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.

WARNING
To prevent fire and serious injury:
Keep torch and wire clear of grounded objects while welder plugged in.

Specifications
- Wire: 0.030”-0.035” Flux-Core
- Capacity: 18 Ga. – 3/16” Steel Plate
- Weldable Materials: Mild, Low Alloy Steel (Not for Aluminum or Stainless Steel)

BASIC WELDING INSTRUCTIONS AND WELDING TIPS ARE IN 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:

63583 WELD EXAMPLE PICTURES

CLEAN WELDS FIRST!
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