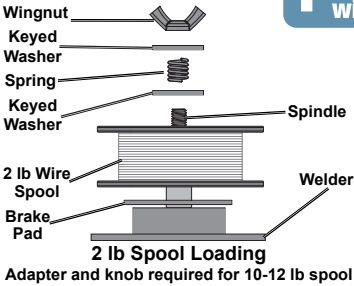
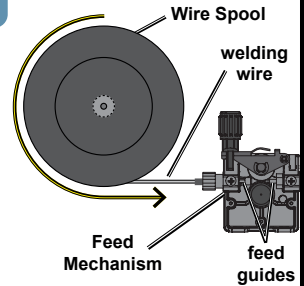


**⚠ WARNING** To prevent serious injury, read manual warnings and instructions before use.

**1** Connect cables as needed for flux wire welding - see back of guide.



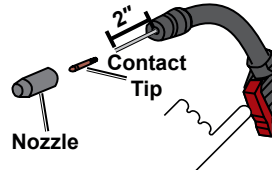
**2** Install wire spool. Insert wire through both feed guides and clamp it into feed mechanism. See manual if changing wire size or using solid wire.



**⚠ WARNING**

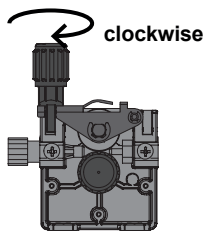
To prevent serious injury, read manual warnings and instructions before use.

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

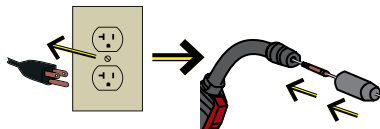
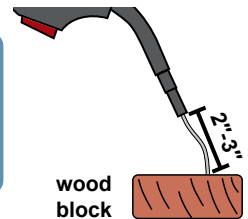


**⚠ WARNING**

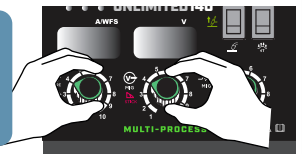
To prevent fire and serious injury, keep torch and wire clear of grounded objects while welder plugged in.



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

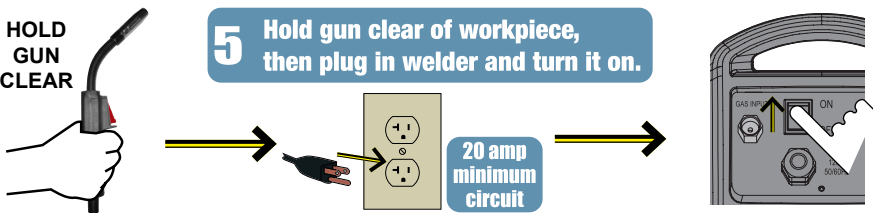


**4** Unplug welder and replace nozzle and tip. Adjust welder settings according to chart.



HOLD GUN CLEAR

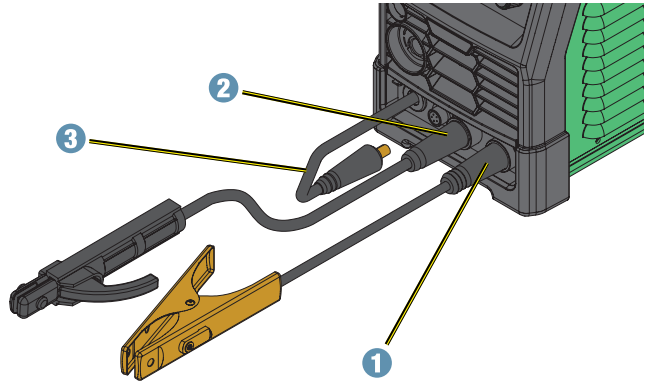
**5** Hold gun clear of workpiece, then plug in welder and turn it on.



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

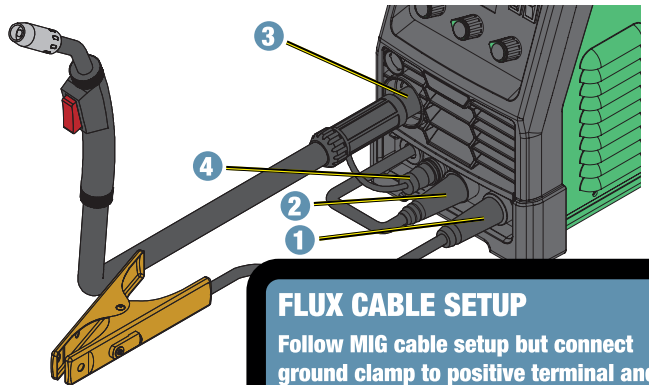
## STICK CABLE SETUP

1. Connect ground clamp to negative terminal.
2. Connect electrode holder to positive terminal.
3. Leave wire feed power disconnected.



## MIG CABLE SETUP

1. Connect ground clamp to negative terminal.
2. Connect wire feed power to positive terminal.
3. Connect MIG gun to wire feed.
4. Connect wire feed control.



## FLUX CABLE SETUP

Follow MIG cable setup but connect ground clamp to positive terminal and wire feed power to negative terminal.

## TIG CABLE SETUP

1. Connect ground clamp to positive terminal.
2. Connect TIG torch to negative terminal.
3. Connect gas line to gas regulator.
4. Leave wire feed power disconnected.

