.7mm)
—	1/22	1.5/31	2/38	2.2/45	3.3/60	4.5/65	7/70	8/80	—
—	0/17	1/20	1.5/29	1.9/32	2.4/39	2.9/45	7/50	8.6/70	—
—	—	—	0.9/51	1.9/54	4.5/60	6.5/75	7.1/87	—	—
—	—	—	0/32	1/42	4.6/45	6/60	7.5/75	8/85	—
—	—	—	—	—	—	5.9/40	7/48	8.3/50	8.6/54
—	—	—	0.1/61	0.7/70	4.8/90	—	—	—	—
—	—	—	—	—	3.9/41	5/54	6.9/70	—	—

SECTION 6 – OPERATION

6-1. Controls



Light "ON" steady — Machine is overheated, allow to cool.
 Light "flashes once" — Trigger code, make sure welding gun trigger is not depressed when power is turned on.
 Light "flashes twice" — Shorted output code, make sure wire is not stuck to workpiece.
 Light "flashes three times" — Wirefeed system code, check welding gun and drive system.

284825A

1 Voltage Control

Turn control clockwise to increase voltage.

2 Wire Feed Control

Turn control clockwise to increase wire feed speed.

3 Diagnostic Light

Refer to section 7-6 if light is illuminated or flashing.

4 Power On Light

Power should be on when S1 is turned on.

This unit has three automatic timers included in its operation to help save contact tips, gas, and wire:

Tip Saver - Weld output shuts off if tip is shorted to work surface.






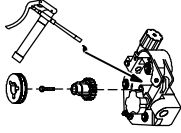

Safety shut-off - Weld output will shut off if no arc is detected within 3 seconds after gun trigger is depressed.

6-2. Arc Start Features / Controls

- Run-In** Run-In is a feature that reduces the wire speed prior to the welding arc being struck to produce smoother arc starts with less spatter.
- There are two available settings for the IronMan 240:
- Manual Run-In (**default setting**)
- Automatic Run-In / FasTack
- Run-In Setup Mode** Turn on the welder while holding the MIG gun trigger. Verify the yellow diagnostic light on the control panel (Section 6–1) blinks once every 2 seconds. While continuing to hold the MIG gun trigger, turn the wire feed control knob from minimum to maximum and verify the yellow diagnostic light begins to blink rapidly. Continue to hold the MIG gun trigger and then adjust the wire feed control knob to the desired run-in speed / mode described below. Release the trigger and then pull and release the trigger once more to set.
- Manual Run-In** During Run-in setup mode, if the wire feed control knob is set to 25 or higher, manual Run-in has been selected and set as a percentage of wire speed.
- Example: During the Run-In Setup mode if the wire feed control knob is set to “50”, Run-In will then be 50% of whatever speed is selected during welding. If the wire speed is set to 300 inches per minute then prior to the weld arc being struck, the wire feed motor will run at 50% of that (150 inches per minute). If the wire speed was then reduced the run-in speed will scale with that and will still be 50 % of the wire feed speed.
- If Run-in is set too high when the wire first contacts the work piece you may experience stumbling / popping starts, producing excess spatter. If Run-in is set too low, you may experience contact tip burnback.
- The default setting for Manual Run-In is 80%. Setting Manual Run-in to 100% effectively disables Run-in and the wire speed will no longer be reduced prior to the arc being struck (similar to the Hobart Ironman 230). The MIG gun and spool gun share the same run-in setting when using Manual Run-in.
- Automatic Run-In / FasTack** During Run-In Setup mode, if the wire feed control knob is set to 20 or lower, Automatic Run-In has been selected. Automatic Run-In further optimizes run-in by automatically adjusting the Run-In for improved arc starts when tack welding. Automatic Run-In adjusts the wire speed prior to the arc being struck, varying the speed based on the amount of time since the last arc.

SECTION 7 – MAINTENANCE AND TROUBLESHOOTING

7-1. Routine Maintenance

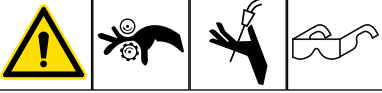
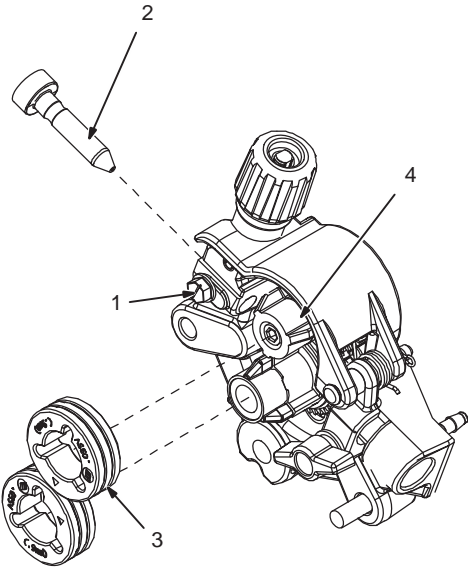
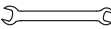
 <p>⚠ Disconnect power before maintaining.</p> <p><i>🔧 Maintain more often during severe conditions.</i></p>				
	✓ = Check	◇ = Change	○ = Clean	☆ = Replace
Every 3 Months	 <p>☆ Unreadable Labels</p>	 <p>○ Weld Terminals</p>	 <p>✓ ☆ Weld Cables</p>	
Every 6 Months	 <p>○ Inside Unit</p>	 <p>✓ Apply Light Coat Of Oil Or Grease To Drive Motor Shaft</p>	 <p>○ Clean Drive Rolls</p>	

*To be done by factory authorized service agent.


7-2. Unit Overload

Thermistor RT1 in SCR1 protects the unit from damage due to overheating. If Over Temp light illuminates, output and wire feed will shut down. Wait for unit to cool down allowing fan motor to run until Over Temp light turns off. If unit is cool and no weld output continues, contact Factory Authorized Service Agent.

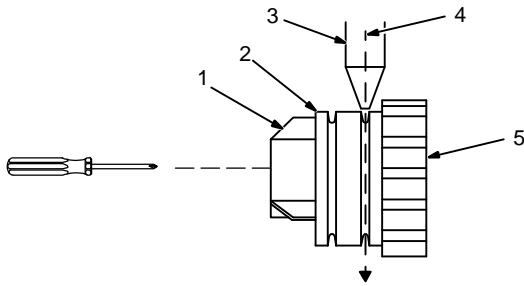
7-3. Changing Drive Roll and Wire Inlet Guide

	
 <p style="text-align: center;">907728</p> <p> 7/16 in.</p>	<p>1 Securing Screw</p> <p>2 Inlet Wire Guide</p> <p>Loosen screw. Slide tip as close to drive rolls as possible without touching. Tighten screw.</p> <p>3 Drive Roll</p> <p>The drive roll consists of two different sized grooves. The stamped markings on the end surface of the drive roll refers to the groove on the opposite side of the drive roll. The groove closest to the motor shaft is the proper groove to thread (see Section 5-12).</p> <p>4 Drive Roll Securing Nut</p> <p>Turn nut one click to secure drive roll.</p>

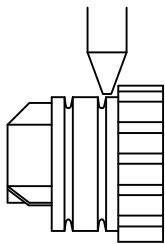
7-4. Aligning Drive Rolls and Wire Guide



Correct



Incorrect



Ref. 800412-A


⚠ Turn Off power.

View is from top of drive rolls looking down with pressure assembly open.

- 1 Drive Roll Securing Nut
- 2 Drive Roll
- 3 Wire Guide
- 4 Welding Wire
- 5 Drive Gear

Insert screwdriver, and turn screw in or out until drive roll groove lines up with wire guide.

Close pressure roll assembly.



7-5. Jog Mode

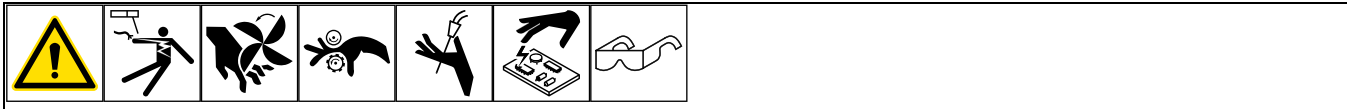
When using the internal motor, if the trigger is held for more than 3 seconds without striking an arc, the unit will automatically shut off weld power and shielding gas, but will feed wire continuously at the preset wire feed speed for up to 20 feet (6.1 m). Once 20 feet (6.1 m) of wire is delivered, a trigger error will occur until trigger is released. When using a spoolgun, if the trigger is held for 3 seconds without striking an arc the unit will automatically shut off weld power and shielding gas, but will feed wire continuously at the preset wire feed speed for up to 10 seconds. After 10 seconds, a trigger error will occur until the trigger is released.

7-6. Diagnostic Light

The Diagnostic light provides diagnostic modes to help troubleshoot various malfunctions with the unit.


Status	Condition	Error	Remedy
Off	Normal	Unit working properly	None
On	Over Temperature	Unit overheated and output stopped.	Release trigger and allow cooling fan to run until diagnostic light turns off.
Flashing 1 Time	Trigger Error	Gun trigger is closed or shorted when unit power is turned on.	Release trigger, then pull trigger again to continue welding.
		Spoolrunner 200 gun trigger was held closed for more than 10 seconds without striking an arc.	
		Standard MIG gun trigger was held closed while more than 20 feet (6.1 m) of wire was delivered without striking an arc.	
Flashing 2 Times	Shorted Secondary	Contact tip is directly shorted to the workpiece. Arc shuts off in this condition.	Release trigger, move contact tip off of workpiece and then pull trigger again to continue welding.
Flashing 3 Times	Motor Overcurrent	Malfunction in wire drive system or motor overcurrent.	Release trigger, then pull trigger again to continue welding.
		Check for proper spool brake adjustment or obstruction in the wire feed system.	
		Check wire guides, gun liner and contact tip for obstruction.	
Flashing 6 Times	Thermistor Error	Malfunction in thermal protection system.	Contact factory authorized service agent.

7-7. Troubleshooting



Trouble	Remedy
No weld output; wire does not feed.	Secure power cord plug in receptacle (see Section 5-11).
	Check and replace power switch if necessary.
	Replace building line fuse or reset circuit breaker if open (see Section 5-11).
	Secure gun plug in receptacle or repair leads, or replace trigger switch (see welding gun Owner's Manual).
No weld output; wire feeds.	Connect work clamp to get good metal to metal contact.
	Replace contact tip (see welding gun Owner's Manual).
	Check connections at output terminals of welder.
Low weld output.	Connect unit to proper input voltage or check for low line voltage (see Section 5-11).
Low, high, or erratic wire speed.	Adjust front panel settings (see Section 6-1).
	Change to correct size drive roll (see Section 7-3).
	Adjust drive roll pressure (see Section 5-12).
	Replace inlet guide, contact tip, and/or liner if necessary (see welding gun Owner's Manual).
Wire Drive/Gun Trouble	Remedy
Wire feeding stops during welding.	Straighten gun cable and/or replace damaged parts (see welding gun Owner's Manual).
	Adjust drive roll pressure (see Section 5-12).
	Readjust hub tension (see Section 5-8).
	Replace contact tip if blocked (see welding gun Owner's Manual).
	Clean or replace wire inlet guide or liner if dirty or plugged (see welding gun Owner's Manual).
	Replace drive roll if worn or slipping (see Section 7-3).
	Secure gun plug in receptacle or repair leads, or replace trigger switch (see welding gun Owner's Manual).
	Check and clear any restrictions at drive assembly and liner (see welding gun Owner's Manual). Have nearest Factory Authorized Service Agent check drive motor.

SECTION 8 – ELECTRICAL DIAGRAM

	WARNING
	<ul style="list-style-type: none"> • Do not touch live electrical parts. • Disconnect input power or stop engine before servicing. • Do not operate with covers removed.
ELECTRIC SHOCK HAZARD	<ul style="list-style-type: none"> • Have only qualified persons install, use, or service this unit.

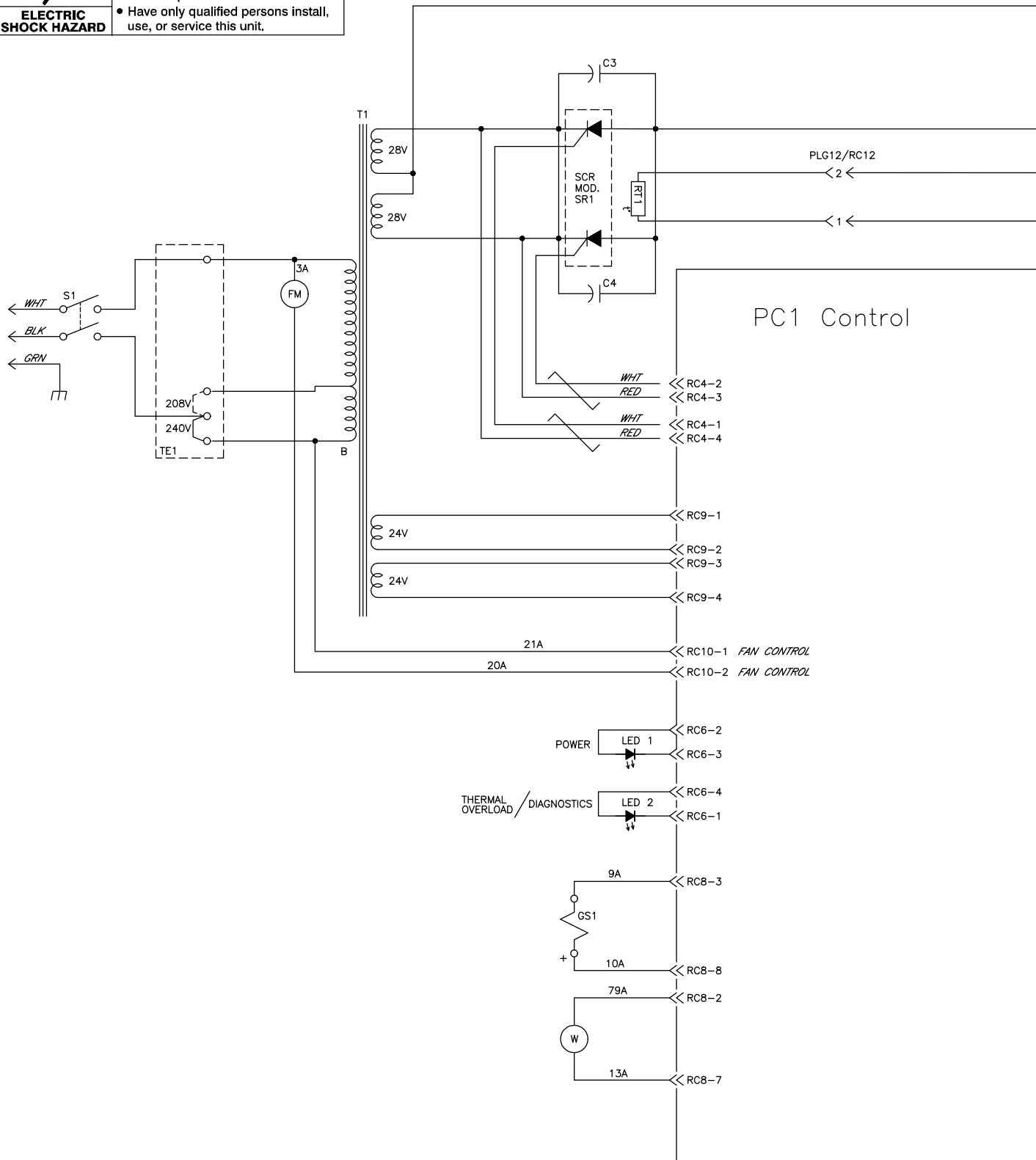
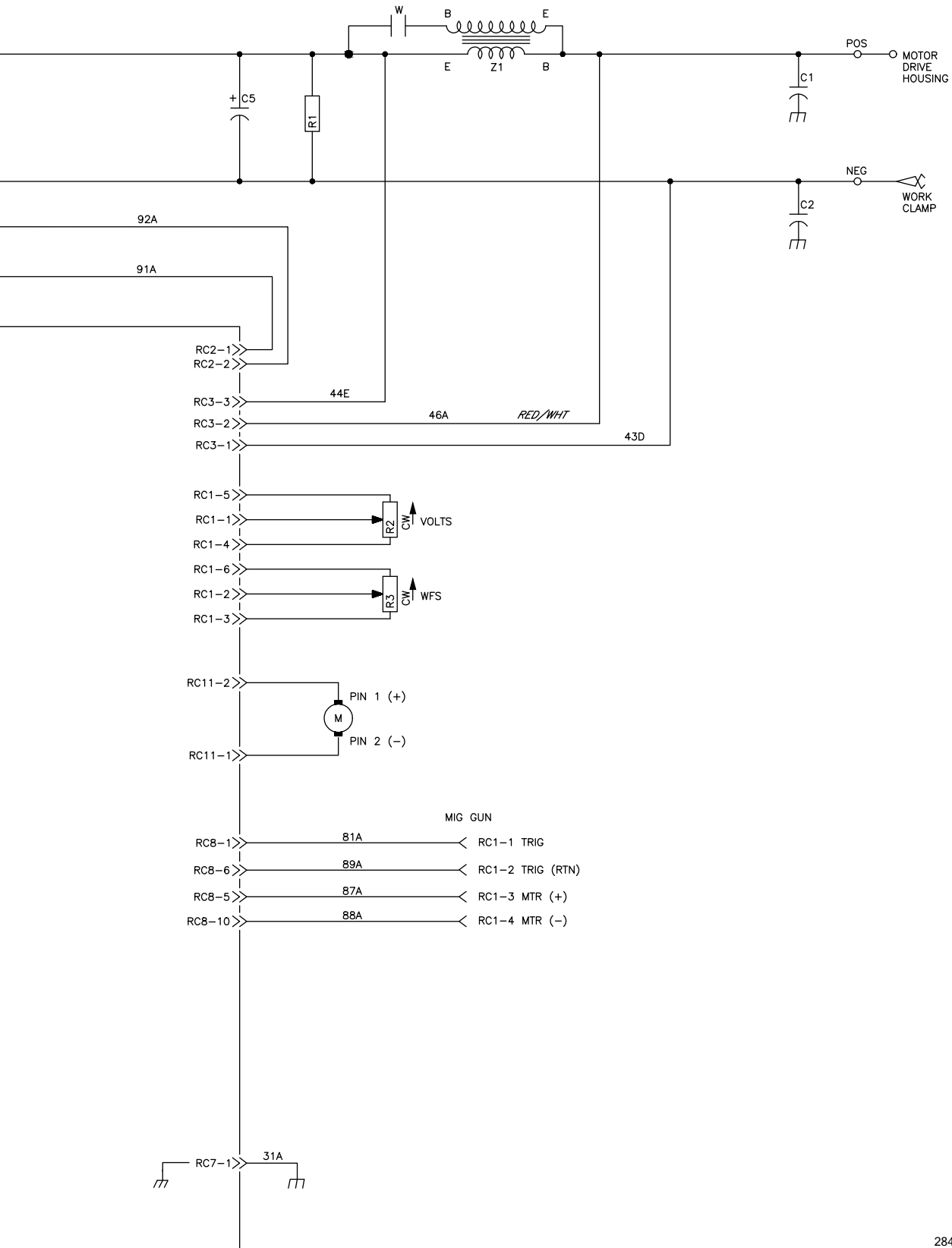


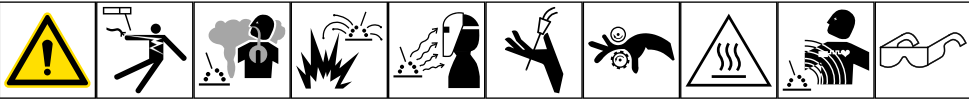
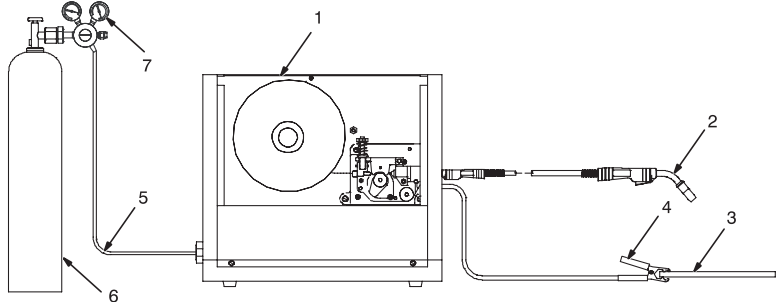
Figure 8-1. Welding Power Source Circuit Diagram



284828-C

SECTION 9 – GMAW (MIG) WELDING (MIG) GUIDELINES


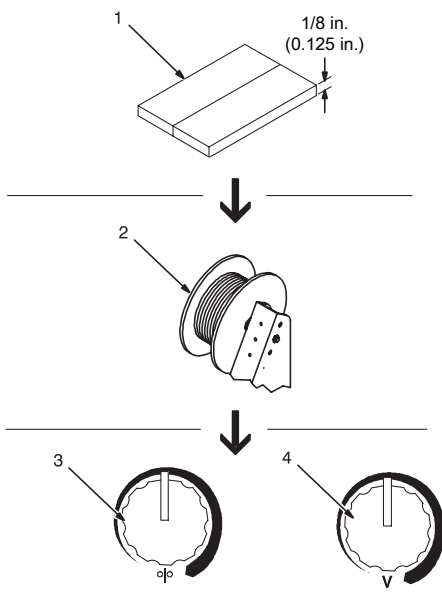
9-1. Typical GMAW (MIG) Process Connections

⚠️ Weld current can damage electronic parts in vehicles. Disconnect both battery cables before welding on a vehicle. Place work clamp as close to the weld as possible.

1 Wire Feeder/Welding Power Source	5 Gas Hose
2 Gun	6 Shielding Gas Cylinder
3 Workpiece	7 Regulator/Flowmeter
4 Work Clamp	

9-2. Typical GMAW (MIG) Process Control Settings

☞ These settings are guidelines only. Material and wire type, joint design, fitup, position, shielding gas, etc. affect settings. Test welds to be sure they comply to specifications.

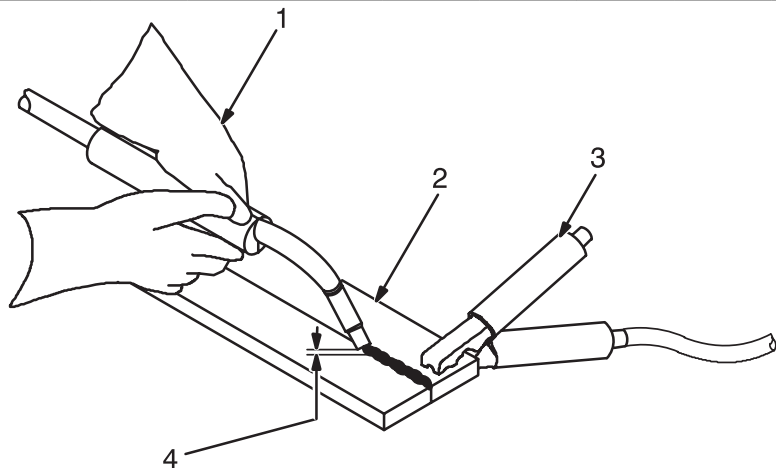
- Material Thickness**
Material thickness determines weld parameters.
Convert material thickness to amperage (A):
0.001 in. (0.025 mm) = 1 ampere
0.125 in. (3.17 mm) ÷ 0.001 = 125 A
- Select Wire Size**
See table below.
- Select Wire Feed Speed (Amperage)**
Wire feed speed (amperage) controls weld penetration. See table below.
- Select Voltage**
Voltage controls height and width of weld bead.
Low Voltage: wire stubs into work
High Voltage: arc is unstable (spatter)
Set voltage midway between high and low voltage and adjust as needed for the weld.

Wire Size	Amperage Range	Recommended Wire Feed Speed	Wire Feed Speed *
0.023 in. (0.58 mm)	30-90 A	3.5 ipm (89 mmpm) per amp	3.5 x 125 A = 437 ipm (11.11 mpm)
0.030 in. (0.76 mm)	40-145 A	2 ipm (51 mmpm) per amp	2 x 125 A = 250 ipm (6.35 mpm)
0.035 in. (0.89 mm)	50-180 A	1.6 ipm (41 mmpm) per amp	1.6 x 125 A = 200 ipm (5.08 mpm)
0.045 in. (1.14 mm)	75-250 A	1 ipm (25 mmpm) per amp	1 x 125 A = 125 ipm (3.17 mpm)

*125 A based on 1/8 in. (3.17 mm) material thickness.

ipm = inches per minute; mmpm = millimeters per minute; mpm = meters per minute

9-3. Holding And Positioning Welding Gun



☞ Wire is energized when gun trigger is pressed. Before lowering helmet and pressing trigger, be sure wire is no more than 1/2 in. (13 mm) past end of contact tip, and tip of wire is positioned correctly on seam.

1 Hold Gun and Control Gun Trigger

Use both hands to stabilize the gun.

2 Workpiece

3 Work Clamp

4 Contact Tip To Work Distance (Stickout)

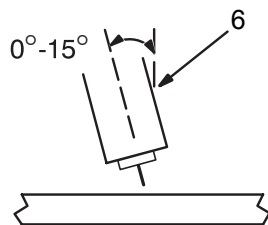
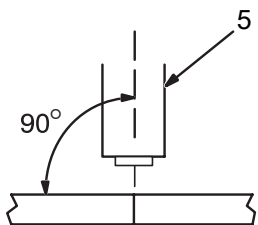
Short Circuit: 1/4 to 1/2 in. (6 to 13 mm)

Spray Transfer: 1/2 to 3/4 in. (13 to 14 mm)

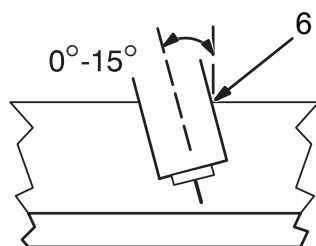
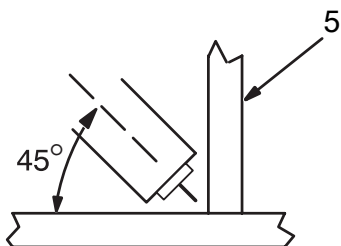
5 End View Of Work Angle

6 Side View Of Travel Angle

Groove Welds



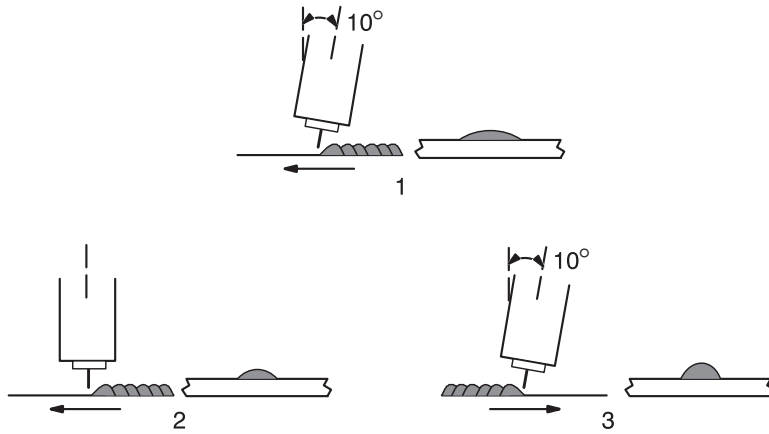
Fillet Welds



9-4. Conditions That Affect Weld Bead Shape



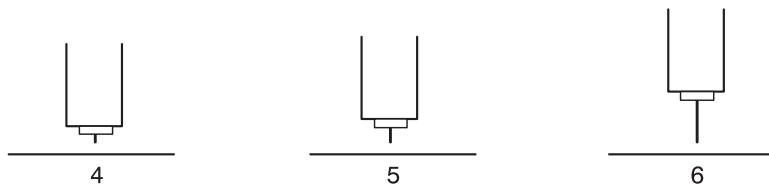
Gun Angles and Weld Bead Profiles



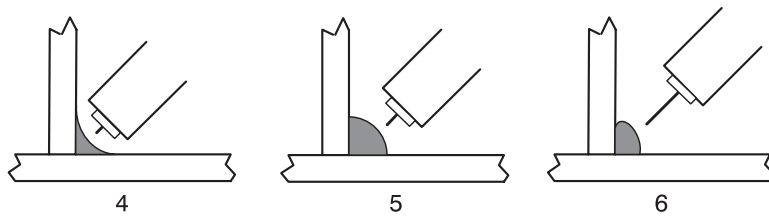
☞ Weld bead shape depends on gun angle, direction of travel, contact to work distance (stickout), travel speed, thickness of base metal, wire feed speed (weld current), and voltage.

- 1 Push
- 2 Perpendicular
- 3 Drag
- 4 Short
- 5 Normal
- 6 Long
- 7 Slow
- 8 Normal
- 9 Fast

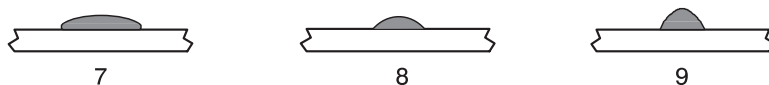
Contact Tip To Work Distance (Stickout)



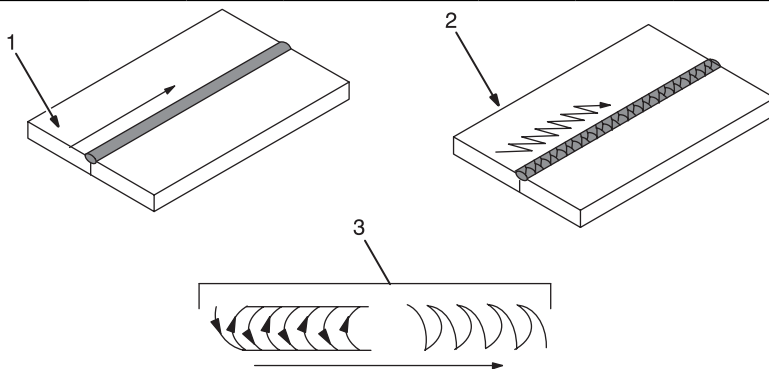
Fillet Weld Contact Tip To Work Distance (Stickout)



Travel Speed



9-5. Gun Movement During Welding



☞ Normally, a single stringer bead is satisfactory for most narrow groove weld joints; however, for wide groove weld joints or bridging across gaps, a weave bead or multiple stringer beads works better.

- 1 Stringer Bead - Steady Forward Movement Along Weld Joint
- 2 Weave Bead - Side To Side Movement Along Weld Joint
- 3 Weave Patterns

Use weave patterns to cover a wide area in one pass of the electrode.

9-6. Poor Weld Bead Characteristics

<ol style="list-style-type: none"> 1 Large Spatter Deposits 2 Rough, Uneven Bead 3 Large Crater At End of Weld 4 Overlap Present 5 Little To No Penetration 									

9-7. Good Weld Bead Characteristics

<ol style="list-style-type: none"> 1 Little To No Micro Spatter 2 Uniform Bead 3 Little To No Crater At End Of Weld 4 No Overlap 5 Adequate Penetration Into Base Metal 									

9-8. Troubleshooting – Excessive Spatter

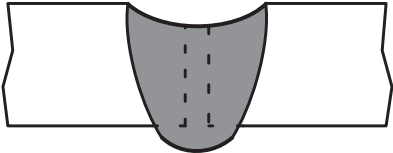
	Excessive Spatter - metal particles expelled during welding that do not form a part of the weld.
Possible Causes	Corrective Actions
Wire feed speed too high.	Select lower wire feed speed.
Voltage too high.	Select lower voltage range.
Electrode extension (stickout) too long.	Use shorter contact tip to work distance (stickout).
Workpiece dirty.	Remove all grease, oil, moisture, rust, paint, undercoating, and dirt from work surface before welding.
Insufficient shielding gas at welding arc.	Increase flow of shielding gas at regulator/flowmeter and/or prevent drafts near welding arc.
Dirty wire.	Use clean, dry wire.
	Eliminate pickup of oil or lubricant on wire from feeder or liner.

9-9. Troubleshooting – Porosity

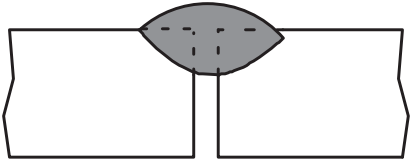
	Porosity - small cavities or holes resulting from gas pockets in weld metal.
Possible Causes	Corrective Actions
Insufficient shielding gas at welding arc.	Increase flow of shielding gas at regulator/flowmeter and/or prevent drafts near welding arc.
	Remove spatter from gun nozzle.
	Check gas hoses for leaks.
	Ensure proper contact tip to work distance.
	Hold gun near bead at end of weld until molten metal solidifies.
Wrong gas.	Use welding grade shielding gas; change to different gas.
Dirty wire.	Use clean, dry wire.
	Eliminate pick up of oil or lubricant on wire from feeder or liner.
Workpiece dirty.	Remove all grease, oil, moisture, rust, paint, coatings, and dirt from work surface before welding.

	Use a more highly deoxidizing wire (contact supplier).
Excessive contact tip to work distance	Ensure proper contact tip to work distance

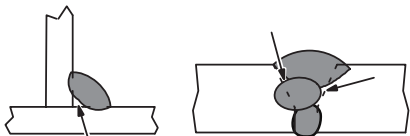
9-10. Troubleshooting – Excessive Penetration

	Excessive Penetration - weld metal melting through base metal.
Possible Causes	Corrective Actions
Excessive heat input.	Select lower voltage and reduce wire feed speed.
	Increase travel speed.

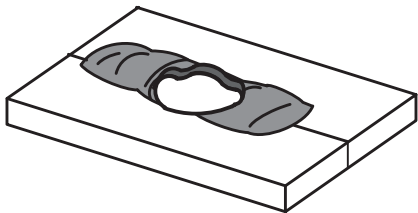
9-11. Troubleshooting – Incomplete Joint Penetration

	Incomplete Joint Penetration - weld metal does not extend through the joint thickness.
Possible Causes	Corrective Actions
Improper joint preparation.	Joint preparation and design must provide access to bottom of groove while maintaining proper contact tip to work distance.
Improper weld technique.	Maintain proper work and travel angles.
	Keep wire on leading edge of weld puddle.
	Maintain proper contact tip to work distance.
Insufficient heat input.	Select higher wire feed speed and/or select higher voltage.
	Reduce travel speed.

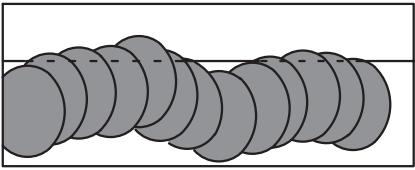
9-12. Troubleshooting – Incomplete Fusion

	Incomplete Fusion - failure of weld metal to fuse completely with base metal or a preceding weld bead.
Possible Causes	Corrective Actions
Workpiece dirty.	Remove all grease, oil, moisture, rust, paint, undercoating, and dirt from work surface before welding.
Insufficient heat input.	Select higher voltage and/or adjust wire feed speed.
Improper welding technique.	Place bead in proper location(s) in joint during welding.
	Pause on groove side walls when using weaving technique.
	Keep wire on leading edge of weld puddle.
	Maintain proper work and travel angles.

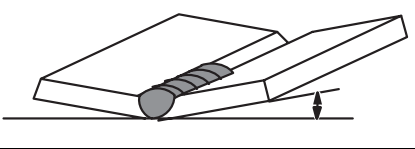
9-13. Troubleshooting – Burn-Through

	Burn-Through - a hole caused by excessive penetration.
Possible Causes	Corrective Actions
Excessive heat input.	Select lower voltage and reduce wire feed speed.
	Increase and/or maintain steady travel speed.

9-14. Troubleshooting – Waviness Of Bead

	<p>Waviness Of Bead - weld metal that is not parallel and does not cover joint formed by base metal.</p>
Possible Causes	Corrective Actions
Excessive contact tip to work distance.	Ensure proper contact tip to work distance.
Unsteady hand.	Support hand on solid surface or use two hands.

9-15. Troubleshooting – Distortion

	<p>Distortion - contraction of weld metal during welding that forces base metal to move. Illustration: Base metal moves in the direction of the weld bead.</p>
Possible Causes	Corrective Actions
Excessive heat input.	Use restraint (clamp) to hold base metal in position.
	Make tack welds along joint before starting welding operation.
	Select lower voltage range and/or reduce wire feed speed.
	Increase travel speed.
	Weld in small segments and allow cooling between welds.

9-16. Common MIG Shielding Gases

This is a general chart for common gases and where they are used. Many different combinations (mixtures) of shielding gases have been developed over the years. The most commonly used shielding gases are listed in the following table.

Gas	Application								
	Spray Arc Steel	Short Cir-cuiting Steel	GMAW-P Steel	Spray Arc Stainless Steel	Short Cir-cuiting Stainless Steel	GMAW-P Stainless Steel	Spray Arc Aluminum	Short Cir-cuiting Aluminum	GMAW-P Aluminum
Argon							All Positions	All Positions	All Positions
Argon + 2% O ₂	Flat & Horizontal Fillet		All Positions	Flat & Horizontal Fillet					
Argon + 2% CO ₂				Flat & Horizontal Fillet	All Positions	All Positions			
Argon + 5% CO ₂	Flat & Horizontal Fillet		All Positions						
Argon + 10% CO ₂	Flat & Horizontal Fillet	All Positions	All Positions						
Argon + 25% CO ₂		All Positions							
CO ₂		All Positions							
Helium							All Positions*		
Argon + Helium							All Positions*		
90% HE + 7-1/2% AR + 2-1/2% CO ₂					All Positions				
65% AR + 33% HE + 2% CO ₂						All Positions			

* Heavy Thicknesses

9-17. Troubleshooting Guide For Semiautomatic Welding Equipment

Problem	Probable Cause	Remedy
Wire feed motor operates, but wire does not feed.	Too little pressure on drive rolls.	Increase pressure setting on drive rolls.
	Incorrect drive rolls.	Check size stamped on drive rolls, replace to match wire size and type if necessary.
	Spool hub tension too high.	Decrease brake pressure on wire spool.
	Restriction in the gun and/or assembly.	Check and replace cable, gun, and contact tip if damaged. Check size of contact tip and cable liner, replace if necessary.
Wire curling up in front of the wire feed rolls (bird nesting).	Too much pressure on drive rolls.	Decrease spool hub tension.
	Incorrect liner or gun contact tip size.	Check size of contact tip and check liner length and diameter, replace if necessary.
	Gun end not inserted into drive housing properly.	Loosen gun securing bolt in drive housing and push gun end into housing just enough so it does not touch drive rolls.
	Dirty or damaged (kinked) liner.	Replace liner.
Wire feeds, but no gas flows (GMAW).	Gas cylinder empty.	Replace empty gas cylinder.
	Gas nozzle plugged.	Clean or replace gas nozzle.
	Gas cylinder valve not open or flowmeter not adjusted.	Open gas valve at cylinder and adjust flow rate.
	Restriction in gas line.	Check gas hose between flowmeter and wire feeder, and gas hose in gun and cable assembly.
	Loose or broken wires to gas solenoid.	Have Factory Authorized Service Agent repair wiring.
	Gas solenoid valve not operating.	Have Factory Authorized Service Agent replace gas solenoid valve.
	Incorrect primary voltage connected to welding power source.	Check primary voltage and relink welding power source for correct voltage.
Welding arc not stable.	Wire slipping in drive rolls.	Adjust pressure setting on drive rolls. Replace worn drive rolls if necessary.
	Wrong size gun liner.	Match liner to wire size and type.
	Incorrect voltage setting for selected wire feed speed on welding power source.	Readjust welding parameters.
	Loose connections at the gun weld cable or work cable.	Check and tighten all connections.
	Gun in poor shape or loose connection inside gun.	Repair or replace gun as necessary.
	Wrong size contact tip or worn out contact tip.	Match contact tip to wire size and type. Replace contact tip as necessary.

SECTION 10 – PARTS LIST

10-1. Drive Roll And Wire Guide Kits

Base selection of drive rolls upon the following recommended usages:

- 6 V-Grooved rolls for hard wire (solid steel and metal cored).
- 7 U-Grooved rolls for soft and soft shelled cored wires (aluminum).
- 8 U-Cogged rolls for extremely soft shelled wires (usually hard surfacing types).
- 9 V-Knurled rolls for hard shelled cored wires (flux cored).
- 10 Drive roll types may be mixed to suit particular requirements (example: V-Knurled roll in combination with U-Grooved).

Wire Diameter		Kit No.	Drive Roll		Inlet Wire Guide
Decimal	Metric		Part No.	Type	
0.023 / 0.025 in.	0.6 mm	087131	087130	V-Grooved	056192
0.030 / 0.035 in.	0.8 / 0.9 mm	204579	203526	V-Grooved	056192
0.030 in.	0.8 mm	079594	053695	V-Grooved	056192
0.035 in.	0.9 mm	079595	053700	V-Grooved	056192
0.045 in.	1.2 mm	079596	053697	V-Grooved	056193

5/3/1 WARRANTY



Effective January 1, 2025

5/3/1 WARRANTY applies to all Hobart welding equipment, plasma cutters and spot welders with a serial number preface of NF or newer.

This limited warranty supersedes all previous Hobart warranties and is exclusive with no other guarantees or warranties expressed or implied.

Hobart products are serviced by Hobart or Miller Authorized Service Agencies.

LIMITED WARRANTY - Subject to the terms and conditions below, Miller Electric Mfg. LLC, dba Hobart Welding Products, Appleton, Wisconsin, warrants to its original retail purchaser that new Hobart equipment sold after the effective date of this limited warranty is free of defects in material and workmanship at the time it is shipped. THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

Within the warranty periods listed below, Hobart/Miller will repair or replace any warranted parts or components that fail due to such defects in material or workmanship. Notifications submitted as on-line warranty claims must provide detailed descriptions of the fault and troubleshooting steps taken to diagnose failed parts. Warranty claims that lack the required information as defined in the Miller Service Operation Guide (SOG) may be denied by Miller.

Hobart/Miller shall honor warranty claims on warranted equipment listed below in the event of a defect within the warranty coverage time periods listed below. Warranty time periods start on the delivery date of the equipment to the original retail purchaser.

1 5 Years — Parts and Labor

- Original Main Power Rectifiers only to include SCRs, diodes, and discrete rectifier modules in non-inverter products
- Capacitors
- Stabilizers
- Transformers

2 3 Years — Parts and Labor Unless Specified

- Drive Systems
- Idle Module
- Inverter Power Sources
- PC Boards
- Rotors, Stators and Brushes
- Solenoid Valves
- Switches and Controls
- Transformer/Rectifier Power Sources

3 1 Year — Parts and Labor Unless Specified(90 days for industrial use)

- Accessories (Kits)
- MIG Flowgauge Regulators (No Labor)

- MIG Guns/TIG Torches
- Plasma Cutting Torches
- Remote Controls
- Replacement Parts (No labor) - 90 days
- Running Gear
- Spoolguns

4 6 Months — Parts

- 12 Volt Automotive-Style Batteries

5 Engines and tires are warranted separately by the manufacturer.

Hobart's 5/3/1 Limited Warranty shall not apply to:

1. **Consumable components; such as contact tips, cutting nozzles, contactors, brushes, relays, work station table tops and welding curtains, or parts that fail due to normal wear. (Exception: brushes and relays are covered on all engine-driven products.)**
2. Items furnished by Hobart/Miller, but manufactured by others, such as engines or trade accessories. These items are covered by the manufacturer's warranty, if any.
3. Equipment that has been modified by any party other than Hobart/Miller, or equipment that has been improperly installed, improperly operated or misused based upon industry standards, or equipment which has not had reasonable and necessary maintenance, or equipment which has been used for operation outside of the specifications for the equipment.
4. Defects caused by accident, unauthorized repair, or improper testing.

HOBART PRODUCTS ARE INTENDED FOR COMMERCIAL AND INDUSTRIAL USERS TRAINED AND EXPERIENCED IN THE USE AND MAINTENANCE OF WELDING EQUIPMENT.

The exclusive remedies for warranty claims are, at Hobart's/Miller's option, either: (1) repair; or (2) replacement; or, if approved in writing by Hobart/Miller, (3) the pre-approved cost of repair or replacement at an authorized Hobart/Miller service station; or (4) payment of or credit for the purchase price (less reasonable depreciation based upon use). Products may not be returned without Hobart's/Miller's written approval. Return shipment shall be at customer's risk and expense.

The above remedies are F.O.B. Appleton, WI, or Hobart's/Miller's authorized service facility.

Transportation and freight are the customer's responsibility. TO THE EXTENT PERMITTED BY LAW, THE REMEDIES HEREIN ARE THE SOLE AND EXCLUSIVE REMEDIES REGARDLESS OF THE LEGAL THEORY. IN NO EVENT SHALL HOBART/MILLER BE LIABLE FOR DIRECT, INDIRECT, SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES (INCLUDING LOSS OF PROFIT) REGARDLESS OF THE LEGAL THEORY. ANY WARRANTY NOT PROVIDED HEREIN AND ANY IMPLIED WARRANTY, GUARANTY, OR REPRESENTATION, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE, ARE EXCLUDED AND DISCLAIMED BY HOBART/MILLER.

Some US states do not allow limiting the duration of an implied warranty or the exclusion of certain damages, so the above limitations may not apply to you. This warranty provides specific legal rights, and other rights may be available depending on your state. In Canada, some provinces provide additional warranties or remedies, and to the extent the law prohibits their waiver, the limitations set out above may not apply. This Limited Warranty provides specific legal rights, and other rights may be available, but may vary by province.

Warranty Questions?

Call 1-800-332-3281
8 AM – 5 PM EST

Service

You always get the fast, reliable response you need. Most replacement parts can be processed and shipped in 24 hours.

Support

Need fast answers to the tough welding questions? Contact your distributor or call 1-800-332-3281. The expertise of the distributor and Hobart is there to help you, every step of the way.

Assistance

Visit the Hobart website:
www.HobartWelders.com

Owner's Record

Please complete and retain with your personal records.

Model Name _____ Serial/Style Number _____

Purchase Date _____ (Date which equipment was delivered to original customer.) _____

Distributor _____

Address _____

City _____

State _____ Zip _____



Thank you for purchasing Hobart. Our trained technical support team is dedicated to your satisfaction. For questions regarding performance, operation, or service, contact us!

Resources Available

To locate a Service Center:

Visit our website at <https://www.HobartWelders.com/where-to-buy>

Or call 1-800-332-3281

For Technical Assistance:

Always provide Model Name and Serial/Style Number.

Call 1-800-332-3281

8 AM to 5 PM EST – Monday through Friday

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