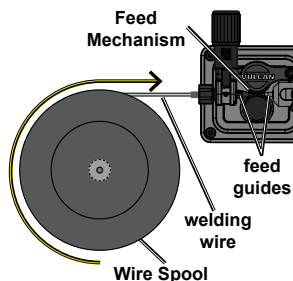


2 lb Spool Loading

Adapter and knob required for 10-12 lb spool

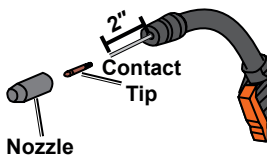
1

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.



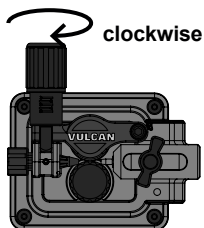
2

Take off nozzle and tip, plug selected cord into welder and into wall, turn welder on, and press cold wire feed switch until wire comes out.



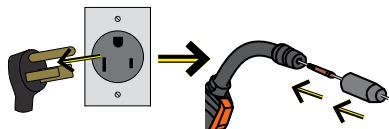
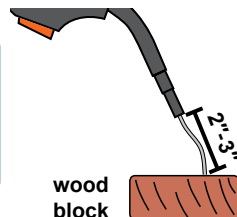
## ⚠ WARNING

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.

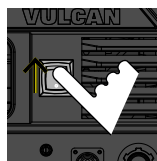
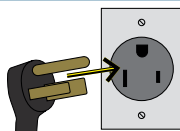


HOLD  
GUN  
CLEAR



5

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



#### CLEAN FLUX-CORE WELDS FIRST!

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

170

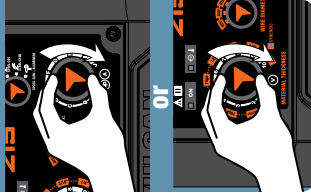


**Good  
Weld**



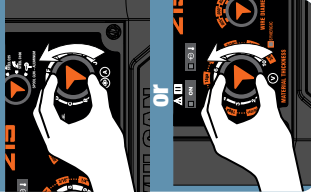
**Current  
or Voltage  
Too Low**

**To Correct:**



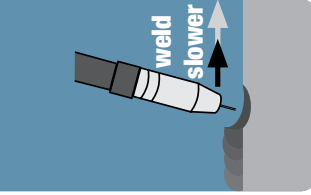
**Current  
or Voltage  
Too High**

**TO CORRECT:**



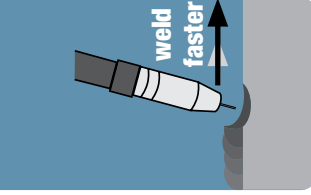
**Weld Speed  
Too Fast**

**TO CORRECT:**



**Weld Speed  
Too Slow**

**TO CORRECT:**



**CTWD  
Too Long or  
Wrong  
Polarity**

**TO CORRECT:**

**Check Polarity  
and**

