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 MANUAL.
Good Weld

ON

MIN

OFF

MAX

WIRE FEED SPEED

GUN

GROUND

120V~

60Hz

20A

90 AMP FLUX WIRE WELDER

ITEM 6

1207

Specifications

Wire

0.030″-

0.035″ Flux-Core

Capacity

18 Ga. – 3/16″ Steel Plate

Weldable Material

Mild, Low Alloy Steel

(Not for Aluminum or Stainless Steel)

Weld Speed

Too Fast

TO CORRECT:

Weld slower

Too Slow

TO CORRECT:

Weld faster

Stickout

Too Long

TO CORRECT:

Stickout less than 1/2"

Current

Too High or Too Fast

Wire Feed Too Fast

TO CORRECT:

Weld slower

Current Too Low

TO CORRECT:

Current faster

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

63582 WELD EXAMPLE PICTURES