Weldclass FURY 165 MPST

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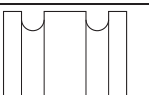
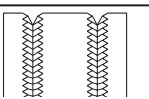
Setting Up Your Welder

Process	Gas	Drive Roller	Connection Polarity
MIG - Solid Steel	Argon + CO2	V-groove 	
MIG - Stainless Steel	Argon + 02/CO2		
MIG - Aluminium	Argon	U-groove 	
MIG - Gasless	N/A	Knurled 	
TIG - Steel/Stainless	Argon	N/A	
Stick (MMA)	N/A	N/A	

Synergic MIG Settings Guide (Amps)

Thickness	Steel	Stainless	Aluminum
1.2mm	40 - 50	40 - 45	35 - 40
1.6mm	**60 - 70**	**55 - 65**	**45 - 55**
2.0mm	70 - 80	65 - 75	60 - 70
2.5mm	85 - 95	75 - 80	70 - 80
3.0mm	**100 - 110**	**85 - 90**	**80 - 85**
3.2mm	105 - 115	90 - 95	85 - 90
4.0mm	115 - 125	100 - 110	95 - 100
5.0mm	130 - 140	115 - 120	105 - 110
6.0mm	145 - 155	125 - 130	115 - 125
6.5mm	**155 - 165**	**135 - 140**	**125 - 135**
7.0mm	* NB	145 - 155	140 - 150
8.0mm	*** NB**	**155 - 165**	**150 - 160**

Other Settings

Process Selection

1. Press the mode button to scroll through the modes.
2. To change between MIG Synergic and Manual press the Left Hand Control (V).
3. Pulse MIG Steel and Aluminium Modes are Synergic, you can adjust/fine tune the Voltage (0 to -3, 0 to +3).

Wire Size Selection

1. Press the Right Hand Control (A) to scroll through the wire sizes.

Pulse Settings (TIG & MMA)

1. Press the Right Hand Control knob (A) then the Orange bar flashes
2. Use the Right Hand Control (A) to adjust the pulse speed, 1hz – 10hz

The weld settings listed are suggestions only with approximate values and may vary depending on the joint type, welding position, wire size, shielding gas, travel speed, MIG Wire stick out, and YOU the operator. Final settings should be trialled on scrap metal to achieve best results. ***NB it is possible to weld 8mm Steel with this machine,** if you use the machine in **Manual Mode** and wind both the Voltage and Wire Feed Speed to the maximum settings.