

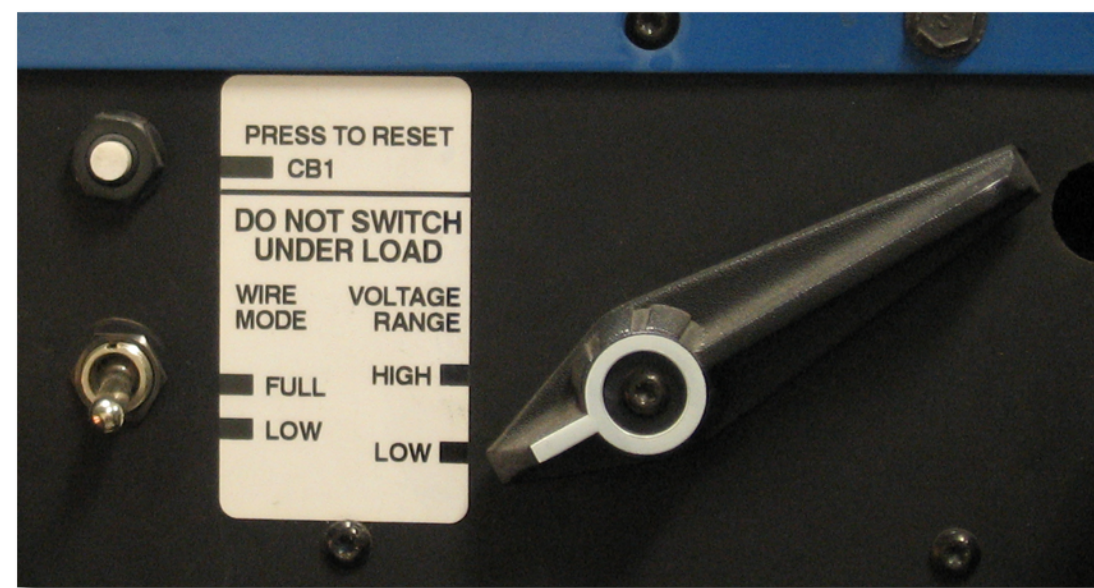
# MIG WELDING SETUP

FOR 0.035" WIRE ONLY. FOR OTHER WIRE SIZES PLEASE CONSULT CHART INSIDE MACHINE

	Material Thickness						
	5/16"	1/4"	3/16"	1/8"	14 ga.	16 ga.	18 ga.
Voltage Range	High	High	High	Low	Low	Low	Low
Wire Mode	Full	Low	Low	Low	Low	Low	Low
Thickness	3	2	1	5	4	3	2
Wire Speed	60	60	51	45	48	41	30

## MACHINE SETTINGS

First consult chart based on Material Thickness

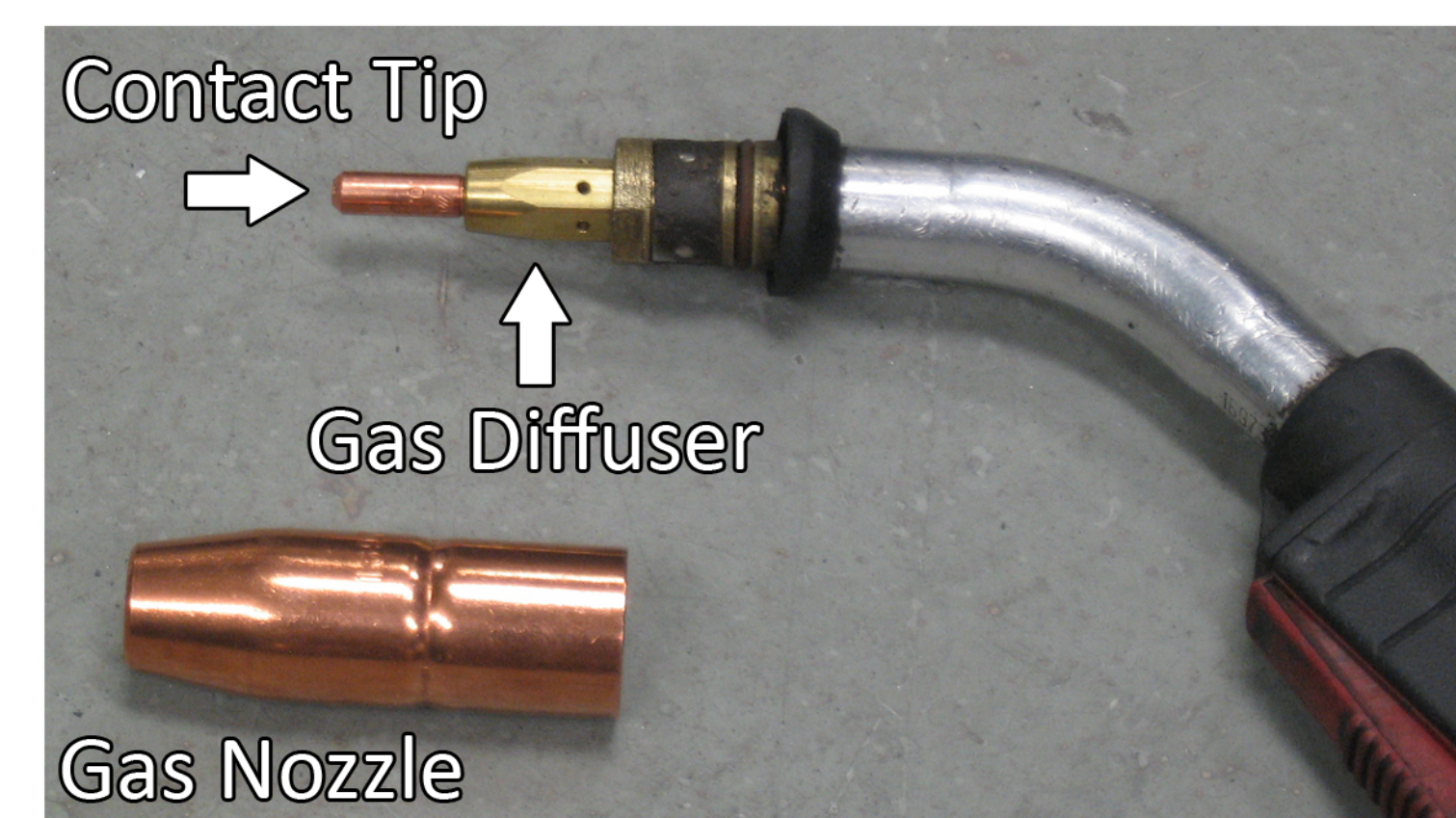


1. Set voltage range lever
2. Set wire mode switch



3. Set wire speed knob
4. Set thickness knob

## MACHINE CLEANING



1. Slide gas nozzle from end of wand
2. Clear away all material inside nozzle and around contact tip and gas diffuser ensuring diffuser holes are clean.
3. Wrench tighten gas diffuser; Hand-tighten contact tip
4. Spray Nozzle-Shield into end of gas nozzle to prevent splatter buildup

**\*\*Excessively worn parts should be replaced\*\***

**\*\*See Russ\*\***

**IF YOU ARE UNSURE  
ABOUT ANYTHING**



**ASK RUSS OR  
A MENTOR**