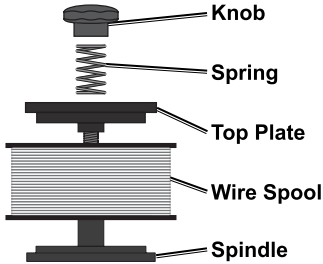
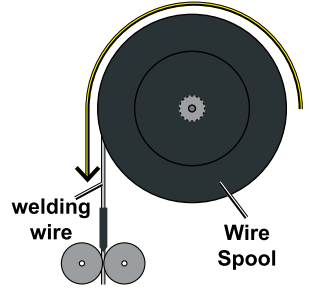


⚠ WARNING To prevent serious injury, read manual warnings and instructions before use.

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.

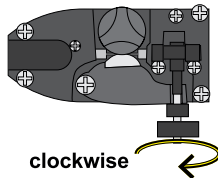
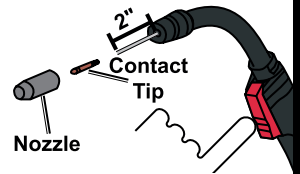


⚠ WARNING

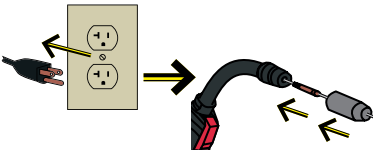
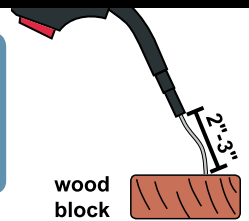
To prevent fire and serious injury:

Keep torch and wire clear of grounded objects while welder plugged in.

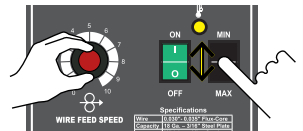
3 Take off nozzle and tip, plug in welder, turn it on, and squeeze trigger until wire comes out.



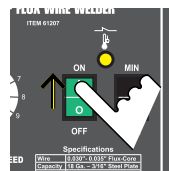
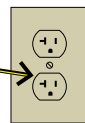
4 Incrementally tighten wire feed tension knob clockwise until wire will bend from feed tension at 2"-3".



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.



CLEAN WELDS FIRST!

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

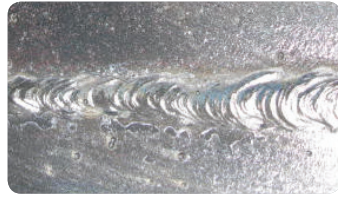
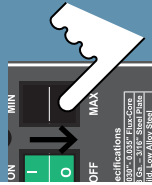


Good Weld



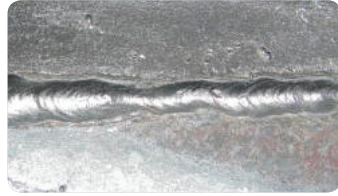
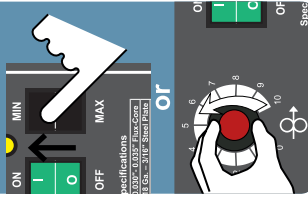
Current Too Low

TO CORRECT:



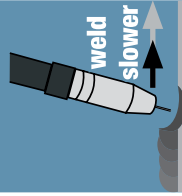
Current Too High or Wire Feed Too Fast

TO CORRECT:



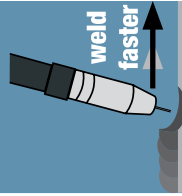
Weld Speed Too Fast

TO CORRECT:



Weld Speed Too Slow

TO CORRECT:



Stickout Too Long

TO CORRECT:

