

# OWNER'S MANUAL

MODEL: STICK225

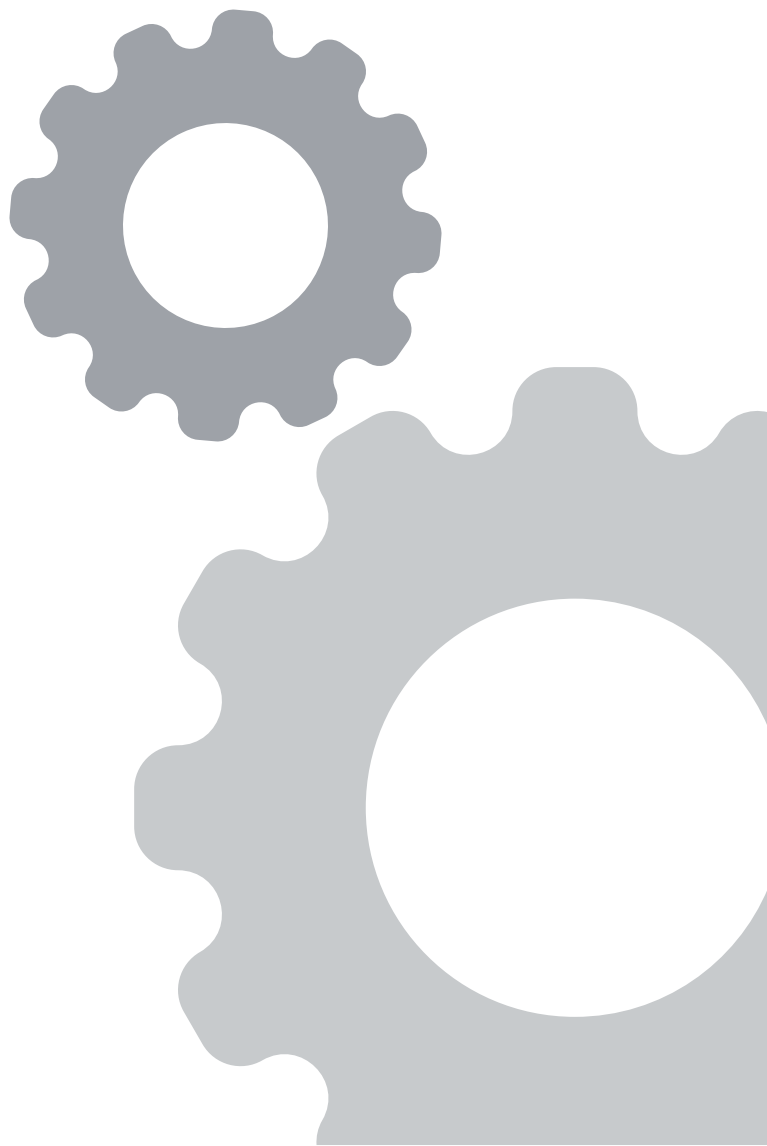
*PrimeWeld*



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**856-500-2000**



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# SAFETY

Welding and cutting equipment can be dangerous to both the operator and people in or near the surrounding working area, if the equipment is not correctly operated. Equipment must only be used under the strict and comprehensive observance of all relevant safety regulations. Read and understand this instruction manual carefully before the installation and operation of this equipment.

## MACHINE OPERATION SAFETY

- Do not switch the function modes while the machine is welding. Switching of the function modes during welding can damage the machine. Damage caused in this manner will not be covered under warranty.
- Disconnect the electrode-holder cable from the machine before switching on the machine, to avoid arcing should the electrode be in contact with the work piece.
- Operators should be trained and or qualified.

**ELECTRIC SHOCK:** It 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 internal machine circuits are also live when power is on. Incorrectly installed or improperly grounded equipment is dangerous.

- Connect the primary input cable according to American standards and regulations. ANSI Z49.1.
- Avoid all contact with live electrical parts of the welding circuit, electrodes and wires with bare hands. The operator must wear dry welding gloves while he/she performs the welding task.
- The operator should keep the work piece insulated from himself/herself.
- Keep cords dry, free of oil and grease, and protected from hot metal and sparks.
- Frequently inspect input power cable for wear and tear, replace the cable immediately if damaged, bare wiring is dangerous and can kill.
- Do not use damaged, under-sized, or badly joined cables.
- Do not drape cables over your body.



**ELECTRIC SHOCK:  
It can kill**

# SAFETY



## FUMES AND GASES ARE DANGEROUS

**FUMES AND GASES ARE DANGEROUS:** Smoke and gas generated while welding or cutting can be harmful to people's health. Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

- Do not breathe the smoke and gas generated while welding or cutting, keep your head out of the fumes.
- Keep the working area well ventilated, use fume extraction or ventilation to remove welding fumes and gases.
- In confined or heavy fume environments always wear an approved air-supplied respirator. Welding fumes and gases can displace air and lower the oxygen level causing injury or death. Be certain the air in your work environment is safe to breathe.
- 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.
- Materials such as galvanized, lead, or cadmium plated steel, contain elements that can give off toxic fumes when welded. Do not weld these materials unless the area is very well ventilated, and or wearing an air supplied respirator.



## ARC RAYS: harmful to people's eyes and skin

**ARC RAYS:** Harmful to people's eyes and skin. Arc rays from the welding process produce intense visible and invisible ultraviolet and infrared rays that can burn eyes and skin.

- Always wear a welding helmet with correct shade of filter lens and suitable protective clothing including welding gloves while the welding operation is performed.
- Measures should be taken to protect people in or near the surrounding working area. Use protective screens or barriers to from flash, glare and sparks warn others not to watch the arc.



## FIRE HAZARD

**FIRE HAZARD:** Welding on closed containers, such as tanks, drums, or pipes, can cause them to explode. Flying sparks from the welding arc, hot work piece, 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.

# SAFETY

- Welding sparks may cause fire, therefore remove any flammable materials away from the working area, at least 40 feet (12m) from the welding arc. Cover flammable materials and containers with approved covers if unable to be moved from the welding area.
- Do not weld on closed containers such as tanks, drums, or pipes, unless they are properly prepared according to the required Safety Standards to insure that flammable or toxic vapors and substances are totally removed, these can cause an explosion even though the vessel has been "cleaned". Vent hollow castings or containers before heating, cutting or welding. They may explode.
- Do not weld where the atmosphere may contain flammable dust, gas, or liquid vapors (such as gasoline).
- Have a fire extinguisher nearby and know how to use it. Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas. Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.



**GAS CYLINDERS**  
Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode

**GAS CYLINDERS:** Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Because gas cylinders are normally part of the welding process, be sure to treat them carefully. **CYLINDERS** can explode if damaged.

- Protect gas cylinders from excessive heat, mechanical shocks, physical damage, slag, open flames, sparks, and arcs.
- Insure cylinders are held secure and upright to prevent tipping or falling over.
- Never allow the welding electrode or earth clamp to touch the gas cylinder, do not drape welding cables over the cylinder.
- Never weld on a pressurized gas cylinder, it will explode and kill you.
- Open the cylinder valve slowly and turn your face away from the cylinder outlet valve and gas regulator.



**GAS BUILD UP**

# SAFETY



**ELECTRONIC  
MAGNETIC  
FIELDS**  
can affect  
implanted  
medical devices

**GAS BUILD UP:** The build up of gas can cause a toxic environment by depleting the air's oxygen content and potentially resulting in injury or death.

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

**ELECTRONIC MAGNETIC FIELDS:** MAGNETIC FIELDS 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 any electric welding, cutting or heating operation.



**NOISE CAN  
DAMAGE  
HEARING**

**NOISE CAN DAMAGE HEARING:** Noise from some processes or equipment can damage hearing. Wear approved ear protection if noise level is high.



**HOT PARTS**

**HOT PARTS:** Items being welded generate and hold high heat and can cause severe burns. Do not touch hot parts with bare hands. Allow a cooling period before working on the welding gun. Use insulated welding gloves and clothing to handle hot parts and prevent burns.

# STICK 225 MACHINE SYSTEM COMPONENTS

## COMPLETE WELDING SYSTEM INCLUDES:

### STICK225

- Electrode Holder with 12feet cable
- Ground Clamp with 12feet cable
- 240V to 120V power adapter
- Hand-hold and Hammer Brush



**Electrode Holder**  
12 feet long



**Ground Clamp**  
12 feet long



**Power Adapter**



**Hand-hold Mask  
and Hammer Brush**

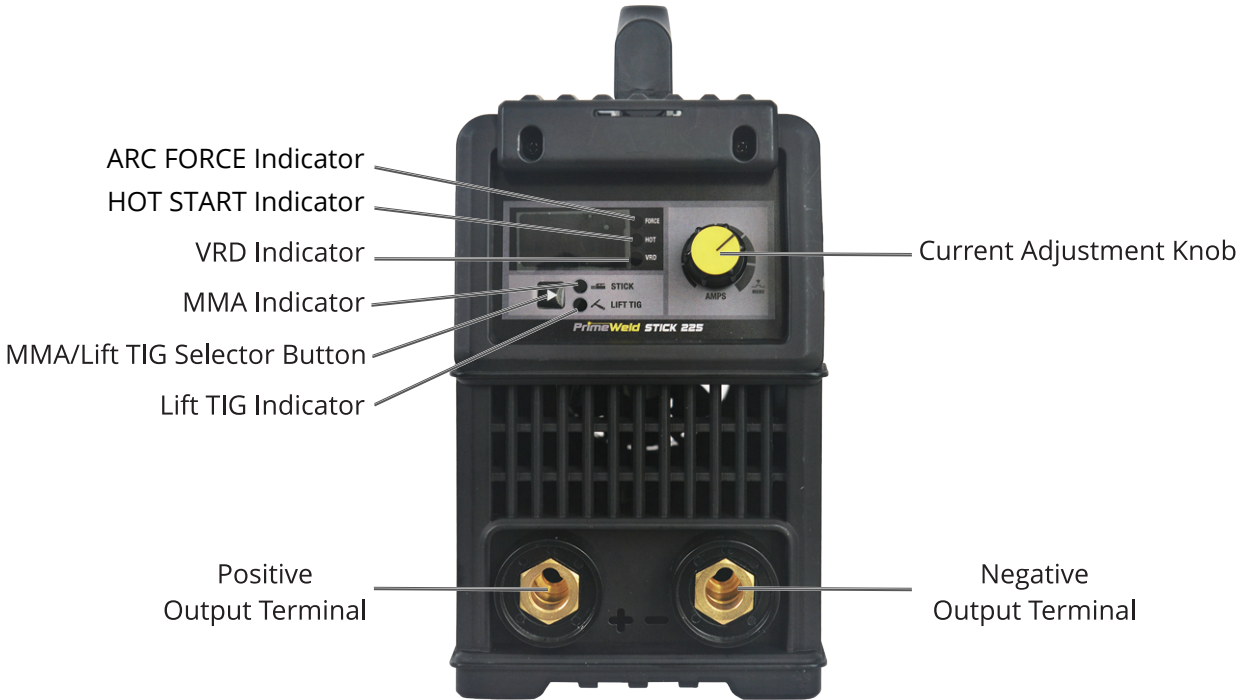
# STICK 225 SPECIFICATIONS

**TABLE 1.1**

<b>ITEM</b> \ <b>TYPE</b>	<b>STICK 225</b>	
Power voltage(V)	1phase 120V±10%	1phase 240V±10%
Frequency(Hz)	50/60	
Rated input current(A)	MMA: 25 TIG: 16	MMA: 51 TIG: 38
Output current adjustment(A)	MMA: 20-70 TIG: 15-70	MMA: 20-225 TIG: 20-225
Output voltage(V)	MMA: 20.8-22.8 TIG: 10.6-12.8	MMA: 20.8-29 TIG: 10.6-19
No-load voltage(V)	81	
VRD voltage(V)	21	
Duty cycle(%) / 40°C	20	
Power factor	0.66	
Efficiency(%)	80.7	
Insulation grade	F	
Housing protection grade	IP21	
Weight(lbs)	11.7	
Overall dimension(in)	13.5x5.3x9.3	

# MACHINE LAYOUT & DESCRIPTIONS

## FRONT VIEW



## BACK VIEW



# SELECTOR SWITCH FUNCTION DESCRIPTIONS



- 1 Arc Force Indicator:** short press the current knob to select the Arc Force Indicator, then rotate the current knob to adjust the Arc Force output current (OFF~100).
- 2 HOT START Indicator:** short press the current knob to select the Hot Start Indicator, then rotate the current knob to adjust the Hot Start output current (OFF~50).
- 3 VRD Indicator:** short press the current knob to select the VRD Option Indicator, then rotate the current knob to select the VRD mode (ON/OFF).
- 4 MMA/Lift TIG Selector Button:** Provide selection of TIG or MMA(Stick) welding modes. Selecting TIG position provides for TIG welding function. Selecting MMA position provides for Stick welding function.
- 5 Power Switch:** This switch powers the machine up when switched to the on position and powers the machine down when switched to the off position.  
NOTE: The On/Off switch is on the back of the STICK 225.

# CAUTION

## 1. WORKING ENVIRONMENT

**1.1** The environment in which this welding equipment is installed must be free of grinding dust, corrosive chemicals, flammable gas or materials etc, and at no more than maximum of 80% humidity.

**1.2** When using the machine outdoors protect the machine from direct sun light, rain water and snow etc; the temperature of working environment should be maintained within -14°F to +104°F (-25.5°C to 40°C).

**1.3** Keep this equipment 1 foot (0.3m) away from the wall.

**1.4** Ensure the working environment is well ventilated.

## 2. SAFETY TIPS

**2.1 Ventilation:** This equipment is small in size, compact in structure and is efficient in producing welding output. The fan is used to dissipate heat generated by this equipment during the welding operation.

**IMPORTANT:** Maintain good ventilation of the louvers of this equipment. The minimum distance between this equipment and any other objects in, or near, the working area should be 1 foot (0.3m). Good ventilation is of critical importance for the normal performance and service life of this equipment.

**2.2 Thermal Overload Protection:** Should the machine be used to an excessive level, or in high temperature environment, poorly ventilated area or if the fan malfunctions, the Thermal Overload Switch will be activated and the machine will cease to operate. Under this circumstance, leave the machine switched on to keep the built-in fan working to bring down the temperature inside the equipment. The machine will be ready for use again when the internal temperature reaches safe level.

**2.3 Over-Voltage Supply:** Regarding the power supply voltage range of the machine, please refer to specifications. The STICK 225 features automatic voltage compensation within the given range. If the input power exceeds the stipulated value, it is possible to cause damage to the components of this equipment. Please ensure your primary power supply is correct.

**2.4** Do not come into contact with the output terminals while the machine is in operation. An electric shock may possibly occur.

# MAINTENANCE

Exposure to extremely dusty, damp, or corrosive air is damaging to the welding machine. In order to prevent any possible failure or fault of this welding equipment, blow the dust out at regular intervals with clean and dry compressed air of required pressure.

**PLEASE NOTE:** Lack of maintenance can result in the cancellation of the warranty; the warranty of this welding equipment will be void if the machine has been modified, or if an attempt is made to take apart the machine or open the factory seal of the machine without the consent of an authorized representative of the manufacturer.

## TROUBLESHOOTING

**CAUTION:** Only qualified technicians are authorized to undertake the repair of this welding equipment. For your safety and to avoid electrical shock, please observe all safety notes and precautions detailed in this manual.

**PLEASE NOTE WHEN USING GENERATOR POWER: MINIMUM SUGGESTED POWER IS 10KVA**

# INSTALLATION & OPERATION

Please install the machine strictly according to the following steps. The protection class of this machine is IP21, so avoid using it in rain.

## CONNECTION OF INPUT CABLES

Primary input cable is supplied with this welding equipment. Connect the primary input cable with power supply of required input voltage. Refer to data plate on machine for Input voltage, IMAX.

## ATTENTION! CHECK FOR GAS LEAKS

### RECOMMENDED PROCEDURE IS AS FOLLOWS:

1. Connect the regulator to the gas cylinder, and the gas hose assembly to the regulator and machine. Securely tighten all connections.
2. Slowly open the cylinder valve.
3. Set the flow rate on the regulator to approximately 15-25CFH (7-12LMN).
4. Close the cylinder valve and pay attention to the needle indicator of the contents pressure gauge on the regulator, if the needle drops away towards zero there is a gas leak. Sometimes a gas leak can be slow and to identify it will require leaving the gas pressure in the regulator and line for an extended time period. In this situation it is recommended to open the cylinder valve, set the flow rate to 15 -25CFH (7-12LMN), close the cylinder valve and check after a minimum of 15 minutes.
5. If there is a gas loss then check all connectors for leakage by brushing or spraying with soapy water. Bubbles will appear at the leakage point.
6. Tighten fitting connections to eliminate gas leakage.

**IMPORTANT! We strongly recommend that you check for gas leakage prior to operation of your machine. We recommend that you close the cylinder valve when the machine is not in use.**

**Primeweld authorized representatives or agents of primeweld will not be liable or responsible for the loss of any gas.**

# INSTALLATION SET-UP FOR SMAW (STICK) WELDING

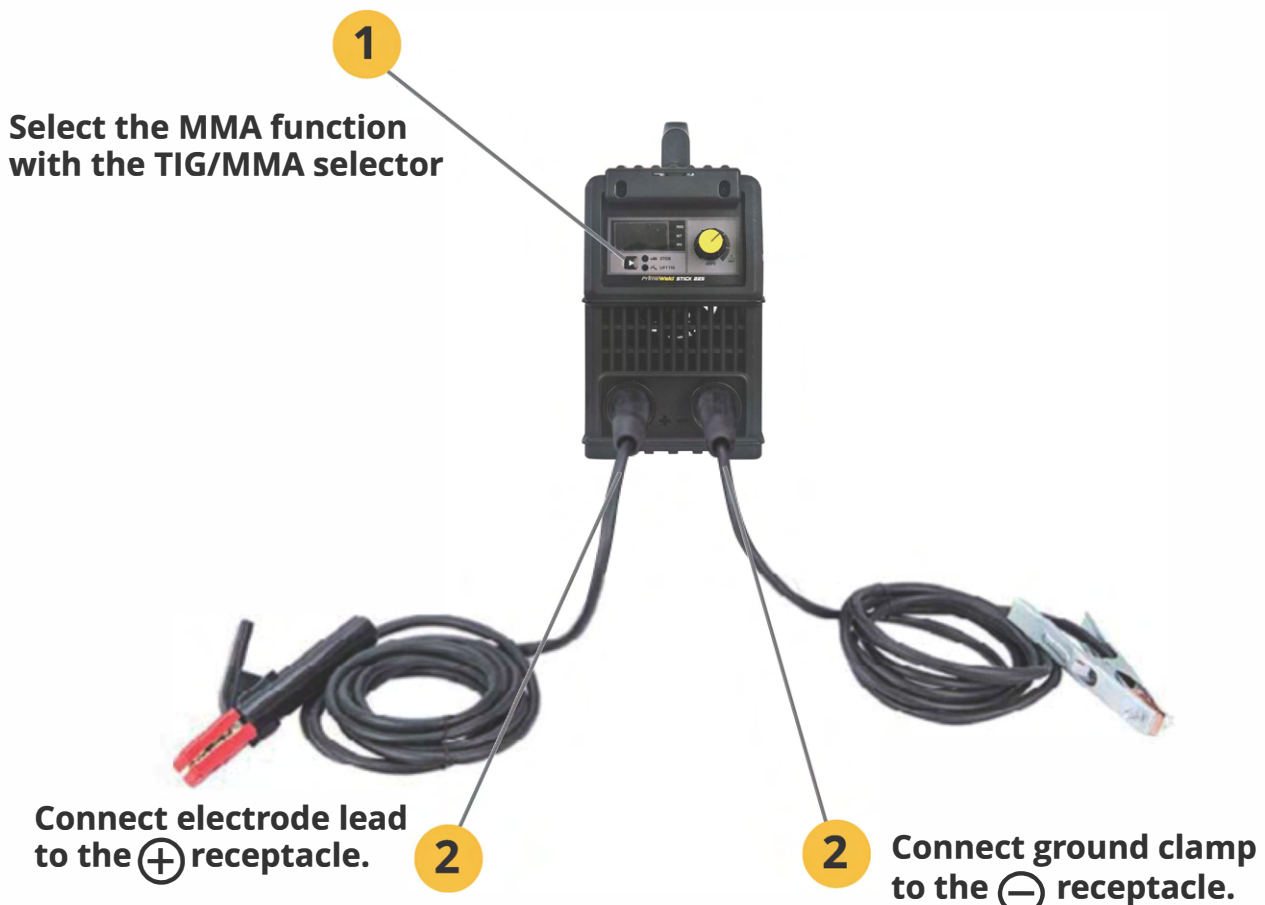
## INSTALLATION SET UP FOR SMAW (STICK) WELDING

- 1 Turn the power source on and select the MMA function with the TIG/MMA selector button.
- 2 Connection of Output Cables

Two weld output receptacles are available on this welding machine. For Stick welding the electrode holder is connected to the positive receptacle, while the ground lead (work piece) is connected to the negative receptacle, this is known as DC+ polarity. However various electrodes require a different polarity for optimum results and careful attention should be paid to the polarity, refer to the electrode manufacturer's information for the correct polarity.

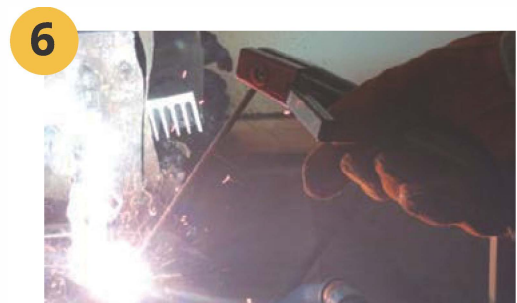
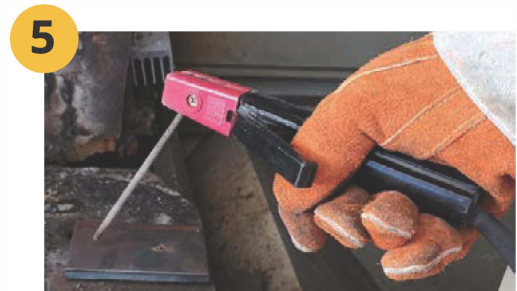
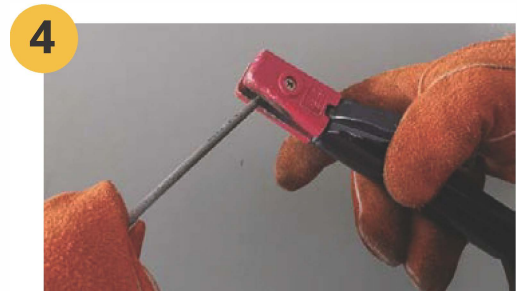
**DC+ Electrode connected to ⊕ output receptacle.**

**DC- Electrode connected to ⊖ output receptacle.**



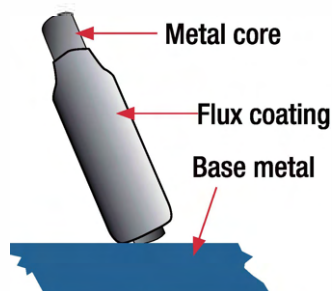
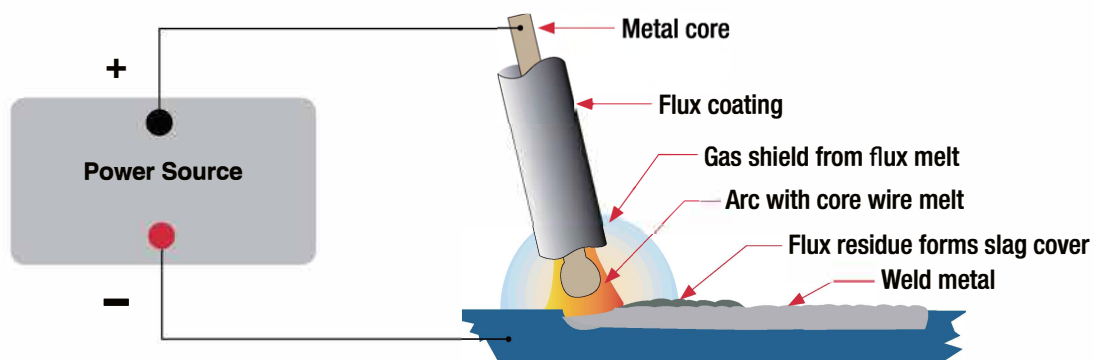
# OPERATION FOR SMAW (STICK) WELDING

- 3 Set the welding current relevant to the electrode type and size being used as recommended by the electrode manufacturer.
- 4 Place the electrode into the electrode holder and clamp tight.
- 5 Scratch the electrode against the work piece to create an arc and hold the electrode steady to maintain the arc.
- 6 Hold the electrode slightly above the work piece to maintain the arc while traveling at an even speed to create an even weld deposition.
- 7 To finish the weld, break the arc by quickly snapping the electrode away from the work piece.
- 8 Wait for the weld to cool and carefully chip away the slag to reveal the weld metal underneath.



# SMAW (STICK) WELDING GENERAL DESCRIPTION

One of the most common types of arc welding is shielded metal arc welding (SMAW) or stick welding. An electric current is used to strike an arc between the base material and a consumable electrode rod or 'stick'. The electrode rod is made of a material that is compatible with the base material being welded and is covered with a flux that gives off gaseous vapors that serve as a shielding gas and provide a layer of slag, both of which protect the weld area from atmospheric contamination. The electrode core itself acts as filler material. The residue from the flux that forms a slag covering over the weld metal must be chipped away after welding.



The arc is initiated by momentarily touching the electrode to the base metal.

The heat of the arc melts the surface of the base metal to form a molten pool at the end of the electrode.

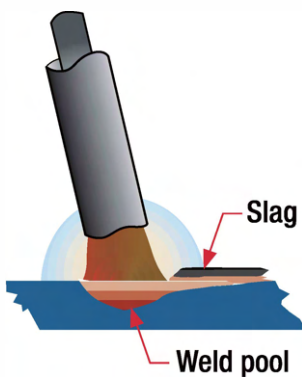
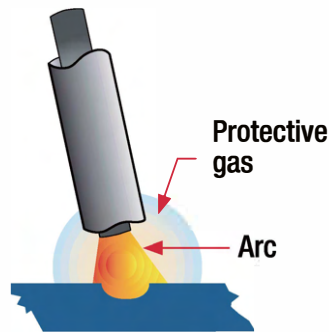
The melted electrode metal is transferred across the arc into the molten pool and becomes the deposited weld metal.

The deposit is covered and protected by a slag which comes from the electrode coating.

The arc and the immediate area are enveloped by an atmosphere of protective gas.

SMAW (stick) electrodes have a solid metal core and a flux coating. These electrodes are identified by the metal core diameter and by a series of letters and numbers. The letters and numbers identify the metal alloy and the intended use of the electrode.

# SMAW (STICK) WELDING GENERAL DESCRIPTION



The metal core works as conductor of the current that maintains the arc. The metal core melts and is deposited into the weld pool.

The covering on a shielded metal arc welding electrode is called flux. The flux on the electrode performs many different functions.

These include:

***Producing a protective gas around the weld area***

***Providing fluxing elements and deoxidizers***

***Creating a protective slag coating over the weld as it cools***

***Establishing arc characteristics***

***Adding alloying elements.***

Covered electrodes serve many purposes in addition to adding filler metal to the molten pool. These additional functions are provided mainly by the covering on the electrode.

# SMAW (STICK) WELDING FUNDAMENTALS

## ELECTRODE SELECTION

As a general rule, the selection of an electrode is straight forward, in that it is only a matter of selecting an electrode of similar composition to the parent metal. However, for some metals there is a choice of several electrodes, each of which has particular properties to suit specific classes of work. It is recommended that you consult your welding equipment supplier for the correct selection of electrode.

### ELECTRODE SIZE

Average Thickness of Material		Maximum Recommended Electrode Diameter	
0.03 – 0.07 inches	0.75 – 2mm	3/32 inch	2.4mm
0.07 – 0.19 inches	2 – 4.8mm	1/8 inch	3.2mm
0.19 – 0.39 inches	4.8–10mm	5/32 inch	4 mm

## ELECTRODE SIZE

The size of the electrode generally depends on the thickness of the section being welded, and the thicker the section the larger the electrode required. The table gives the maximum size of electrodes that may be used for various thicknesses of section based on using a general purpose type E6013, E7018 and E6010 electrode.

### WELDING CURRENT (AMPERAGE)

Electrode Size		Current Range
3/32 inch	2.4mm	60–100 amps
1/8 inch	3.2mm	100–160 amps
5/32 inch	4 mm	160–200 amps
1/5 inch	5 mm	200–300 amps

## WELDING CURRENT (AMPERAGE)

Correct current selection for a particular job is an important factor in stick welding. With the current set too low, difficulty can be experienced in striking and maintaining a stable arc. The electrode tends to stick to the work, penetration is poor and beads with a distinct rounded profile will be deposited. Too high current is accompanied by overheating of the electrode resulting in undercut and burning through of the base metal and producing excessive spatter. Normal current for a particular job may be considered as the maximum which can be used without burning through the work, over-heating the electrode or producing a rough spattered surface. The table shows current ranges generally recommended for a general purpose type E6013, E7018 and E6010 electrode.

**General rule of thumb for down hand welding is to have an arc length no greater than the diameter of the electrode.**

# SMAW (STICK) WELDING FUNDAMENTALS

## ARC LENGTH

To strike the arc, the electrode should be gently scraped on the work until the arc is established. There is a simple rule for the proper arc length; it should be the shortest arc that gives a good surface to the weld. An arc too long reduces penetration, produces spatter and gives a rough surface finish to the weld. An excessively short arc will cause sticking of the electrode and result in poor quality welds. General rule of thumb for down hand welding is to have an arc length no greater than the diameter of the electrode.

## ELECTRODE ANGLE

The angle that the electrode makes with the work is important to ensure a smooth, even transfer of metal. When welding in down hand, fillet, horizontal or overhead the angle of the electrode is generally between 5 and 15 degrees towards the direction of travel. When vertical up welding the angle of the electrode should be between 80 and 90 degrees to the work piece.

## TRAVEL SPEED

The electrode should be moved along in the direction of the joint being welded at a speed that will give the size of run required. At the same time, the electrode is fed downwards to keep the correct arc length at all times. Excessive travel speeds lead to poor fusion, lack of penetration, etc., while too slow a rate of travel will frequently lead to arc instability, slag inclusions and poor mechanical properties.

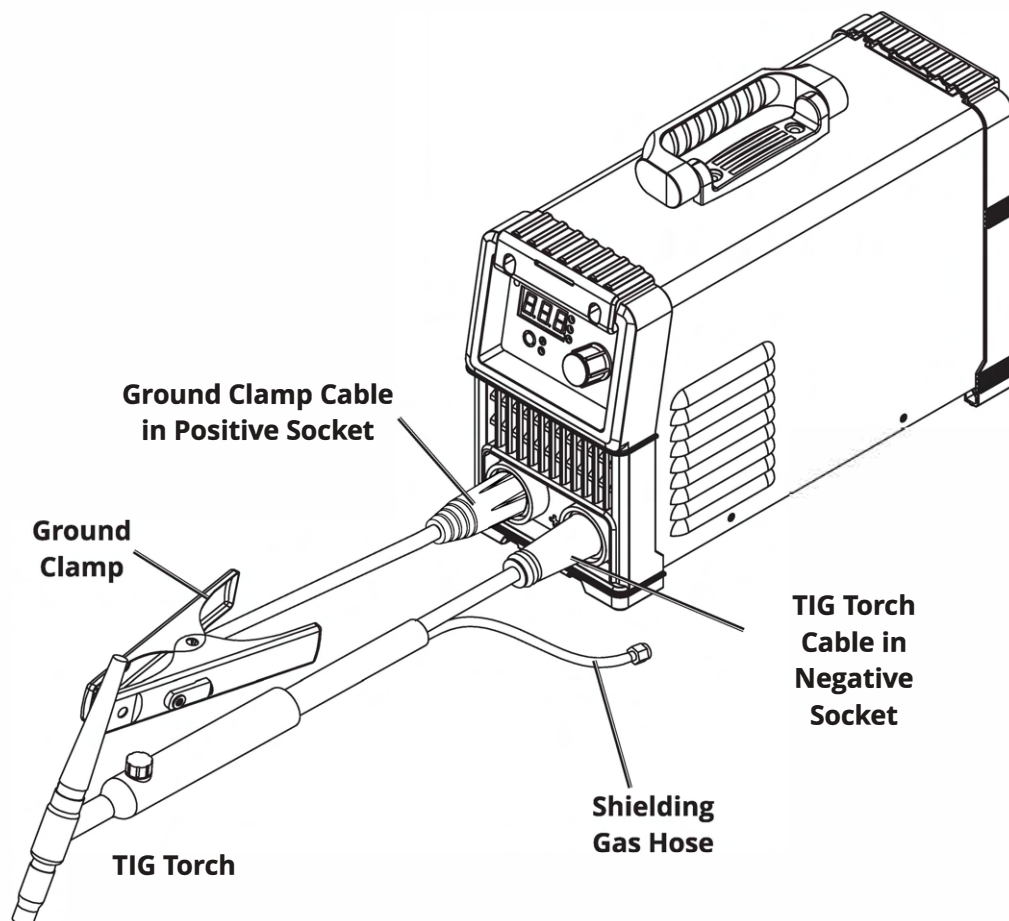
## MATERIAL AND JOINT PREPARATION

The material to be welded should be clean and free of any moisture, paint, oil, grease, mill scale, rust or any other material that will hinder the arc and contaminate the weld material. Joint preparation will depend on the method used, including sawing, punching, shearing, machining, flame cutting and others. In all cases edges should be clean and free of any contaminants. The type of joint will be determined by the chosen application.

**Excessive travel speeds lead to poor fusion, lack of penetration, etc., while too slow a rate of travel will frequently lead to arc instability, slag inclusions and poor mechanical properties.**

# LIFT TIG SETUP

## Connect cables

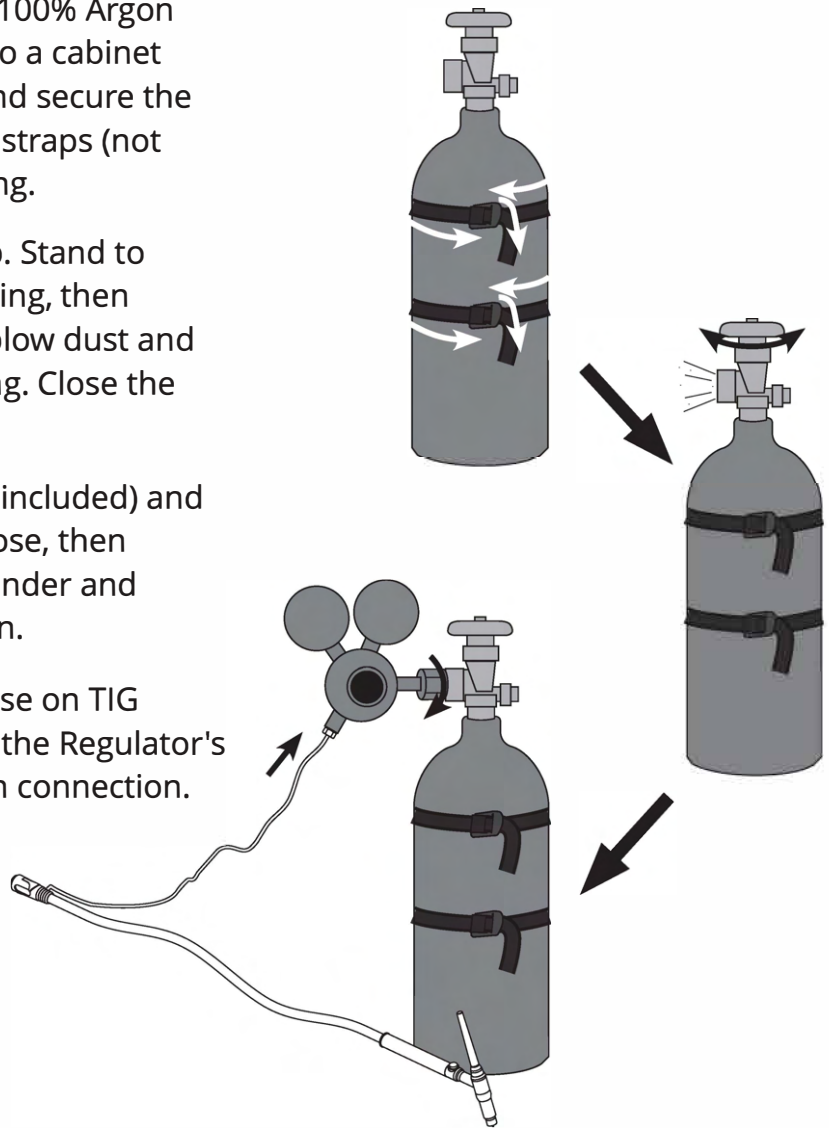


1. Plug Ground Clamp Cable into Positive Socket. Twist clockwise all the way to lock in place.
2. Plug TIG Torch Cable into Negative Socket. Twist clockwise all the way to lock in place.
3. For connecting Shielding Gas Hose, refer to Connect Shielding Gas section on next page.

# LIFT TIG SETUP

## Connect Shielding Gas

1. With assistance, place an 100% Argon cylinder(not included) onto a cabinet or cart near the Welder and secure the cylinder in place with two straps (not included) to prevent tipping.
2. Remove the cylinder's cap. Stand to the side of the valve opening, then open the valve briefly to blow dust and dirt from the valve opening. Close the cylinder valve.
3. Locate the Regulator (not included) and close its valve until it is loose, then thread Regulator onto cylinder and wrench-tighten connection.
4. Connect Shielding Gas Hose on TIG Torch Cable Connector to the Regulator's Outlet and wrench-tighten connection.

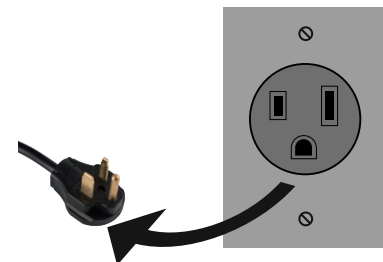


# LIFT TIG SETUP

## Connect Power Cord

1. Turn the Power Switch off before connecting Power Cord.
2. If using 120VAC, connect the included adapter to the end of the Power Cord. If using 240VAC, do not use the adapter.

**Note:** The circuit must be equipped with delayed action-type circuit breaker or fuses.



240V to 120V Plug Adapter



## Sharpen Tungsten Electrode

To avoid Electrode contamination, dedicate a fine grit grinding wheel exclusively to Electrode grinding.

**WARNING!** Some Electrodes may contain materials that are hazardous to breathe. Wear a respirator and ANSI-approved safety goggles when grinding an Electrode.

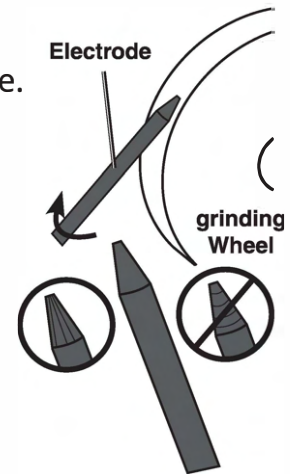
1. Shut off the welder and wait until Electrode and Torch have cooled enough to handle.
2. Remove Back Cap to release Collet's grip on Electrode.
3. Pull Electrode out from front of Torch. (Pulling it from rear will damage Collet and create burrs on Electrode).
4. If Electrode has dulled or been otherwise contaminated, use pliers or a suitable tool to grip the Electrode above the contaminated section and snap off the end of the Electrode.

# LIFT TIG SETUP

5. Lightly press Electrode tip against the surface of the grinding wheel at an angle. Rotate Electrode tip until a blunt point is formed.

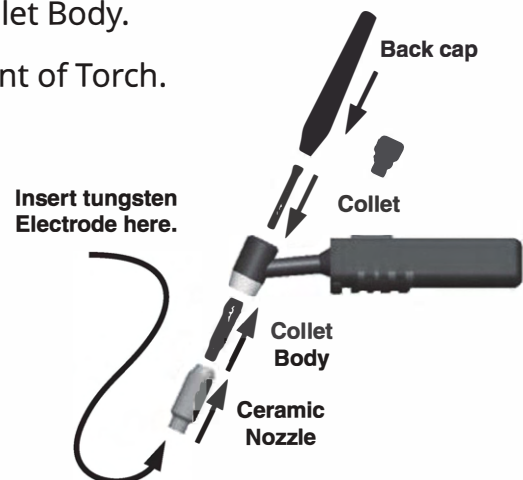
**Note:** Grinding direction must be parallel to length of Electrode.

6. The conical portion of the ideal tip will be 2-1/2 times as long as the Electrode diameter.
7. Re-insert Electrode into Collet with tip protruding 1/8"-1/4" beyond the Ceramic Nozzle, then re-tighten the Back Cap to secure the Electrode in place.



## Connect Power Cord

1. Thread Collet Body into the front of the Torch.
2. Make sure Ceramic Nozzle size is appropriate for application.
3. Thread Ceramic Nozzle onto Collet Body.
4. Insert Collet into back of Torch and into Collet Body.
5. Insert Tungsten Electrode into Collet on front of Torch.
6. Lock Electrode in place with Back Cap. Electrode should protrude 1/8" to 1/4" beyond the Ceramic Nozzle.









# TUNGSTEN ELECTRODES

Tungsten is a rare metallic element used for manufacturing TIG welding electrodes. The TIG process relies on tungsten's hardness and high temperature resistance to carry the welding current to the arc. Tungsten has the highest melting point of any metal at 6,192° F (3,422°C).

Tungsten electrodes are nonconsumable and come in a variety of sizes, they are made from pure tungsten or an alloy of tungsten and other rare earth elements. Choosing the correct tungsten depends on the material being welded, the amount of amps required.

Tungsten electrodes are color-coded at the end for easy identification.

Below are the most commonly-used tungsten electrodes.

TUNGSTEN ELECTRODE CHARACTERISTICS		
Tungsten	Color Code	Characteristics
Pure	 Green	Provides good arc stability for AC welding. Reasonably good resistance to contamination. Lowest current carrying capacity. Least expensive. Maintains a balled end. Used on transformer based machines only.
2% Ceriated	 Gray	Similar performance to thoriated tungsten. Easy arc starting, good arc stability, long life. Possible replacement for thoriated.
2% Thoriated	 Red	Easier arc starting. Higher current capacity. Greater arc stability. High resistance to weld pool contamination. Difficult to maintain balled end on AC.
1.5% Lanthanated	 Gold	Similar performance to thoriated tungsten. Easy arc starting, good arc stability, long life, high current capacity. 1.5% possible replacement for thoriated. 2% possible replacement for Pure.
2% Lanthanated	 Blue	Similar performance to thoriated tungsten. Easy arc starting, good arc stability, long life, high current capacity. 1.5% possible replacement for thoriated. 2% possible replacement for Pure.
.8% Zirconiated	 White	Excellent for AC welding due to favorable retention of balled end, high resistance to contamination, and good arc starting. Preferred when tungsten contamination of weld is intolerable. Possible replacement for Pure.

*\*Substitute for Purple (Same oxide blend).*

# TUNGSTEN ELECTRODES

TUNGSTEN ELECTRODE CURRENT RANGES						
Tungsten Diameter in inches (mm)	Gas Cup (Inside Diameter)	TYPICAL CURRENT RANGE				
		Direct Current, DC		Alternating Current, AC		
		DCEN	70% Penetration		(50/50) Balanced Wave, AC	
		Ceriated	Zirconiated	Ceriated	Zirconiated	Ceriated
		Thoriated		Thoriated	Pure	Thoriated
		Lanthanated		Lanthanated		Lanthanated
.040" (1.0mm)	#6 (3/8")	15–80 amps	20–60 amps	15–80 amps	10–30 amps	20–60 amps
1/16" (1.6mm)	#6 (3/8")	70–150 amps	50–100 amps	70–150 amps	30–80 amps	60–120 amps
3/32" (2.3mm)	#8 (1/2")	150–250 amps	100–160 amps	140–235 amps	60–130 amps	100–180 amps
1/8" (3.2mm)	#8 (1/2")	250–400 amps	150–200 amps	225–325 amps	100–180 amps	160–250 amps

All values are based on the use of Argon as a shielding gas. Other current values may be employed depending on the shielding gas, type of equipment, and application.  
 DCEN = Direct Current Electrode Negative (Straight Polarity)

# TUNGSTEN PREPARATION

Always use diamond wheels when grinding and cutting tungsten. While tungsten is a very hard material, the surface of a diamond wheel is harder, and this makes for smooth grinding. Grinding without diamond wheels, such as aluminum oxide wheels, can lead to jagged edges, imperfections, or poor surface finishes not visible to the eye that will contribute to weld inconsistency and weld defects.

Always grind the tungsten in a longitudinal direction on the grinding wheel. Tungsten electrodes are manufactured with the molecular structure of the grain running lengthwise and thus grinding crosswise is "grinding against the grain." If electrodes are ground crosswise, the electrons have to jump across the grinding marks and the arc can start before the tip and wander. Grinding longitudinally with the grain, the electrons flow steadily and easily to the end of the tungsten tip. The arc starts straight and remains narrow, concentrated, and stable.

### TUNGSTEN GRINDING

- Grind longitudinally (never radially)
- Truncate (blunt) end
- Diameter of flat spot determines amperage capacity

The included angle determines weld bead shape and size. Generally, as the included angle increases, penetration increases and bead width decreases.

### TUNGSTEN TIP PREPARATION

#### DC TIG WELDING

Flat: 1/4 TO 1/2 X Diameter

Taper Length: 2 - 3 X Diameter

### TUNGSTEN EXTENSION

#### STANDARD PARTS

General Purpose 3 X Diameter

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#### GAS LENS PARTS

General Purpose 3 X Diameter

MAX: 6 X Diameter (In draft-free areas)

# TUNGSTEN PREPARATION

<b>TUNGSTEN ELECTRODE TIP SHAPES AND CURRENT RANGES</b>					
<b>ELECTRODE DIAMETER</b>		<b>DIAMETER AT TIP</b>		<b>INCLUDED ANGLE</b>	<b>CURRENT RANGE</b>
Millimeters	Inches	Millimeters	Inches		
1.0mm	.040"	.125mm	.005"	12°	2–15 amps
1.0mm	.040"	.250mm	.010"	20°	5–30 amps
1.6mm	1/16"	.500mm	.020"	25°	8–50 amps
1.6mm	1/16"	.800mm	.030"	30°	10–70 amps
2.4mm	3/32"	.800mm	.030"	35°	12–90 amps
2.4mm	3/32"	1.100mm	.045"	45°	15–150 amps
3.2mm	1/8"	1.100mm	.045"	60°	20–200 amps
3.2mm	1/8"	1.500mm	.060"	90°	25–250 amps

# SMAW (STICK) WELDING TROUBLESHOOTING

The following chart addresses some of the common problems of SMAW (Stick) welding. In all cases of equipment malfunction, the manufacturer's recommendations should be strictly adhered to and followed.

<b>1: No arc</b>	
<b>POSSIBLE REASON</b>	<b>SUGGESTED REMEDY</b>
Incomplete welding circuit	Confirm that the ground clamp is connected. Check all cable connections.
Wrong mode selected	Check the STICK selector switch is selected.
No power supply	Check that the machine is switched on and has a power supply.
<b>2: Porosity – small cavities or holes resulting from gas pockets in weld metal.</b>	
<b>POSSIBLE REASON</b>	<b>SUGGESTED REMEDY</b>
Arc length too long	Shorten the arc length.
Work piece dirty, contaminated or moisture	Remove moisture and materials like paint, grease, oil, and dirt, including mill scale from base metal.
Damp electrodes	Use only dry electrodes.
<b>3: Excessive Spatter</b>	
<b>POSSIBLE REASON</b>	<b>SUGGESTED REMEDY</b>
Amperage too high	Decrease the amperage or choose a larger electrode.
Arc length too long	Shorten the arc length.
<b>4: Weld sits on top, lack of fusion</b>	
<b>POSSIBLE REASON</b>	<b>SUGGESTED REMEDY</b>
Insufficient heat input	Increase the amperage.
Work piece dirty, contaminated or moisture	Remove moisture and materials like paint, grease, oil, and dirt, including mill scale from base metal.
Poor welding technique	Use the correct welding technique or seek assistance for the correct technique.
<b>5: Lack of penetration</b>	
<b>POSSIBLE REASON</b>	<b>SUGGESTED REMEDY</b>
Insufficient heat input	Increase the amperage.
Poor welding technique	Use the correct welding technique or seek assistance for the correct technique.
Poor joint preparation	Check the joint design and fit up, make sure the material is not too thick. Seek assistance for the correct joint design and fit up.
<b>6: Excessive penetration–burn through</b>	
<b>POSSIBLE REASON</b>	<b>SUGGESTED REMEDY</b>
Excessive heat input	Reduce the amperage.
Incorrect travel speed	Try increasing the weld travel speed.
<b>7: Uneven weld appearance</b>	
<b>POSSIBLE REASON</b>	<b>SUGGESTED REMEDY</b>
Unsteady hand, wavering hand	Use two hands where possible to steady up, practice your technique.
<b>8: Distortion – movement of base metal during welding</b>	
<b>POSSIBLE REASON</b>	<b>SUGGESTED REMEDY</b>
Excessive heat input	Reduce the amperage.
Poor welding technique	Use the correct welding technique or seek assistance for the correct technique.
Poor joint preparation and or joint design	Check the joint design and fit up, make sure the material is not too thick. Seek assistance for the correct joint design and fit up.
<b>9: Electrode welds with different or unusual arc characteristic</b>	
<b>POSSIBLE REASON</b>	<b>SUGGESTED REMEDY</b>
Incorrect polarity	Change the polarity, check the electrode manufacturer for correct polarity.

# GTAW (TIG) WELDING TROUBLESHOOTING

The following chart addresses some of the common problems of TIG welding. In all cases of equipment malfunction, the manufacturer's recommendations should be strictly adhered to and followed.

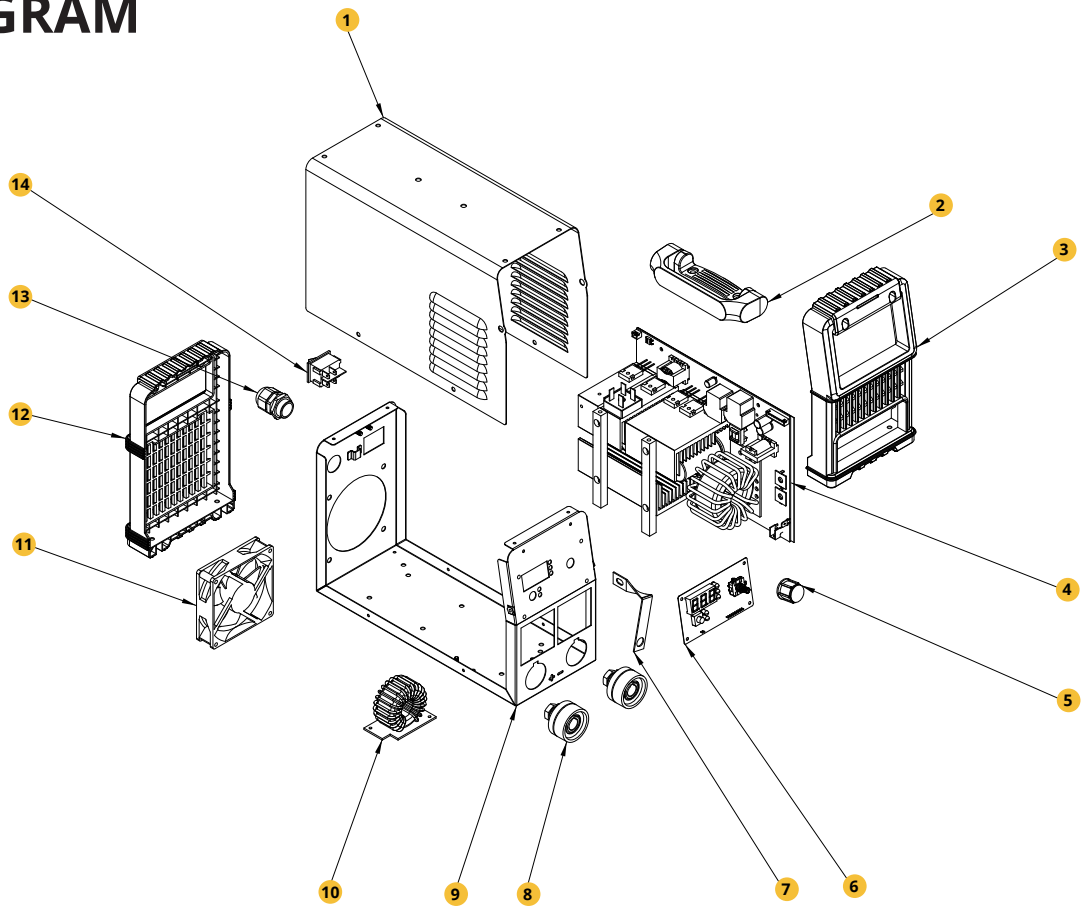
<b>1: Tungsten burning away quickly</b>	
<b>POSSIBLE REASON</b>	<b>SUGGESTED REMEDY</b>
Incorrect Gas	Check that pure Argon is being used.
No gas	Check the gas cylinder contains gas and is connected.
Inadequate gas flow	Check the gas is connected, check hoses, gas valve and torch are not restricted. Set the gas flow between 15–25 CFH (7–12 LMN) flow rate.
Back cap not fitted correctly	Make sure the torch back cap is fitted so that the o-ring is inside the torch body.
Torch connected to DC +	Connect the torch to the DC- output terminal.
Incorrect tungsten being used	Check and change the tungsten type if necessary.
<b>2: Contaminated tungsten</b>	
<b>POSSIBLE REASON</b>	<b>SUGGESTED REMEDY</b>
Touching tungsten into the weld pool	Keep tungsten from contacting weld puddle. Raise the torch so that the tungsten is off of the work piece 1/8"-1/4" (3.2–6.35mm).
Touching the filler wire to the tungsten	Keep the filler wire from touching the tungsten during welding, feed the filler wire into the leading edge of the weld pool in front of the tungsten.
Tungsten melting into the weld pool	Check that correct type of tungsten is being used. Too much current for the tungsten size so reduce the amps or change to a larger tungsten.
<b>3: Porosity — poor weld appearance and color</b>	
<b>POSSIBLE REASON</b>	<b>SUGGESTED REMEDY</b>
Incorrect Gas	Check that pure Argon is being used.
Inadequate gas flow / gas leaks	Check the gas is connected, check hoses, gas valve and torch are not restricted. Set the gas flow between 15–25 CFH (7–12 LMN) flow rate. Check hoses and fittings for holes, leaks, etc.
Moisture on the base metal	Remove all moisture from base metal before welding.
Contaminated base metal	Remove materials like paint, grease, oil, and dirt, including mill scale from base metal.
Contaminated filler wire	Remove all grease, oil, or moisture from filler metal.
Incorrect filler wire	Check the filler wire and change if necessary.
<b>4: Yellowish residue / smoke on the alumina nozzle &amp; discolored tungsten</b>	
<b>POSSIBLE REASON</b>	<b>SUGGESTED REMEDY</b>
Incorrect Gas	Use pure Argon gas.
Inadequate gas flow	Set the gas flow between 15–25 CFH (7–12 LMN) flow rate.
Inadequate post flow gas	Increase the post flow gas time.
Alumina gas nozzle too small for size of tungsten being used	Increase the size of the alumina gas nozzle.
<b>5: Unstable arc during DC welding</b>	
<b>POSSIBLE REASON</b>	<b>SUGGESTED REMEDY</b>
Torch connected to DC +	Connect the torch to the DC - output terminal.
Contaminated base metal	Remove materials like paint, grease, oil, and dirt, including mill scale from base metal.
Tungsten is contaminated	Remove 3/8" (10mm) of contaminated tungsten and re-grind the tungsten.
Arc length too long	Lower torch so that the tungsten is off of the work piece 1/8"-1/4" (3.2–6.35mm).
<b>8: Arc wanders during DC welding</b>	
<b>POSSIBLE REASON</b>	<b>SUGGESTED REMEDY</b>
Poor gas flow	Check and set the gas flow between 15–25 CFH (7–12 LMN) flow rate.
Incorrect arc length	Lower torch so that the tungsten is off of the work piece 1/8"-1/4" (3.2–6.35mm).
Tungsten incorrect or in poor condition	Check that correct type of tungsten is being used. Remove 3/8" (10mm) from the weld end of the tungsten and re-sharpen the tungsten.
Poorly prepared tungsten	Grind marks should run lengthwise with tungsten, not circular. Use proper grinding method and wheel.
Contaminated base metal	Remove contaminating materials like paint, grease, oil, and dirt, including mill scale from base metal.
Contaminated filler wire	Remove all grease, oil, or moisture from filler metal.
Incorrect filler wire	Check the filler wire and change if necessary.

# GTAW (TIG) WELDING TROUBLESHOOTING

<b>10: Arc difficult to start or will not start DC welding</b>	
<b>POSSIBLE REASON</b>	<b>SUGGESTED REMEDY</b>
Incorrect machine set up	Check machine set up is correct.
No gas, incorrect gas flow	Check the gas is connected and cylinder valve open, check hoses, gas valve and torch are not restricted. Set the gas flow between 15–25 CFH (7–12 LMN) flow rate.
Tungsten is contaminated	Remove 3/8" (10mm) of contaminated tungsten and re-grind the tungsten.
Incorrect tungsten size and or tungsten being used	Check and change the size and or the tungsten if required.
Loose connection	Check all connectors and tighten.
Ground clamp not connected to work	Connect the ground clamp directly to the work piece wherever possible.
Loss of high frequency	Check torch and cables for cracked insulation or bad connections.

# PARTS LIST AND DIAGRAM

## DIAGRAM



part	Description	Qty
1	Machine Cover	1
2	Handle	1
3	Front Plastic Cover	1
4	Inverter Module	1
5	Knob	1
6	Digital Panel	1
7	Copper Connections	1

part	Description	Qty
8	Quick Connector	2
9	Baseboard	1
10	Reactor	1
11	Fan	1
12	Back Plastic Cover	1
13	Cable Fixtures	1
14	Rocker Switch	1

