



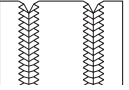







## Setting Up Your Welder

Process	Gas	Drive Roller	Connection Polarity
MIG - Solid Steel	Argon + CO2	V-groove 	
MIG - Stainless Steel	Argon + O2/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	165 - 175	145 - 155	140 - 150
8.0mm	175 - 185	155 - 165	150 - 160
10.0mm	*NB	165 - 175	160 - 170

## Other Settings

Process Selection	Wire Size Selection	Pulse Settings (TIG & MMA)
<ol style="list-style-type: none"> <li>Press the mode button to scroll through the modes.</li> <li>To change between MIG Synergic and Manual press the Left Hand Control (V).</li> <li>Pulse MIG Steel and Aluminium Modes are Synergic, you can adjust/fine tune the Voltage (0 to -3, 0 to +3).</li> </ol>	<ol style="list-style-type: none"> <li>Press the Right Hand Control (A) to scroll through the wire sizes.</li> </ol>	<ol style="list-style-type: none"> <li>Press the Right Hand Control knob (A) then the Orange bar flashes</li> <li>Use the Right Hand Control (A) to adjust the pulse speed, 1hz - 10hz</li> </ol> 

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 10mm 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.**