WARNING: To prevent serious injury, read manual warnings and instructions before use.

1. Assemble face shield handle and cover handle.

2. Install FLUX-CORE wire spool. Insert wire through both wire liners and clamp it into feed mechanism. See manual if changing wire size.

3. Take off nozzle and tip, plug in welder, turn it on, and squeeze trigger until wire comes out.

4. Incrementally tighten wire feed tension knob clockwise until wire will bend from feed tension at 2”-3”.

5. Unplug welder and replace nozzle and tip. Adjust wire feed speed and MAX/MIN settings according to chart.

6. Hold gun clear of workpiece, then plug in welder and turn it on.

Basic welding instructions and welding tips are in the manual.
**Good Weld**

**Current Too Low**

**TO CORRECT:**

**Current Too High or Wire Feed Too Fast**

**TO CORRECT:**

**Weld Speed Too Fast**

**TO CORRECT:**

**Weld Speed Too Slow**

**TO CORRECT:**

**Stickout Too Long**

**TO CORRECT:**

*CLEAN WELDS FIRST!*

Flux-core welds will have a coat of slag over them until cleaned.

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68887 WELD EXAMPLE PICTURES

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