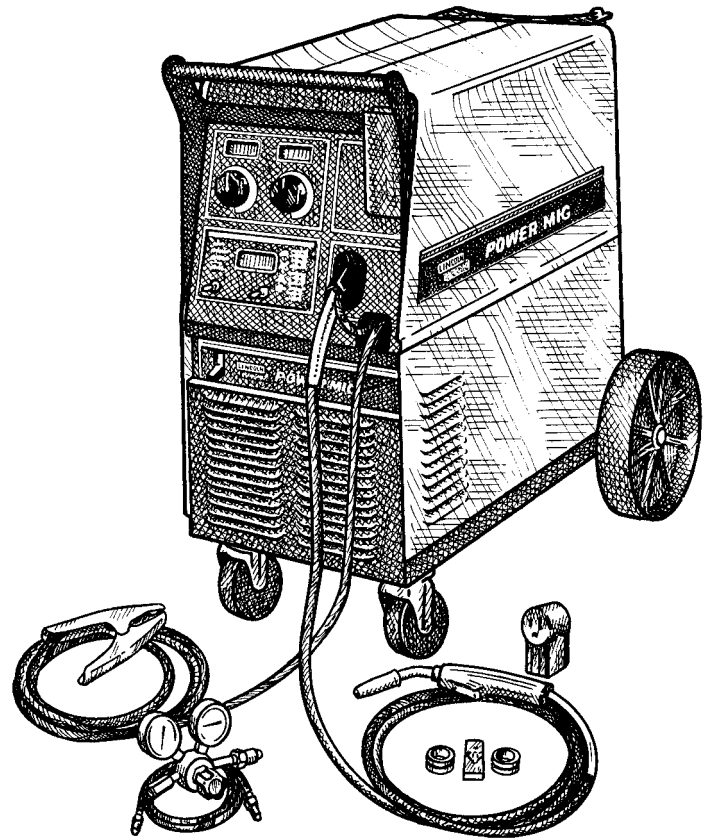


# POWER MIG™ 350MP

For use with machine Code Number: 11147, 11309

## Safety Depends on You

Lincoln arc welding and cutting equipment is designed and built with safety in mind. However, your overall safety can be increased by proper installation ... and thoughtful operation on your part. **DO NOT INSTALL, OPERATE OR REPAIR THIS EQUIPMENT WITHOUT READING THIS MANUAL AND THE SAFETY PRECAUTIONS CONTAINED THROUGHOUT.** And, most importantly, think before you act and be careful.



## SERVICE MANUAL



**LINCOLN**<sup>®</sup>  
**ELECTRIC**

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- World's Leader in Welding and Cutting Products •
- Sales and Service through Subsidiaries and Distributors Worldwide •

Cleveland, Ohio 44117-1199 U.S.A. TEL: 216.481.8100 FAX: 216.486.1751 WEB SITE: [www.lincolnelectric.com](http://www.lincolnelectric.com)Download from [Www.Somanuals.com](http://Www.Somanuals.com). All Manuals Search And Download.

**! WARNING****CALIFORNIA PROPOSITION 65 WARNINGS**

Diesel engine exhaust and some of its constituents are known to the State of California to cause cancer, birth defects, and other reproductive harm.

The Above For Diesel Engines

The engine exhaust from this product contains chemicals known to the State of California to cause cancer, birth defects, or other reproductive harm.

The Above For Gasoline Engines

**ARC WELDING CAN BE HAZARDOUS. PROTECT YOURSELF AND OTHERS FROM POSSIBLE SERIOUS INJURY OR DEATH. KEEP CHILDREN AWAY. PACEMAKER WEARERS SHOULD CONSULT WITH THEIR DOCTOR BEFORE OPERATING.**

Read and understand the following safety highlights. For additional safety information, it is strongly recommended that you purchase a copy of "Safety in Welding & Cutting - ANSI Standard Z49.1" from the American Welding Society, P.O. Box 351040, Miami, Florida 33135 or CSA Standard W117.2-1974. A Free copy of "Arc Welding Safety" booklet E205 is available from the Lincoln Electric Company, 22801 St. Clair Avenue, Cleveland, Ohio 44117-1199.

**BE SURE THAT ALL INSTALLATION, OPERATION, MAINTENANCE AND REPAIR PROCEDURES ARE PERFORMED ONLY BY QUALIFIED INDIVIDUALS.**

**FOR ENGINE powered equipment.**

1.a. Turn the engine off before troubleshooting and maintenance work unless the maintenance work requires it to be running.



1.b. Operate engines in open, well-ventilated areas or vent the engine exhaust fumes outdoors.



1.c. Do not add the fuel near an open flame welding arc or when the engine is running. Stop the engine and allow it to cool before refueling to prevent spilled fuel from vaporizing on contact with hot engine parts and igniting. Do not spill fuel when filling tank. If fuel is spilled, wipe it up and do not start engine until fumes have been eliminated.

1.d. Keep all equipment safety guards, covers and devices in position and in good repair. Keep hands, hair, clothing and tools away from V-belts, gears, fans and all other moving parts when starting, operating or repairing equipment.

1.e. In some cases it may be necessary to remove safety guards to perform required maintenance. Remove guards only when necessary and replace them when the maintenance requiring their removal is complete. Always use the greatest care when working near moving parts.



1.f. Do not put your hands near the engine fan. Do not attempt to override the governor or idler by pushing on the throttle control rods while the engine is running.

1.g. To prevent accidentally starting gasoline engines while turning the engine or welding generator during maintenance work, disconnect the spark plug wires, distributor cap or magneto wire as appropriate.



1.h. To avoid scalding, do not remove the radiator pressure cap when the engine is hot.

**ELECTRIC AND MAGNETIC FIELDS may be dangerous**

2.a. Electric current flowing through any conductor causes localized Electric and Magnetic Fields (EMF). Welding current creates EMF fields around welding cables and welding machines

2.b. EMF fields may interfere with some pacemakers, and welders having a pacemaker should consult their physician before welding.

2.c. Exposure to EMF fields in welding may have other health effects which are now not known.

2.d. All welders should use the following procedures in order to minimize exposure to EMF fields from the welding circuit:

2.d.1. Route the electrode and work cables together - Secure them with tape when possible.

2.d.2. Never coil the electrode lead around your body.

2.d.3. Do not place your body between the electrode and work cables. If the electrode cable is on your right side, the work cable should also be on your right side.

2.d.4. Connect the work cable to the workpiece as close as possible to the area being welded.

2.d.5. Do not work next to welding power source.



## ELECTRIC SHOCK can kill.

- 3.a. The electrode and work (or ground) circuits are electrically "hot" when the welder is on. Do not touch these "hot" parts with your bare skin or wet clothing. Wear dry, hole-free gloves to insulate hands.
- 3.b. Insulate yourself from work and ground using dry insulation. Make certain the insulation is large enough to cover your full area of physical contact with work and ground.
- In addition to the normal safety precautions, if welding must be performed under electrically hazardous conditions (in damp locations or while wearing wet clothing; on metal structures such as floors, gratings or scaffolds; when in cramped positions such as sitting, kneeling or lying, if there is a high risk of unavoidable or accidental contact with the workpiece or ground) use the following equipment:**
- Semiautomatic DC Constant Voltage (Wire) Welder.
  - DC Manual (Stick) Welder.
  - AC Welder with Reduced Voltage Control.
- 3.c. In semiautomatic or automatic wire welding, the electrode, electrode reel, welding head, nozzle or semiautomatic welding gun are also electrically "hot".
- 3.d. Always be sure the work cable makes a good electrical connection with the metal being welded. The connection should be as close as possible to the area being welded.
- 3.e. Ground the work or metal to be welded to a good electrical (earth) ground.
- 3.f. Maintain the electrode holder, work clamp, welding cable and welding machine in good, safe operating condition. Replace damaged insulation.
- 3.g. Never dip the electrode in water for cooling.
- 3.h. Never simultaneously touch electrically "hot" parts of electrode holders connected to two welders because voltage between the two can be the total of the open circuit voltage of both welders.
- 3.i. When working above floor level, use a safety belt to protect yourself from a fall should you get a shock.
- 3.j. Also see Items 6.c. and 8.



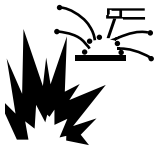
## ARC RAYS can burn.

- 4.a. Use a shield with the proper filter and cover plates to protect your eyes from sparks and the rays of the arc when welding or observing open arc welding. Headshield and filter lens should conform to ANSI Z87. 1 standards.
- 4.b. Use suitable clothing made from durable flame-resistant material to protect your skin and that of your helpers from the arc rays.
- 4.c. Protect other nearby personnel with suitable, non-flammable screening and/or warn them not to watch the arc nor expose themselves to the arc rays or to hot spatter or metal.



## FUMES AND GASES can be dangerous.

- 5.a. Welding may produce fumes and gases hazardous to health. Avoid breathing these fumes and gases. When welding, keep your head out of the fume. Use enough ventilation and/or exhaust at the arc to keep fumes and gases away from the breathing zone. **When welding with electrodes which require special ventilation such as stainless or hard facing (see instructions on container or MSDS) or on lead or cadmium plated steel and other metals or coatings which produce highly toxic fumes, keep exposure as low as possible and below Threshold Limit Values (TLV) using local exhaust or mechanical ventilation. In confined spaces or in some circumstances, outdoors, a respirator may be required. Additional precautions are also required when welding on galvanized steel.**
- 5.b. Do not weld in locations near chlorinated hydrocarbon vapors coming from degreasing, cleaning or spraying operations. The heat and rays of the arc can react with solvent vapors to form phosgene, a highly toxic gas, and other irritating products.
- 5.c. Shielding gases used for arc welding can displace air and cause injury or death. Always use enough ventilation, especially in confined areas, to insure breathing air is safe.
- 5.d. Read and understand the manufacturer's instructions for this equipment and the consumables to be used, including the material safety data sheet (MSDS) and follow your employer's safety practices. MSDS forms are available from your welding distributor or from the manufacturer.
- 5.e. Also see item 1.b.

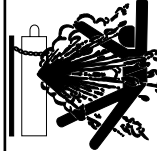


### WELDING SPARKS can cause fire or explosion.

6.a. Remove fire hazards from the welding area. If this is not possible, cover them to prevent the welding sparks from starting a fire.

Remember that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas. Avoid welding near hydraulic lines. Have a fire extinguisher readily available.

- 6.b. Where compressed gases are to be used at the job site, special precautions should be used to prevent hazardous situations. Refer to "Safety in Welding and Cutting" (ANSI Standard Z49.1) and the operating information for the equipment being used.
- 6.c. When not welding, make certain no part of the electrode circuit is touching the work or ground. Accidental contact can cause overheating and create a fire hazard.
- 6.d. Do not heat, cut or weld tanks, drums or containers until the proper steps have been taken to insure that such procedures will not cause flammable or toxic vapors from substances inside. They can cause an explosion even though they have been "cleaned". For information, purchase "Recommended Safe Practices for the Preparation for Welding and Cutting of Containers and Piping That Have Held Hazardous Substances", AWS F4.1 from the American Welding Society (see address above).
- 6.e. Vent hollow castings or containers before heating, cutting or welding. They may explode.
- 6.f. Sparks and spatter are thrown from the welding arc. Wear oil free protective garments such as leather gloves, heavy shirt, cuffless trousers, high shoes and a cap over your hair. Wear ear plugs when welding out of position or in confined places. Always wear safety glasses with side shields when in a welding area.
- 6.g. Connect the work cable to the work as close to the welding area as practical. Work cables connected to the building framework or other locations away from the welding area increase the possibility of the welding current passing through lifting chains, crane cables or other alternate circuits. This can create fire hazards or overheat lifting chains or cables until they fail.
- 6.h. Also see item 1.c.



### CYLINDER may explode if damaged.

7.a. Use only compressed gas cylinders containing the correct shielding gas for the process used and properly operating regulators designed for the gas and pressure used. All hoses, fittings, etc. should be suitable for the application and maintained in good condition.

- 7.b. Always keep cylinders in an upright position securely chained to an undercarriage or fixed support.
- 7.c. Cylinders should be located:
  - Away from areas where they may be struck or subjected to physical damage.
  - A safe distance from arc welding or cutting operations and any other source of heat, sparks, or flame.
- 7.d. Never allow the electrode, electrode holder or any other electrically "hot" parts to touch a cylinder.
- 7.e. Keep your head and face away from the cylinder valve outlet when opening the cylinder valve.
- 7.f. Valve protection caps should always be in place and hand tight except when the cylinder is in use or connected for use.
- 7.g. Read and follow the instructions on compressed gas cylinders, associated equipment, and CGA publication P-1, "Precautions for Safe Handling of Compressed Gases in Cylinders," available from the Compressed Gas Association 1235 Jefferson Davis Highway, Arlington, VA 22202.



### FOR ELECTRICALLY powered equipment.

- 8.a. Turn off input power using the disconnect switch at the fuse box before working on the equipment.
- 8.b. Install equipment in accordance with the U.S. National Electrical Code, all local codes and the manufacturer's recommendations.
- 8.c. Ground the equipment in accordance with the U.S. National Electrical Code and the manufacturer's recommendations.

## PRÉCAUTIONS DE SÛRETÉ

Pour votre propre protection lire et observer toutes les instructions et les précautions de sûreté spécifiques qui paraissent dans ce manuel aussi bien que les précautions de sûreté générales suivantes:

### Sûreté Pour Soudage A L'Arc

1. Protégez-vous contre la secousse électrique:
  - a. Les circuits à l'électrode et à la pièce sont sous tension quand la machine à souder est en marche. Éviter toujours tout contact entre les parties sous tension et la peau nue ou les vêtements mouillés. Porter des gants secs et sans trous pour isoler les mains.
  - b. Faire très attention de bien s'isoler de la masse quand on soude dans des endroits humides, ou sur un plancher métallique ou des grilles métalliques, principalement dans les positions assis ou couché pour lesquelles une grande partie du corps peut être en contact avec la masse.
  - c. Maintenir le porte-électrode, la pince de masse, le câble de soudage et la machine à souder en bon et sûr état de fonctionnement.
  - d. Ne jamais plonger le porte-électrode dans l'eau pour le refroidir.
  - e. Ne jamais toucher simultanément les parties sous tension des porte-électrodes connectés à deux machines à souder parce que la tension entre les deux pinces peut être le total de la tension à vide des deux machines.
  - f. Si on utilise la machine à souder comme une source de courant pour soudage semi-automatique, ces précautions pour le porte-électrode s'appliquent aussi au pistolet de soudage.
2. Dans le cas de travail au dessus du niveau du sol, se protéger contre les chutes dans le cas où on reçoit un choc. Ne jamais enrouler le câble-électrode autour de n'importe quelle partie du corps.
3. Un coup d'arc peut être plus sévère qu'un coup de soleil, donc:
  - a. Utiliser un bon masque avec un verre filtrant approprié ainsi qu'un verre blanc afin de se protéger les yeux du rayonnement de l'arc et des projections quand on soude ou quand on regarde l'arc.
  - b. Porter des vêtements convenables afin de protéger la peau de soudeur et des aides contre le rayonnement de l'arc.
  - c. Protéger l'autre personnel travaillant à proximité au soudage à l'aide d'écrans appropriés et non-inflammables.
4. Des gouttes de laitier en fusion sont émises de l'arc de soudage. Se protéger avec des vêtements de protection libres de l'huile, tels que les gants en cuir, chemise épaisse, pantalons sans revers, et chaussures montantes.

5. Toujours porter des lunettes de sécurité dans la zone de soudage. Utiliser des lunettes avec écrans latéraux dans les zones où l'on pique le laitier.
6. Eloigner les matériaux inflammables ou les recouvrir afin de prévenir tout risque d'incendie dû aux étincelles.
7. Quand on ne soude pas, poser la pince à un endroit isolé de la masse. Un court-circuit accidentel peut provoquer un échauffement et un risque d'incendie.
8. S'assurer que la masse est connectée le plus près possible de la zone de travail qu'il est pratique de le faire. Si on place la masse sur la charpente de la construction ou d'autres endroits éloignés de la zone de travail, on augmente le risque de voir passer le courant de soudage par les chaînes de levage, câbles de grue, ou autres circuits. Cela peut provoquer des risques d'incendie ou d'échauffement des chaînes et des câbles jusqu'à ce qu'ils se rompent.
9. Assurer une ventilation suffisante dans la zone de soudage. Ceci est particulièrement important pour le soudage de tôles galvanisées plombées, ou cadmiées ou tout autre métal qui produit des fumées toxiques.
10. Ne pas souder en présence de vapeurs de chlore provenant d'opérations de dégraissage, nettoyage ou pistolage. La chaleur ou les rayons de l'arc peuvent réagir avec les vapeurs du solvant pour produire du phosgène (gas fortement toxique) ou autres produits irritants.
11. Pour obtenir de plus amples renseignements sur la sûreté, voir le code "Code for safety in welding and cutting" CSA Standard W 117.2-1974.

## PRÉCAUTIONS DE SÛRETÉ POUR LES MACHINES À SOUDER À TRANSFORMATEUR ET À REDRESSEUR

1. Relier à la terre le châssis du poste conformément au code de l'électricité et aux recommandations du fabricant. Le dispositif de montage ou la pièce à souder doit être branché à une bonne mise à la terre.
2. Autant que possible, l'installation et l'entretien du poste seront effectués par un électricien qualifié.
3. Avant de faire des travaux à l'intérieur de poste, le débrancher à l'interrupteur à la boîte de fusibles.
4. Garder tous les couvercles et dispositifs de sûreté à leur place.

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**POWER MIG 350MP**



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**POWER MIG 350MP**





## TECHNICAL SPECIFICATIONS – POWER MIG 350MP

### INPUT – SINGLE PHASE ONLY

<b>Standard Voltage/Frequency</b> 208/230/460/575/60 Hz	<b>Input Current @ 230Amp Rated Output</b> 48/43/22/17 Amps	<b>Input Current @ 300 Amp Rated Output</b> 72/62/31/25 Amps
------------------------------------------------------------	----------------------------------------------------------------	-----------------------------------------------------------------

### RATED OUTPUT

<b>Input Voltage</b> 208 230/460/575 208/230/460/575	<b>Duty Cycle</b> 40% 60% 100%	<b>Amps</b> 300 Amps 300 Amps 230Amps	<b>Volts at Rated Amperes</b> 32 Volts 32 Volts 29 Volts
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### OUTPUT

<b>Welding Current Range (Continuous)</b> 5 – 350 Amps	<b>Maximum Open Circuit Voltage</b> 67 Volts	<b>Welding Voltage Range</b> 10-45 Volts
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### RECOMMENDED INPUT WIRE AND FUSE SIZES - SINGLE PHASE

Input Voltage/ Frequency (Hz)	230Amps @ 29 Volts (100% Duty Cycle)	300Amps @ 32 Volts (60% Duty Cycle)	75°C Copper Wire AWG (IEC) Sizes (MM <sup>2</sup> )	Fuse or Breaker Size
208/60*	48 A	72 A	6 (16 mm <sup>2</sup> )	90 A
230/60	43 A	62 A	6 (16 mm <sup>2</sup> )	80 A
460/60	22 A	31 A	10 (6 mm <sup>2</sup> )	50 A
575/60	17 A	25 A	12 (2.5 mm <sup>2</sup> )	35 A

NOTE: Use #10 AWG Grounding Wire

\*For 208V Input ONLY: The duty Cycle Rating at 300 Amps is 40%

### PHYSICAL DIMENSIONS

<b>Height</b> 31.79 in 808 mm	<b>Width</b> 18.88 in 480 mm	<b>Depth</b> 38.78 in 985 mm	<b>Weight</b> 255 lbs 116 kg
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### WIRE SPEED RANGE

<b>Wire Speed</b>	50 – 700 IPM (1.27 – 17.8 m/minute)
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POWER MIG 350MP



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Read entire installation section before starting installation.

## SAFETY PRECAUTIONS

### ⚠ WARNING



#### ELECTRIC SHOCK can kill.

- Do not touch electrically live parts or electrode with skin or wet clothing.
- Insulate yourself from work and ground.
- Always wear dry insulating gloves.
- Do not use AC welder if your clothing, clothes or work area is damp or if working on, under or inside work piece.

Use the following equipment:

- Semiautomatic DC constant voltage (wire) welder.
- DC manual (stick) welder.
- AC welder with reduced voltage control.
- Do not operate with panels removed.
- Disconnect input power before servicing.



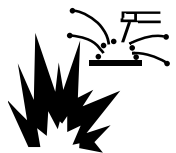
#### FUMES AND GASES can be dangerous.

- Keep your head out of fumes.
- Use ventilation or exhaust to remove fumes from breathing zone and general area.



#### WELDING SPARKS can cause fire or explosion.

- Keep flammable material away.
- Do not weld on closed containers.



#### ARC RAYS can burn eyes and skin.

- Wear eye, ear and body protection.



Observe all safety information throughout this manual.

**ONLY QUALIFIED PERSONNEL SHOULD INSTALL, USE OR SERVICE THIS EQUIPMENT.**

## UNCRATING THE POWER MIG 350MP

Cut banding and lift off cardboard carton. Cut banding holding the machine to the skid. Remove foam and corrugated packing material. Untape accessories from Gas Bottle Platform. Unscrew the two wood screws (at the Gas Bottle Platform) holding the machine to the skid. Roll the machine off the skid assembly.

## LOCATION

Locate the welder in a dry location where there is free circulation of clean air into the louvers in the back and out the front. A location that minimizes the amount of smoke and dirt drawn into the rear louvers reduces the chance of dirt accumulation that can block air passages and cause overheating.

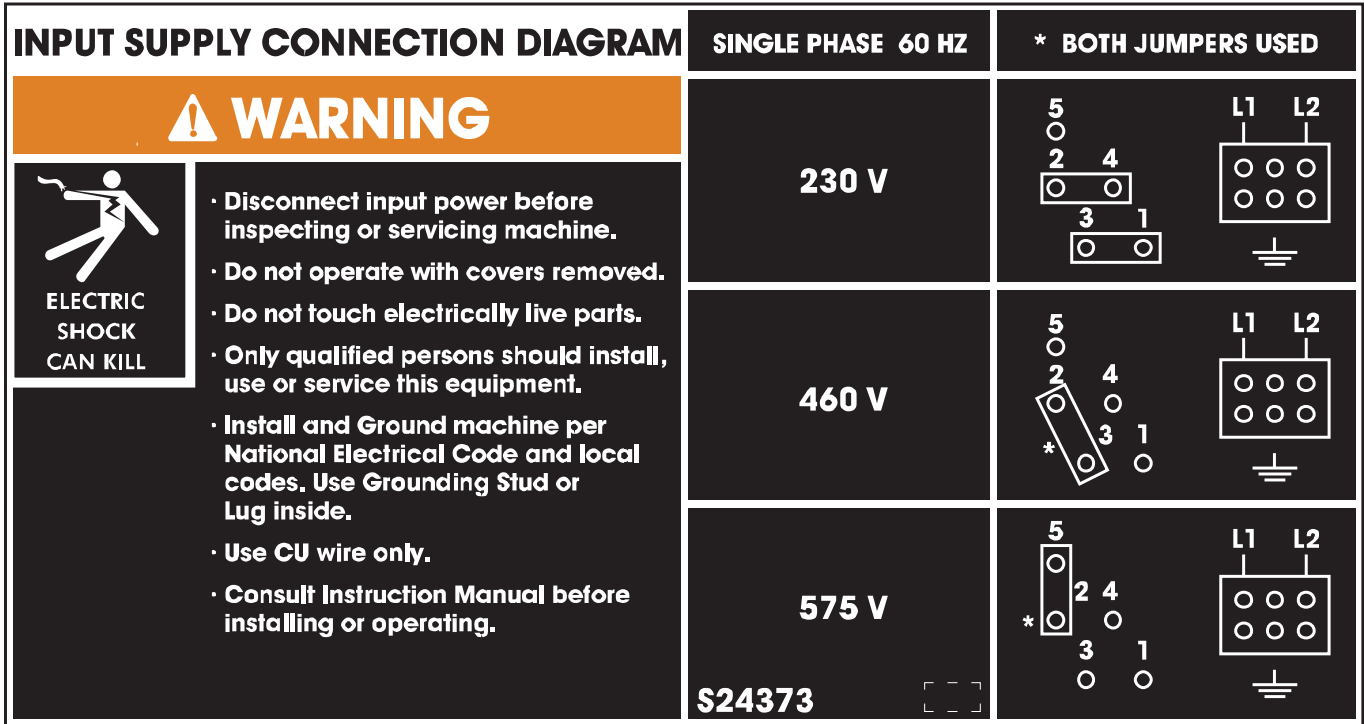
## INPUT POWER, GROUNDING AND CONNECTION DIAGRAMS

1. Before starting the installation, check with the local power company if there is any question about whether your power supply is adequate for the voltage, amperes, phase, and frequency specified on the welder nameplate. Also be sure the planned installation will meet the U.S. National Electrical Code and local code requirements. This welder may be operated from a single phase line or from one phase of a two or three phase line.
2. The Power MIG 350MP is supplied connected for 230 Volt Input. If the welder is to be operated on another voltage, it must be reconnected according to the instructions in *Figure A.1*

POWER MIG 350MP

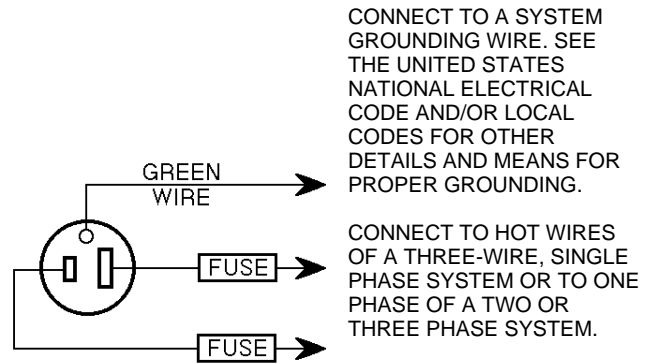


FIGURE A.1 — TRIPLE VOLTAGE MACHINE INPUT CONNECTIONS



3. The Power MIG is shipped with a 10ft.(3.05m) input cable and plug connected to the welder. Using the instructions in Figure A.2, have a qualified electrician connect the receptacle or cable to the input power lines and the system ground per the U.S. National Electrical Code and any applicable local codes. See "Technical Specifications" at the beginning of this chapter for proper wire sizes. For long runs over 100ft. (30.48m), larger copper wires should be used. Fuse the two hot lines with super lag type fuses as shown in the following diagram. The center contact in the receptacle is for the grounding connection. A green wire in the input cable connects this contact to the frame of the welder. This ensures proper grounding of the welder frame when the welder plug is inserted into the receptacle.

FIGURE A.2 — RECEPTACLE DIAGRAM



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## GUN AND CABLE INSTALLATION

A Magnum 300 gun and 15Ft.(4.6m) cable (12Ft.(3.7m) for Codes 11000 and below) are provided with the Power MIG 350MP. A Magnum cable liner for .035-.045" (0.9-1.2 mm) electrode and contact tips for .035" (0.9mm) and .045" (1.2mm) are included for 15Ft..

### **⚠ WARNING**

Turn the welder power switch off before installing gun and cable.

### LINER INSTALLATION AND TRIMMING INSTRUCTION (SEE FIGURE A.3)

1. Remove the gas nozzle.
2. Remove the gas diffuser from the gun tube. If gas diffuser contains a small set screw, loosen the set screw.
3. Lay gun and cable out straight on a flat surface. Loosen set screw of the connector on the back end of the gun.
4. Insert the untrimmed Liner into the back end of the gun.
5. Seat Liner bushing into back of gun. Secure Liner by tightening set screw. Do not install the gas diffuser at this time.
6. Lay the cable straight and trim Liner to 9/16". Remove burrs.
7. Secure the gas diffuser into the tube.
8. Tighten the set screw against the Liner.

### **⚠ CAUTION**

This screw should only be gently tightened. Over tightening will split or collapse the liner and cause poor wire feeding.

## GUN & CABLE ASSEMBLY INSTALLED INTO THE POWER MIG

1. Unscrew knurled screw on the drive unit front end (inside wire feed compartment) until tip of screw no longer protrudes into gun opening as seen from front of machine.
2. Insert the male end of gun cable into the female casting through opening in front panel. Make sure connector is fully inserted and tighten knurled screw.
3. Connect the gun trigger connector from the gun and cable to the mating receptacle inside the compartment located above the gun connection made in step 2 above. Make sure that the key ways are aligned, insert and tighten retaining ring.

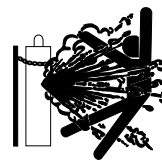
## SHIELDING GAS

(For Gas Metal Arc Welding Processes)

Customer must provide cylinder of appropriate type shielding gas for the process being used.

A gas flow regulator, for CO<sub>2</sub> or Argon blend gas, and an inlet gas hose are factory provided with the Power MIG 350MP.

### **⚠ WARNING**



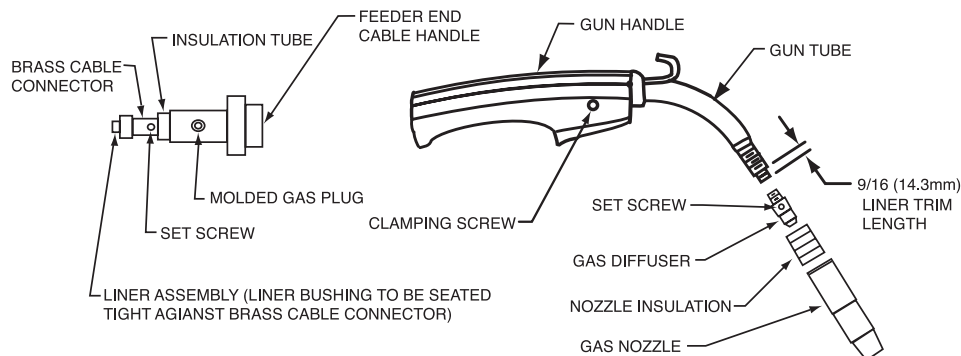
**CYLINDER may explode if damaged.**

- Gas under pressure is explosive. Always keep gas cylinders in an upright position and always keep chained to undercarriage or stationary support. See American National Standard Z-49.1, "Safety in Welding and Cutting" published by the American Welding Society.

Install shielding gas supply as follows:

1. Set gas cylinder on rear platform of Power MIG 350MP. Hook chain in place to secure cylinder to rear of welder.
2. Remove the cylinder cap. Inspect the cylinder valves and regulator for damaged threads, dirt, dust, oil or grease. Remove dust and dirt with a clean cloth.

FIGURE A.3



POWER MIG 350MP



**DO NOT ATTACH THE REGULATOR IF OIL, GREASE OR DAMAGE IS PRESENT!** Inform your gas supplier of this condition. Oil or grease in the presence of high pressure oxygen is explosive.

3. Stand to one side away from the outlet and open the cylinder valve for an instant. This blows away any dust or dirt which may have accumulated in the valve outlet.

### **WARNING**

**Be sure to keep your face away from the valve outlet when “cracking” the valve.**

4. Attach the flow regulator to the cylinder valve and tighten the union nut(s) securely with a wrench.

**NOTE:** If connecting to 100% CO<sub>2</sub> cylinder, insert regulator adapter between regulator and cylinder valve. If adapter is equipped with a plastic washer, be sure it is seated for connection to the CO<sub>2</sub> cylinder.

5. Attach one end of the inlet gas hose to the outlet fitting of the flow regulator, the other end to the Power MIG 350MP rear fitting, and tighten the union nuts securely with a wrench.
6. Before opening the cylinder valve, turn the regulator adjusting knob counterclockwise until the adjusting spring pressure is released.
7. Standing to one side, open the cylinder valve slowly a fraction of a turn. When the cylinder pressure gauge pointer stops moving, open the valve fully.

### **WARNING**

**Never stand directly in front of or behind the flow regulator when opening the cylinder valve. Always stand to one side.**

8. The flow regulator is adjustable. Adjust it to the flow rate recommended for the procedure and process being used before making the weld.

POWER MIG 350MP



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**POWER MIG 350MP**



Read entire Operation section before operating the Power MIG 350MP.

## ⚠ WARNING



**ELECTRIC SHOCK can kill.**

- Do not touch electrically live parts or electrode with skin or wet clothing. Insulate yourself from work and ground.
- Always wear dry insulating gloves.



**FUMES AND GASES can be dangerous.**

- Keep your head out of fumes.
- Use ventilation or exhaust to remove fumes from breathing zone.



**WELDING SPARKS can cause fire or explosion.**

- Keep flammable material away.
- Do not weld on closed containers.



**ARC RAYS can burn eyes and skin.**

- Wear eye, ear and body protection.

Observe all safety information throughout this manual.

## DEFINITIONS OF WELDING MODES

### NON-SYNERGIC WELDING MODES

- A **Non-synergic** welding mode requires all welding process variables to be set by the operator.

### SYNERGIC WELDING MODES

- A **Synergic** welding mode offers the simplicity of single knob control. The machine will select the correct voltage and amperage based on the wire feed speed (WFS) set by the operator.

## COMMON WELDING ABBREVIATIONS

### WFS

- Wire Feed Speed

### CC

- Constant Current

### CV

- Constant Voltage

### GMAW (MIG)

- Gas Metal Arc Welding

### GMAW-P (MIG)

- Gas Metal Arc Welding-(Pulse)

### GMAW-PP (MIG)

- Gas Metal Arc Welding-(Pulse-on-Pulse)

### GTAW (TIG)

- Gas Tungsten Arc Welding

### SMAW (STICK)

- Shielded Metal Arc Welding

### FCAW (INNERSHIELD)

- Flux Core Arc Welding

POWER MIG 350MP



## PRODUCT DESCRIPTION

The Power MIG 350MP is a complete semiautomatic multi-process DC arc welding machine offering CV and CC DC welding. It is rated for 350MP amps, 32 volts at a 60% duty cycle. The standard machine is equipped to weld CC-Stick, CC-GTAW, CV-FCAW, and synergic and non-synergic CV-GMAW / GMAW-P and Pulse-on-Pulse and Power Mode welding processes. See the descriptions for Pulse™ and Power Mode welding processes later in this section.

Mode #5 and mode #6 are non-synergic CV GMAW modes for bare and flux cored wires, respectively. In these modes, the user presets the wire feed speed (WFS) on the left meter and the welding voltage on the right. These two settings are independent; that is, if the WFS is changed the voltage will remain constant, or vice versa.

All of the other mode numbers designated as "CV" are synergic. Again, WFS is shown on the left meter and voltage is shown on the right meter. However, in using these modes, the WFS is preset and the voltage is preset only once. Now, when the WFS is changed, the voltage will change with it, so that the arc appearance and arc length will stay the same without the necessity to re-adjust the voltage.

The modes shown as "GMAW-P" or "GMAW-PP" are all synergic pulsed modes. In these modes WFS is shown on the left meter and "Trim" is shown on the right meter. The user adjusts WFS to obtain an arc with the correct arc energy for the material thickness being welded. The Trim, which is adjustable from values of -1.5 to 0 (OFF) and up to +1.5 controls the arc length. Higher values of Trim give longer arc lengths. Once the user has adjusted the Trim for one WFS, the power supply will synergically change many variables so that, as the WFS is changed, the arc length and arc appearance will remain the same. The synergic modes are usable with both push and push - pull torches, as described later in this Manual. When using a spool gun, however, although the synergic pulsed modes are still accessible, they must be used in a non-synergic manner as described in the Accessory Section.

The digital microcomputer based control system allows easy and accurate adjustment of weld parameters through the multi-process panel located on the front of the machine. The Power MIG 350MP is equipped with a 6-pin and 7-pin connector to allow operation of a push-pull gun for feeding aluminum wires, a spool gun, remotes, and a foot amptrol.

### Other features

Optional kits are available for push-pull welding, spool gun operation, push feeding of 3/64 aluminum with the standard Power MIG 350MP gun and wire feeder. A Dual Cylinder Mounting Kit is also offered.

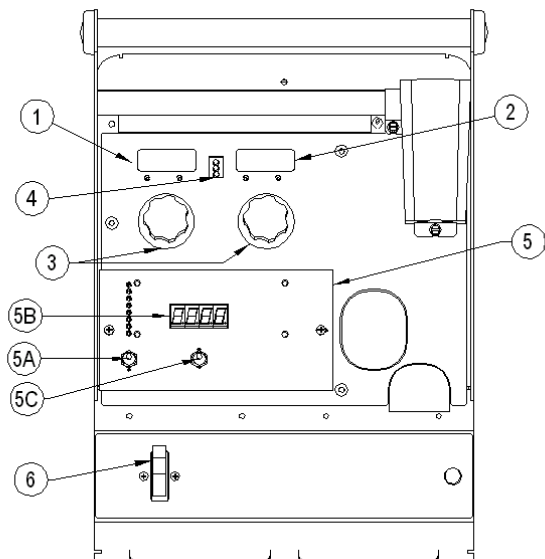
## CONTROLS AND SETTINGS

(See Figure B.1)

**1. WIRE FEED SPEED (WFS) / AMP METER** - This meter displays either the WFS or current value (Amps) depending on the status of the machine. Located below the display is the text "WFS" and "Amps." An LED light is illuminated to the left of one of these units to indicate the units of the value displayed on the meter.

- Prior to CV operation, the meter displays the desired preset WFS value.
- Prior to CC-Stick and CC-GTAW operation, the meter displays the preset current value.
- During Welding, the meter displays actual average amps.
- After welding, the meter holds the actual current value for 5 seconds. During this time, the display is blinking to indicate that the machine is in the "Hold" period. Output adjustment while in the "Hold" period results in the "prior to operation" characteristics stated above.
- After the 5 second "Hold" period, the meter displays the set WFS (CV modes) or Amp (CC modes) value.

FIGURE B.1



## POWER MIG 350MP





**2. VOLT / TRIM METER** - This meter displays either the voltage or trim value depending on the status of the machine. Located below the display is the text "Volts" and "Trim." An LED light is illuminated to the left of one of these in order to indicate the units of the value displayed in the meter.

### CV Processes

- Prior to GMAW and FCAW operation, the meter displays the desired preset Voltage value.
- Prior to synergic GMAW-P and GMAW-PP operation, the meter displays the desired preset Trim value. Trim adjusts the synergic default voltage as a percentage of that voltage. A trim value of 1 is the default and results in the recommended voltage setting for a given wire feed speed. Adjusting trim to a value of .95, adjusts the voltage to 95% of the recommended voltage.
- During Welding, the meter displays actual average volts.
- After welding, the meter holds the actual voltage value for 5 seconds. During this time, the display is blinking to indicate that the machine is in the "Hold" period. Output adjustment while in the "Hold" period results in the "prior to operation" characteristics stated above.
- After the 5 second "Hold" period, the meter displays the set Voltage (GMAW, FCAW) or Trim (GMAW-P) value.

### CC Processes

- The meter displays the status of the output.
- When output is enabled, the meter will display "ON."
- When there is no output, the meter will display "OFF."

**3. OUTPUT CONTROLS** - The Power MIG 350MP has 2 encoder knobs to adjust weld parameters.

- Each encoder changes the displayed value of the meter located directly above that encoder.
- In CC-GTAW modes, the left encoder sets the maximum welding current. Full depression of a foot or hand ampntrol results in the preset level of current.
- In CC-Stick and CC-GTAW, the right encoder activates and de-activates the output. Turning the encoder clockwise enables the output if not using a remote trigger device. To de-energize the output, turn the encoder counter-clockwise. The display above will indicate the "ON" or "OFF" status of the output.

**4. THERMAL** - This status light illuminates when the power source has been driven into thermal overload.

**5. MULTI-PROCESS PANEL** - This panel enables selection of weld modes as well as adjustment of certain weld parameters within each weld mode.

The eight discrete LED's are used to identify which selection will be shown on the display. The possible selections are:

- Weld Mode (Process selection choices)
  - Preflow / Postflow
  - Run-In
  - Start
  - Arc Control
  - Crater
  - Burnback
  - Spot
- } Choice of weld parameters that can be adjusted. Complete descriptions of each parameter are found later in this section.

Only one LED will be illuminated at any time. The Weld Mode attribute will always be a valid selection (the other attributes may not be available in all processes).

### 5A. SELECT Toggle Switch

- This switch toggles through the 8 selections detailed above the switch.
- A red LED is located next to each possible selection and is illuminated when that choice can be changed.

### 5B. Display Meter

- This meter displays the active weld mode (a set of weld parameters that have been determined to provide the recommended results for a particular welding process) when the "Weld Mode" LED is illuminated or when any one of the other seven LED's is illuminated the meter indicates what value that welding parameter has been set to.

### 5C. SET Toggle Switch

- This switch adjusts (up or down) the value shown on the display meter. When the WELD MODE LED is illuminated, this switch is changing the weld mode of the machine. The most commonly used modes are displayed in the chart on the right half of the Multi-Process Panel.

If the LED next to a weld parameter (Preflow/Postflow, Run-In, Start, etc.) is illuminated, the SET switch will adjust the setting of that specific weld parameter. The setting is shown on the display meter.

### 6. ON/OFF POWER SWITCH

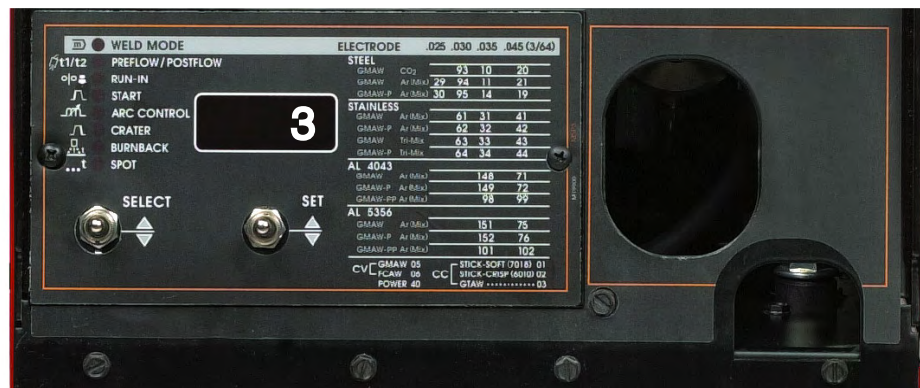
**SETTING AND CONFIGURING THE POWER MIG 350MP FOR WELDING**

- Check that the electrode polarity is correct for the process and turn the Power Switch to the "ON" position. After the "boot-up" period (approximately 20 seconds), the Power MIG 350MP will default to the last preset weld mode that was active when the machine was powered down. The Multi-Process Panel defaults with the "Weld Mode" active.
- Toggle the SET switch to the desired "Weld Mode" operation. The Multi-Process Meter displays a weld mode number corresponding to a CC or CV welding process as detailed by the chart on the right side of the panel. In the example shown in Figure B.2 "3" is displayed above the SET switch. This means that the machine is set for CC-GTAW (TIG) welding.
- Toggle the SELECT switch to activate the "weld parameters" for the selected weld mode.
- Set each parameter using the SET switch to adjust the parameter displayed on the display meter.

NOTE: If the LED next to the weld parameter is flashing, the WFS/AMP and/or the Volt/Trim values can also be adjusted for that parameter using the control knobs below each display meter. An LED below each of the displays will also be flashing to indicate which value is adjustable.

The Table B.1 shows which weld parameters are adjustable for a given weld mode. The weld parameters are detailed later in this section.

**FIGURE B.2**



**TABLE B.1**

	PREFLOW / POSTFLOW	RUN IN	START	ARC CONTROL	CRATER	BURNBACK	SPOT
CC-STICK	-----	-----	Yes	Yes	-----	-----	-----
CC-GTAW	Yes	-----	Yes	-----	-----	-----	-----
CV-FCAW	-----	Yes	Yes	Yes	Yes	Yes	Yes
CV-GMAW	Yes	Yes	Yes	Yes	Yes	Yes	Yes
CV-GMAW-P	Yes	Yes	Yes	Yes	Yes	Yes	Yes
POWER	Yes	Yes	Yes	Yes	Yes	Yes	Yes

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## MULTI-PROCESS PANEL FUNCTIONS

### Weld Mode

Setting the Weld Mode is selecting the proper program from the ones available in the machine's memory for a particular welding application. The table on the right side of the front panel (See Figure B.2) gives information on the different programs available in this machine. It describes the type of process (CV, CC, synergic GMAW), type of metal (mild steel, stainless steel, aluminum), type of shielding gas and size of electrode recommended for a particular mode.

The Weld Mode selection is enabled by toggling the SELECT switch until the LED next to Weld Mode is lit. A Weld Mode number will be displayed on the display meter. Toggling the SET switch up or down will increase or decrease the WELD MODE number displayed. The machine will change to the selected weld mode after two seconds of SET switch inactivity. If the SELECT switch is changed before two seconds of SET switch inactivity, the machine will not change modes. The last active Weld Mode will be saved at power down so that it will be selected with the next power up of the machine.

### Preflow / Postflow

- The Preflow setting allows a time to be selected for shielding gas to flow after the trigger is pulled and prior to wire feeding and establishing an arc.
- The Postflow setting allows a time to be selected for shielding gas to continue to flow after the trigger is released and output current is turned off.
- The Preflow timer will be selected by toggling the SELECT switch until the LED next to PREFLOW /POSTFLOW is lit. The display meter will read Pre. The present Preflow time will be displayed and can be changed by positioning the SET switch up or down.
- The Postflow timer will be selected by pressing down the SELECT switch an additional time. The LED next to PREFLOW / POSTFLOW will remain lit; but the display meter will now read Pos. The present Postflow time will be displayed and can be changed by positioning the SET switch up or down.
- The default value for both Preflow and Postflow is "OFF" (0 seconds).
- Preflow can be adjusted from 0 to 2.5 seconds in 0.1 second increments.
- Postflow can be adjusted from 0 to 10.0 seconds in 0.1 second increments.

### Run-In

- The Run-In function offers the ability to set a wire feed speed, from trigger until an arc is established, that is independent of the Welding or Start wire feed speed. Setting a Run-In WFS lower than the welding WFS avoids stubbing problems when starting the arc.
- Run-In is selected by toggling the SELECT switch until the LED next to RUN-IN is lit. A Run-In WFS may be adjusted using the SET switch on the Multi-Process Panel. The Display meter on the Multi-Process Panel will indicate the run-in speed. Do not use the Output Control Knob on the upper case front to adjust the WFS. This will change the welding WFS displayed in the meters on the upper case front.
- The default value for Run-In is "OFF."
- Run-In speed is adjustable from 50 ipm to 150 ipm (Inches per Minute).

### Start Procedure

This machine provides the option of setting a Starting Procedure to start the weld, and from there, to ramp to the welding procedure over a specified amount of time. Typically starting on a higher starting procedure than the welding procedure is known as a "Hot Start". Setting a starting procedure lower than the welding procedure is known as a "Cold Start".

For **SMAW (Stick) welding** setting a "Hot Start" helps to minimize stubbing the electrode.

For **GTAW (TIG) welding** setting a "Cold Start" minimizes burn-through of thin materials when not using a manual amperage control.

For **Wire Feed welding** using a start procedure can help improve starting characteristics. A good example is when welding aluminum. Aluminum's high thermal conductivity results in heat spreading around the plate very fast. Therefore more energy is necessary at the very beginning to heat up the starting point of the weld. Once the welding begins, it is not necessary to give this extra heat anymore so a ramp down to the welding procedure is necessary.

To set a Start Procedure begin by using the SELECT switch to select the Start LED. Using the SET switch, enter the desired Start ramp time duration (its available values range from 0.01 seconds to 0.50 seconds in increments of 0.01 seconds or the default value of OFF). This value will be displayed on the digital meter of the multiprocess panel (See Figure B.2).

After setting the Start time also set the WFS, and voltage/trim. The way to know what information needs to be entered is to look for flashing LED's. If an LED is flashing that parameter value needs to be entered.

## POWER MIG 350MP



**Arc Control** (See Table B.2)

There are no specific unit values offered because the setting of this feature largely depends upon operator preference. Arc Control has a different effect on the character of the arc depending upon the welding process applied.

In **SMAW (STICK mode)**, arc control adjusts the arc force. It can be set to the lower range for a soft and less penetrating arc characteristic (negative numeric values) or to the higher range (positive numeric values) for a crisp and more penetrating arc. Normally, when welding with cellulosic types of electrodes (E6010, E7010, E6011), a higher energy arc is required to maintain arc stability. This is usually indicated when the electrode sticks to the work-piece or when the arc pops-out during manipulative technique. For low hydrogen types of electrodes (E7018, E8018, E9018, etc.) a softer arc is usually desirable and the lower end of the Arc Control suits these types of electrodes. In either case the arc control is available to increase or decrease the energy level delivered to the arc.

In **GMAW-S**, the short-circuiting mode of metal transfer, the Arc Control features the ability to increase or decrease the energy level at the arc. Setting the arc control from 1 to 10 decreases energy, and setting the Arc Control from 0 to -10 increases the energy delivered to the arc.

Solid carbon steel electrodes in a range from .025" - .045" (.6 mm - 1.1 mm) are nominally used, and the shielding gas blend for GMAW-S is usually 100% carbon dioxide or a blend of argon and carbon dioxide. The Arc Control in this scenario is set to control the droplet size and more pinch is added (increasing pinch reduces energy to the arc) to achieve the "bacon frying" sound associated with this mode of metal transfer.

Carbon steel electrodes employed in GMAW-S usually perform best when the droplet size is regulated by pinch to reduce the droplet size transferred with each short-circuit event.

When welding with solid stainless steel types of electrodes it is usually desirable to increase the energy delivered to the arc. High percentage argon blends with a 2 % addition of oxygen or a three part shielding gas blend comprised of 90% Helium + 7.5% Argon + 2.5 % carbon dioxide are usually employed. The added energy is associated, in this scenario, with increasing the inductance (negative numeric values). By adding to the energy level the weld bead appearance improves – spatter levels decrease and wetting action at the toes of a fillet weld increases. The arc is softer with the higher inductance setting and the arc lends itself to faster travel speed.

In **GMAW-P**, the pulsed spray mode of metal transfer, the Arc Control is, once again, used to increase and decrease the focus of the energy delivered to the arc. Increasing the setting in the range of +1 to +10 results in an increase in pulsed frequency, and the effect is to narrow the arc cone and concentrate the available energy to a smaller area. Decreasing the Arc Control setting from -1 to -10 results in a reduction of pulsed frequency – the result is a broader arc cone, which creates a wider weld bead.

Important to note here is that if a component of a pulsed waveform is increased, then another must be decreased. Adding pulsed frequency through an increase in the Arc Control setting, then also results in a proportional decrease in background current. If this were not the case, then the arc would become too long, with too much energy, and the arc would be unusable.

**TABLE B.2-ARC CONTROL SETTINGS BY PROCESS**

PROCESS	ARC CONTROL SYNONYM	SETTING	APPLICATION AND RESULT
<b>SMAW (STICK)</b>	Arc Force	Lower (-1 to -10) for low hydrogen types of electrodes. Higher (+1 to +10) for cellulosic and other types.	Minus settings are soft and buttery for low hydrogen electrodes. Plus settings are harsh and digging for other types of electrodes.
<b>GMAW – S (Short circuiting metal transfer)</b>	Inductance or Pinch Control	Setting -1 to -10 for softer higher energy arc. Setting +1 to +10 for a crisper lower energy arc.	The minus settings result a more fluid puddle and larger droplet size. The positive settings reduce the droplet size and reduce energy to the arc.
<b>GMAW – P (Pulsed spray metal transfer)</b>	Pulsed frequency control	Minus settings reduces frequency. Plus settings increase frequency.	Wider arc cone and weld bead. Narrower arc cone and narrower bead.
<b>Pulse – on –Pulse™ (Aluminum Only)</b>	Pulsed frequency array control	Minus settings result in lower array frequency and the plus settings increase the array frequency.	Minus settings result in a wider bead with more distinct ripples. Plus settings narrow the resultant bead and the ripples are less distinct.

**POWER MIG 350MP**



In the case of special waveforms designed for pulsed welding aluminum, Pulse on Pulse™, the effect is similar to what occurs with standard pulse. As the Arc Control is increased from +1 to +10 the frequency of the Pulse on Pulse array increases. As the frequency increases the weld bead ripples become less distinct and the arc cone narrows. When the Arc Control is set from -1 to -10 the Pulse on Pulse arrays decrease in frequency, the weld bead ripples become more distinct, and the bead width increases.

In **GMAW-PP mode**, arc control adjusts the modulation frequency, which means the speed at which the ripples are produced in the weld. (See Pulse-on-pulse description later in this section.) When faster travel speeds are desired, arc control needs to be set higher. When slower travel speeds are desired, arc control needs to be set lower.

- The Arc-control adjustment is selected by toggling the SELECT switch until the LED next to ARC CONTROL is lit. The Arc-control value will be displayed. Arc-control can be adjusted by toggling the SET switch up or down.
- The default value is "OFF."

### Crater

The crater is the end of the weld, which normally solidifies creating a concave surface. This can result in stresses that can cause cracks in the center of the crater. The purpose of the Crater control is to fill up the crater, so that its surface becomes flat.

Crater control in this machine is more efficient than in other machines. Normally, in other machines, the crater filling procedure is a step down from the welding WFS to the crater filling WFS. In this machine instead of a step down, the transition is a ramp down, which results in a more controlled filling up of the crater and so, less stresses present in it.

The values to enter are first the desired time to stay at the Crater settings and the desired WFS and voltage/trim to fill the crater.

- The Crater timer is selected by toggling the SELECT switch until the LED next to CRATER is lit and flashing. A crater time may be set using the SET switch.
- The available values for crater control time go from "Off" to 0.1 seconds and from there to 10.0 seconds in increments of 0.1 seconds.
- The Crater function offers the ability to set an endpoint for WFS and Voltage that will be reached over a specified time period. At the end of the weld when the trigger is released, the crater timer will begin and the WFS and Volts settings will ramp down from the Weld Mode WFS and Voltage settings to the Crater WFS and Voltage settings over the time selected. This creates a ramp down of the WFS and Volts during the Crater time.

- In the GMAW, FCAW, and Power weld modes, crater WFS and voltage are adjustable using the control knobs on the upper case front. This is indicated by the flashing LED's next to "WFS" and "VOLTS."
- In the GMAW-P weld modes, Crater WFS and trim are adjustable. This is indicated by the flashing LEDs next to "WFS" and "TRIM."

### Burnback

Setting the Burnback means setting the adjustable time delay between turning off the wire feeding and turning off the arc. Burnback helps to prevent wire sticking to the puddle.

- The Burnback feature will allow current to continue to flow for a specified time period at the end of a weld after wire feeding has stopped.
- The Burnback timer will be selected by toggling the SELECT switch until the LED next to BURNBACK is lit. A burnback time may be set using the SET switch.
- The default value is "OFF" (0 seconds).
- Burnback time is adjustable from 0 to 0.25 seconds in 0.01 second increments.

### Spot

The Spot Timer adjusts arc on-time for spot or tack welds.

- With the Spot feature active (Spot time selected), when the trigger is pulled and the arc is established, the weld will continue until the expiration of the spot timer and the next active state will be enabled (crater or burnback). The trigger must be released and pulled again for another Spot cycle.
- The Spot timer is selected by toggling the SELECT switch until the LED next to SPOT is lit. The present SPOT time will be displayed and can be changed by toggling the SET switch up or down.
- The default value is "OFF" (0 seconds).
- Spot can be adjusted from 0 to 10.0 seconds in 0.1 second increments.

### WIRE DRIVE ROLL

The drive rolls installed with the Power MIG 350MP have two grooves, one side for .030" (0.8mm) solid steel electrode, and the other for the .045"(1.2mm) electrode. The actual drive roll size is stenciled on the side opposite of its groove. If feeding problems occur, a check may be required to make sure that the wire size and the drive roll size matches. See "Procedure for Changing Drive Rolls" in this section.

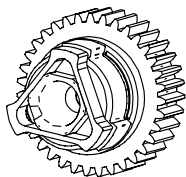
POWER MIG 350MP



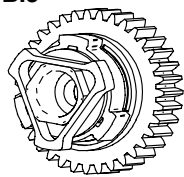
## PROCEDURE FOR CHANGING DRIVE AND IDLE ROLL SETS

1. Turn off the power source.
2. Release the pressure on the idle roll by swinging the adjustable pressure arm down toward the back of the machine. Lift the cast idle roll assembly and allow it to sit in an upright position.
3. Remove the outside wire guide retaining plate by loosening the two large knurled screws.
4. Twist the drive roll retaining mechanism to the unlocked position as shown below and remove the drive roll. (See Figure B.3)

FIGURE B.3



UNLOCKED POSITION



LOCKED POSITION

5. Remove the inside wire guide plate.
6. Replace the drive and idle rolls and inside wire guide with a set marked for the new wire size. **NOTE:** Be sure that the gun liner and contact tip are also sized to match the selected wire size.
7. Manually feed the wire from the wire reel, over the drive roll groove and through the wire guide and then into the brass bushing of the gun and cable assembly.
8. Replace the outside wire guide retaining plate by tightening the two large knurled screws. Reposition the adjustable pressure arm to its original position to apply pressure. Adjust pressure as necessary.

## WIRE REEL LOADING - READI-REELS, SPOOLS OR COILS

To Mount a 30 Lb. (14 kg) Read-Reel Package (Using the Molded Plastic K363-P Read-Reel Adapter):

1. Open the Wire Drive Compartment Door
2. Depress the Release Bar on the Retaining Collar and remove it from the spindle.
3. Place the Optional Adapter on the spindle
4. Re-install the Retaining Collar. Make sure that the Release Bar "pops up" and that the collar retainers fully engage the retaining ring groove on the spindle.

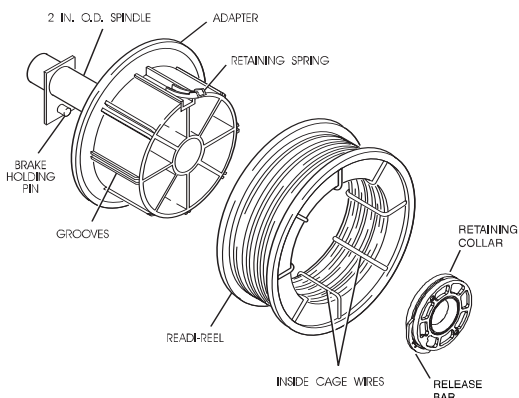
5. Rotate the spindle and adapter so the retaining spring is at the 12 o'clock position.
6. Position the Read-Reel so that it will rotate in a direction when feeding so as to be de-reeled from top the of the coil.
7. Set one of the Read-Reel inside cage wires on the slot in the retaining spring tab.
8. Lower the Read-Reel to depress the retaining spring and align the other inside cage wires with the grooves in the molded adapter.
9. Slide cage all the way onto the adapter until the retaining spring "pops up" fully.

### CAUTION

Check to be sure the retaining ring has fully returned to the locking position and has securely locked the Read-Reel cage in place. Retaining spring must rest on the cage, not the welding electrode.

10. To remove Read-Reel from Adapter, depress retaining spring tab with thumb while pulling the Read-Reel cage from the molded adapter with both hands. Do not remove adapter from spindle.

FIGURE B.4



TO MOUNT 10 to 44 Lb. (4.5-20 kg) SPOOLS (12"/300 mm Diameter) or 14Lb.(6 Kg) Innershield Coils:

(For 13-14 lb. (6 Kg) Innershield coils, a K435 Coil Adapter must be used).

1. Open the Wire Drive Compartment Door
2. Depress the Release Bar on the Retaining Collar and remove it from the spindle.
3. Place the spool on the spindle making certain the spindle brake pin enters one of the holes in the back side of the spool (Note: an arrow mark on the spindle lines up with the brake holding pin to assist in lining up a hole). Be certain the wire comes off the reel in a direction so as to de-reel from the top of the coil.

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4. Re-install the Retaining Collar. Make sure that the Release Bar “pops up” and that the collar retainers fully engage the retaining ring groove on the spindle.

## FEEDING WIRE ELECTRODE

### WARNING

**When triggered, the electrode and drive mechanism are electrically “hot” relative to work and ground and remain “hot” several seconds after the gun trigger is released.**

-----

**NOTE:** Check that drive rolls, guide plates and gun parts are proper for the wire size and type being used. Refer to Table C.1 in ACCESSORIES section.

1. Turn the Readi-Reel or spool until the free end of the electrode is accessible.
2. While securely holding the electrode, cut off the bent end and straighten the first six inches. (If the electrode is not properly straightened, it may not feed properly through the wire drive system).
3. Release the pressure on the idle roll by swinging the adjustable pressure arm down toward the back of the machine. Lift the cast idle roll assembly and allow it to sit in an upright position. Leave the outer wire guide plate installed. Manually feed the wire through the incoming guide bushing and through the guide plates (over the drive roll groove). Push a sufficient wire length to assure that the wire has fed into the gun and cable assembly without restriction. Reposition the adjustable pressure arm to its original position to apply pressure to the wire.
4. Press gun trigger to feed the electrode wire through the gun.

## IDLE ROLL PRESSURE SETTING

The idle roll pressure adjustment knob is set at the factory at the #2 hash mark. This is an approximate setting. The optimum idle roll pressure varies with type of wire, wire diameter, surface conditions, lubrication, and hardness. As a general rule, hard wires may require greater pressure, and soft, or aluminum wire, may require less pressure than the factory setting. The optimum idle roll setting can be determined as follows:

1. Press end of gun against a solid object that is electrically isolated from the welder output and press the gun trigger for several seconds.
2. If the wire “birdnests”, jams or breaks at the drive roll, the idle roll pressure is too great. Back the adjustment knob out 1/2 turn, run new wire through gun, and repeat above steps.
3. If the only result was drive roll slippage, loosen the adjustment knob on the conductor plate and pull the gun cable forward about 6" (15 cm). There should be a slight waviness in the expose wire. If there is not waviness, the pressure is too low. Tighten the adjustment knob 1/4 turn, reinstall the gun cable and repeat the above steps.

## AVOIDING WIRE FEEDING PROBLEMS

Wire feeding problems can be avoided by observing the following gun handling procedures:

- a. Do not kink or pull cable around sharp corners.
- b. Keep the gun cable as straight as possible when welding or loading electrode through cable.
- c. Do not allow dolly wheels or trucks to run over cables.
- d. Keep cable clean by following maintenance instructions.
- e. Use only clean, rust-free electrode. Lincoln electrodes have proper surface lubrication.
- f. Replace the contact tip when the arc starts to become unstable or the contact tip end is fused or deformed.
- g. Keep wire reel spindle brake tension to the minimum required to prevent excess reel over-travel which may cause wire “loop-offs” from the coil.
- h. Use proper drive rolls and wire drive/idle roll pressure for wire size and type being used.

POWER MIG 350MP





# SPECIAL WELDING PROCESSES AVAILABLE ON THE POWER MIG 350MP

## PULSE WELDING (GMAW-P)

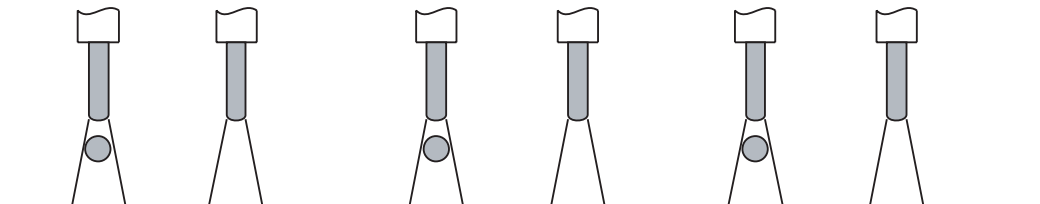
The pulsed-arc process is, by definition, a spray transfer process wherein spray transfer occurs in pulses at regularly spaced intervals. In the time between pulses, the welding current is reduced and no metal transfer occurs.

Pulsed-arc transfer is obtained by operating a power source between low and high current levels. The high current level or "pulse" forces an electrode drop to the workpiece. The low current level or "background" maintains the arc between pulses. (See Figure B.5).

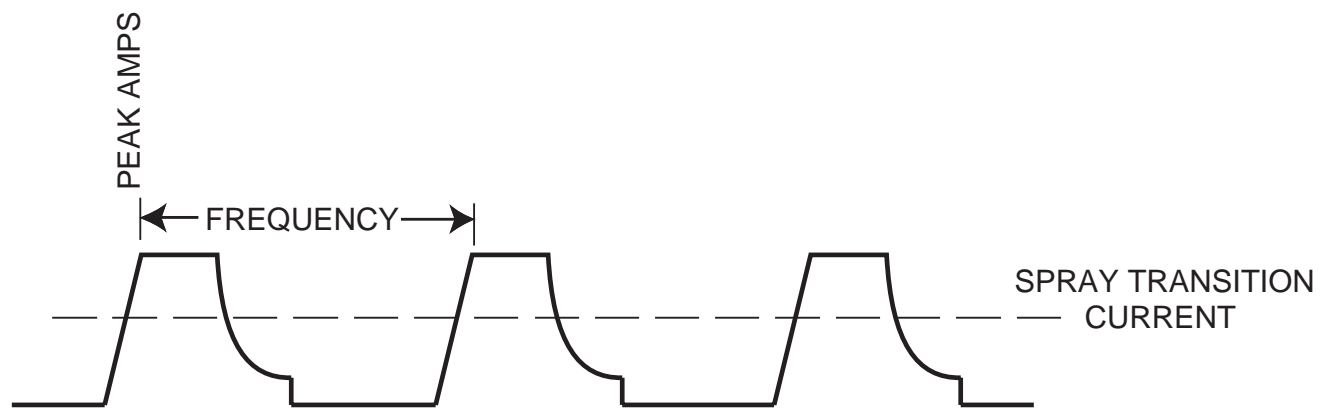
Pulsed MIG is an advanced form of welding that takes the best of all the other forms of transfer while minimizing or eliminating their disadvantages. Unlike short circuit, pulsed MIG does not create spatter or run the risk of cold lapping. The welding positions in pulsed MIG are not limited as they are with globular or spray and its wire use is definitely more efficient. Unlike the spray arc process, pulsing offers controlled heat input that allows better welding on thin materials, lower wire feed speeds and leads to less distortion and improved overall quality and appearance. This is especially important with stainless, nickel and other alloys that are sensitive to heat input.

In **GMAW-P mode**, arc control adjusts the background current and frequency of the wave. When arc control goes up, the frequency increases thus increasing the droplet transfer rate.

FIGURE B.5



EACH PULSE DELIVERS ONE DROPLET OF WELD MATERIAL



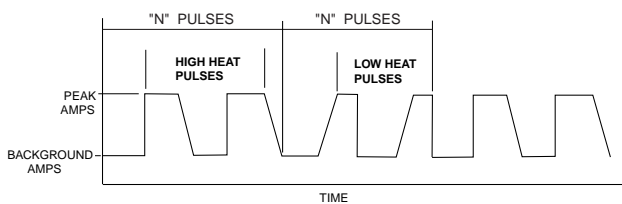
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**PULSE-ON-PULSE™ (GMAW-PP)**

Pulse on Pulse™ is a Lincoln process specifically designed for use in welding relatively thin (less than 1/4" thick) aluminum (See Table B.3). It gives weld beads with very consistent uniform ripple.

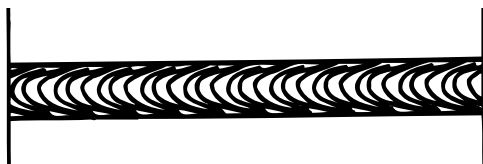
In Pulse on Pulse modes, two distinct pulse types are used, instead of the single pulse type normally used in GMAW-P. A number of high energy pulses are used to obtain spray transfer and transfer metal across the arc. Such pulses are shown in Figure B.6. After a number "N" of such pulses, depending on the wire feed speed used, an identical number "N" of low energy pulses are performed. These low energy pulses, shown in Figure B.6, do not transfer any filler metal across the arc and help to cool the arc and keep the heat input low.

**FIGURE B.6**



The Peak Current, Background Current, and Frequency are identical for the high energy and low energy pulses. In addition to cooling the weld down, the major effect of the low energy pulses is that they form a weld ripple. Since they occur at very regular time intervals, the weld bead obtained is very uniform with a very consistent ripple pattern. In fact, the bead has its best appearance if no oscillation of the welding gun ("whipping") is used. (See Figure B.7)

**FIGURE B.7**



When Arc Control is used in the Pulse on Pulse modes, it does the same things it does in the other pulsed modes: decreasing the Arc Control decreases the droplet transfer and weld deposition rate. Increasing the Arc Control increases the droplet transfer and weld deposition rate. Since Arc Control varies weld droplet transfer rate, the Arc Control can be used to vary the ripple spacing in the weld bead.

**BENEFITS OF PULSE ON PULSE FROM LINCOLN ELECTRIC**

- Excellent appearance of the weld bead
- Improved cleaning action
- Reduced porosity

Table B.3 shows WFS and Trim settings for common aluminum types and wire sizes when welding with Pulse-on-Pulse. The welds made to obtain the values in the table were fillet welds in the flat position. The values in the table can be helpful as a starting point to establish a welding procedure. From there, adjustments need to be made to set the proper procedure for each specific application (out-of-position, other types of joints, etc.).

The comments on Table B.3 show values of WFS below which it is not recommended to weld. The reason is, that below these values the weld transfer will change from a spray arc to a short-arc, which is not advisable when welding aluminum.

**WELDING PROCEDURES FOR PULSE-ON-PULSE (TABLE B.3)**

MATERIAL	Aluminum 4043	Aluminum 4043	Aluminum 5356	Aluminum 5356		
<b>GAS</b>	100% Ar.	100% Ar.	100% Ar.	100% Ar.		
<b>WIRE</b>	E4043	E4043	E5356	E5356		
<b>WIRE SIZE</b>	0.035	3/64	0.035	3/64		
<b>WELD MODE</b>	98	99	101	102		
<b>MATERIAL THICKNESS</b>	<b>WFS / TRIM</b>	14 ga.	250 / 1.0	200 / 1.0	230 / 1.0	225 / 1.0
		10 ga.	400 / 1.0	280 / 1.0	425 / 1.0	400 / 1.0
		3/16	550 / 1.0	340 / 1.0	670 / 1.0	500 / 1.0
		1/4	600 / 1.0	400 / 1.0	700 / 1.0	550 / 0.9
<b>COMMENTS</b>	Not Recommended below 200 WFS	Not Recommended below 100 WFS	Not Recommended below 200 WFS	Not Recommended below 200 WFS		

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**POWER MODE™**

The Power Mode™ process was developed by Lincoln to maintain a stable and smooth arc at low procedure settings which are needed to weld thin metal without pop-outs or burning-through. For Aluminum welding, it provides excellent control and the ability to maintain constant arc length. This results in improved welding performance in two primary types of applications.

- Short Arc MIG at low procedure settings.
- Aluminum MIG welding.

Power Mode™ is a method of high speed regulation of the output power whenever an arc is established. It provides a fast response to changes in the arc. The higher the Power Mode Setting, the longer the arc. If a welding procedure is not established, the best way to determine the Power Mode Setting is by experimentation until the desired output result is established.

In the Power Mode two variables need to be set:

- Wire Feed Speed
- Power Mode Trim

Setting up a Power Mode procedure is similar to setting a CV MIG procedure. Select a shielding gas appropriate for a short arc process.

- For steel, use 75/25 Ar/CO<sub>2</sub> shield gas.
- For Stainless, select a Helium blend Tri-Mix.
- For Aluminum, use 100% Ar.

Start by setting the wire feed speed based upon material thickness and appropriate travel speed. Then adjust the Volts/Trim knob as follows:

- For steel, listen for the traditional “frying egg” sound of a good short-arc MIG procedure to know you have the process set correctly.
- For aluminum, simply adjust the Volts/Trim knob until the desired arc length is obtained.

Note the Volts/Trim display is simply a relative number and DOES NOT correspond to voltage.

Some procedure recommendations appear in Table B.4.

Recommended Welding Procedures for Power Mode - Table B.4

MATERIAL	Aluminum 4043	Aluminum 5356	Mild Steel	Mild Steel	Mild Steel	Mild Steel	Mild Steel	Mild Steel	Mild Steel	Stainless Steel	Stainless Steel
WIRE	E4043	E5356	L56	L56	L56	L56	L56	L56	L56	E308L	E308L
WIRE SIZE	0.035	0.035	0.025	0.025	0.030	0.030	0.035	0.035	0.035	0.030	0.035
GAS	100% Ar.	100% Ar.	100% CO <sub>2</sub>	75/25 Ar/CO <sub>2</sub>	100% CO <sub>2</sub>	75/25 Ar/CO <sub>2</sub>	100% CO <sub>2</sub>	75/25 Ar/CO <sub>2</sub>	100% CO <sub>2</sub>	Tri-mix	Tri-mix
MATERIAL THICKNESS WFS / POWER MODE SETTING	22 ga.		Not Recommended	100 / 0.8	Not Recommended	90 / 1.0					
	20 ga.		120 / 1.0	120 / 1.0	100 / 0.7	100 / 1.0			80 / 1.5	50 / 0.5	
	18 ga.		140 / 1.7	140 / 1.5	110 / 1.5	110 / 1.5	100 / 2.5	100 / 2.5	110 / 2.0	110 / 2.0	
	16 ga.		190 / 2.0	190 / 2.0	125 / 2.0	125 / 2.0	125 / 3.0	125 / 3.0	140 / 2.5	130 / 2.7	
	14 ga.	400 / 2.0	400 / 2.5	260 / 3.0	260 / 3.0	160 / 2.3	160 / 2.3	160 / 3.8	160 / 3.5	210 / 3.0	190 / 3.5
	12 ga.			330 / 5.0	330 / 4.5	230 / 3.5	230 / 3.5	200 / 5.0	200 / 4.5	270 / 5.0	230 / 6.0
	10 ga.	500 / 7.0	500 / 7.0			300 / 6.0	300 / 6.0	240 / 6.5	240 / 7.0	325 / 6.5	300 / 7.0
	3/16	570 / 9.0	600 / 7.8			400 / 7.5	400 / 7.0				
1/4	700 / 9.1	700 / 8.5									
COMMENTS	Not Recommended below 400 WFS	Not Recommended below 400 WFS									

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## DRIVE ROLL KITS

Refer to Table C.1 for various drive roll kits that are available for the Power MIG. All items in **Bold** are supplied standard with the Power MIG.

TABLE C.1

Wire	Size	Drive Roll Kit
Solid Steel	.023"-.030" (0.6-0.8 mm)	KP1696-030S
	<b>.035" (0.9 mm)</b>	<b>KP1696-035S</b>
	<b>.045" (1.2 mm)</b>	<b>KP1696-045S</b>
	.040" (1.0mm)	KP-1696-2
Cored	.035-.045" (0.9-0.2mm)	KP-1696-1
	.035" (0.9 mm)	KP1697-035C
Aluminum	.045" (1.2 mm)	KP1697-045C
	3/64" (1.2 mm)	KP1695-3/64A

\*.035 Aluminum recommended for Push-Pull systems only.

## 3/64" (1.2 mm) ALUMINUM FEEDING KIT (K2153-1)

This kit helps push feeding aluminum through standard machine feeder and gun. It provides gun and wire drive conversion parts to weld with 3/64" (1.2 mm) aluminum wire. 5356 alloy aluminum wire is recommended for best push feeding performance.

Kit includes drive rolls and wire guide plate for the wire drive, liner and two contact tips for the gun, along with installation instructions.

## K363P READI-REEL ADAPTER

The K363P Readi-Reel Adapter mounts to the 2" spindle. It is needed to mount the 22-30 lb. Readi-Reels.

## DUAL CYLINDER MOUNTING KIT (K1702-1)

Permits stable side-by-side mounting of two full size (9" dia. x 5' high) gas cylinders with "no lift" loading. Simple installation and easy instructions provided. Includes upper and lower cylinder supports, wheel axles and mounting hardware.

## ALTERNATIVE MAGNUM GMAW GUN AND CABLE ASSEMBLIES

The following Magnum 350MP gun and cable assemblies are separately available for use with the Power MIG 350MP. Each is rated 300 amps 60% duty cycle (or 300 amps 40% duty) and is equipped with the integrated connector, twist-lock trigger connector, fixed nozzle and insulator, and includes a liner, diffuser, and contact tips for the wire sizes specified:

Length	Part No.	English Wire Size	Metric Wire Size
10' (3.0 m)	K470-1	.035 – .045"	0.9 – 1.2 mm
12' (3.6 m)	K470-7		
15' (4.5 m)	K470-3		

## MAGNUM GUN CONNECTION KIT (Optional K466-6)

Using the optional K466-6 Magnum Connection kit for the Power MIG permits use of standard Magnum 200, 300 or 400 gun and cable assemblies.

## K1692-2 SPOOL GUN (PRINCE™ XL)

When the Power MIG Gun Selector Switch is in the "Standard / Spool Gun" position, the Power MIG provides gun trigger switch transfer between the Magnum gun or the spool gun for the same polarity welding with different wire and gas processes.

### CAUTION

**Closing either gun trigger will cause the electrode of both guns to be electrically "HOT". Be sure unused gun is positioned so electrode or tip will not contact metal case or other metal common to work.**

Because the control circuitry senses each gun through its trigger leads, weld parameters are displayed and adjustable for the last gun that was triggered.

- Pulling the trigger for the built-in feeder gun (Magnum 300):**
    - Disables spool gun operation.
    - Changes the displays of the Power MIG 350MP to correspond to feeder gun operation.
    - Closing feeder gun trigger starts feeder gun welding and makes both electrodes electrically "HOT".
  - Pulling SPOOL GUN Trigger:**
    - Disables built-in feeder gun operation.
    - Changes the displays of the Power MIG 350MP to correspond to Spool Gun operation.
    - Closing spool gun trigger starts spool gun welding and makes both electrodes electrically "HOT".
  - Operation with Power MIG 300:**
    - Install the spool gun per the installation instructions
    - Turn the Power MIG 350MP input power ON.
    - Make sure that the Gun Selector Switch is in the "Standard / Spool Gun" position.
    - Pull and release the trigger of the Spool Gun. The Power Mig recognizes the spool gun as active and weld parameters are adjustable for welding with the Spool Gun
- Non-Synergic Weld Modes (Mode 5)**

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- Voltage is adjustable at the power source. The right control knob on the power source will adjust the voltage that is displayed in the meter directly above it.
- The left Display (WFS / AMPS) on the Power MIG 350MP will have 4 dashes (----) to indicate that the left control knob on the power source is inactive. Wire Feed Speed is set at the Spool Gun.
- The following procedure settings for Aluminum 4043 can be used as initial settings for making test welds to determine final settings:

Wire Dia. In. (mm)	WFS Setting Spool Gun	Arc Voltage Setting
.030" (.8 mm)	270	15V
.035" (.9 mm)	250	16V
3/64" (1.2 mm)	240	20V

#### 4. Synergic Weld Modes

The Power MIG 350MP is designed to enable synergic weld modes and synergic pulse processes with the spool gun. The actual wire feed speed (WFS) of the spool gun must be measured and manually set on the Power MIG 350MP as a work point for the Power MIG 350MP (SPD).

- In synergic modes when the spool gun trigger is pulled, an adjustable value for the SPD work point is displayed in the left meter. The letters SPD are displayed in the right meter.
- The left control knob adjusts the SPD value. The right control knob is inactive.
- Measure the actual WFS, in inches per minute, at the spool gun and set the SPD at the Power MIG 350MP to match this value. WFS can be measured by pulling the trigger of the spool gun and feeding wire for 6 seconds. Measure the length of wire (in inches) that was fed and multiply by 10.
- The Power MIG 350MP is now configured and ready to weld in the synergic mode.
- Adjustment of the SPD value from the set value has the affect of adjusting trim or arc length.
- To increase the arc length; increase the SPD value at the Power MIG 350MP to a value higher than the actual WFS.

**Remember; do not change the WFS at the spool gun.**

- To decrease the arc length; decrease the SPD value at the Power MIG 350MP to a value lower than the actual WFS.

**Remember: The dialed in SPD value at the Power**

**MIG 350MP does not control the WFS at the spool gun. Rather, it is adjusting the Power MIG 350MP synergic work point. Therefore, adjusting the SPD value will not change your actual WFS at the spool gun. WFS can only be changed at the spool gun.**

#### PUSH-PULL FEEDING CONNECTION ADAPTER KIT (K2154-1)

The push-pull adapter kit provides direct connection of a Cobra Gold or Prince XL torch to the Power MIG 350MP wire feeder welder.

The kit is intended for use with the following Cobra Gold or Prince XL torches:

##### Cobra Gold

Air Cooled 15'(5m)	K1589-1	Water-Cooled 15'(5m)	K1590-1
Air Cooled 25'(8m)	K1589-2	Water-Cooled 25'(8m)	K1590-2
Air Cooled 50'(15m)	K1589-3	Water-Cooled 50'(15m)	K1590-3

##### Prince XL

Air Cooled 15'(5m)	K1591-1	Water-Cooled 15'(5m)	K1592-1
Air Cooled 25'(8m)	K1591-2	Water-Cooled 25'(8m)	K1592-2
Air Cooled 50'(15m)	K1591-3	Water-Cooled 50'(15m)	K1592-3

### CAUTION

**Remove all input power to the Power MIG 350MP before installing the Connection Adapter Kit.**

### WARNING

**Refer to the Owner's Manual of the Torch for Amperage and Duty Cycle rating information. The torch rating may not match the rating of the power source.**

#### MAKING A WELD WITH THE PRINCE XL OR COBRA GOLD TORCH INSTALLED

- Set the idle roll pressure on the wire drive between an indicator reading of 0-2. A recommended start point is 1.5.
- Set the Gun Selection toggle switch located inside the wire drive compartment directly above the push-pull control cable connector to "PUSH-PULL GUN."
- Depending on the weld mode, set the Voltage or Trim at the Power MIG 350MP using the right control knob located on the upper case front panel.
- The Wire Feed Speed (WFS) is set using the control knob on the Torch. The left control knob on the POWER MIG 350MP is inactive. The actual WFS being set at the torch is displayed on the Power MIG 350MP.
- All weld parameters normally available for the active weld mode are available during push-pull operation. Refer to the Operation Section of this manual.

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## SAFETY PRECAUTIONS

### WARNING



#### **ELECTRIC SHOCK can kill.**

- Have an electrician install and service this equipment.
- Turn the input power off at the fuse box before working on equipment
- Do not touch electrically hot parts.

## GENERAL MAINTENANCE

In extremely dusty locations, dirt may clog the air passages causing the welder to run hot. Blow dirt out of the welder with low-pressure air at regular intervals to eliminate excessive dirt and dust build-up on internal parts.

The fan motors have sealed ball bearings which require no service.

## DRIVE ROLLS AND GUIDE PLATES

After every coil of wire, inspect the wire drive mechanism. Clean it as necessary by blowing with low pressure compressed air. Do not use solvents for cleaning the idle roll because it may wash the lubricant out of the bearing. All drive rolls are stamped with the wire sizes they will feed. If a wire size other than that stamped on the roll is used, the drive roll must be changed.

For instructions on replacing or changing drive roll, see "Wire Drive Rolls" in Operation section.

## CONTACT TIP AND GAS NOZZLE INSTALLATION

- a. Choose the correct size contact tip for the electrode being used (wire size is stenciled on the side of the contact tip) and screw it snugly into the gas diffuser.
- b. Be sure the nozzle insulator is fully screwed onto the gun tube and does not block the gas holes in the diffuser. (**NOTE:** Insulator is not required when using the optional fixed gas nozzles.)
- c. Slip the appropriate gas nozzle onto the nozzle insulator. Adjustable gas nozzles are available with a .62" (15.9 mm) or .50" (12.7 mm) I.D., and in both standard (flush) and recessed design. The proper nozzle should be selected based on the welding application. Different length fixed nozzles are also available to fit 300 and 400 amp gun tubes to allow either spray or short-circuiting transfer welding.

Choose the gas nozzle as appropriate for the GMAW process to be used. Typically, the contact tip end should be flush to .12" (3.1 mm) extended for the short-circuiting transfer process and .12" (3.1 mm) recessed for spray transfer. For the Outershield (FCAW) process, 1/8" (3 mm) recess is recommended.

## GUN TUBES AND NOZZLES

- a. Replace worn contact tips as required.
- b. Remove spatter from inside of gas nozzle and from tip after each 10 minutes of arc time or as required.

## GUN CABLE CLEANING

To help prevent feeding problems, clean cable liner after using approximately 300 pounds (136 kg) of electrode. Remove the cable from the wire feeder and lay it out straight on the floor. Remove the contact tip from the gun. Using an air hose and only partial pressure, gently blow out the cable liner from the gas diffuser end.

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## ⚠ CAUTION

Excessive pressure at the start may cause the dirt to form a plug.

Flex the cable over its entire length and again blow out the cable. Repeat this procedure until no further dirt comes out. If this has been done and feed problems are experienced, try liner replacement, and refer to trouble shooting section on rough wire feeding.

## LINER REMOVAL AND REPLACEMENT (SEE FIGURE D.1)

### LINER REMOVAL, INSTALLATION AND TRIMMING INSTRUCTIONS FOR MAGNUM 300

NOTE: The variation in cable lengths prevents the interchangeability of liners between guns. Once a liner has been cut for a particular gun, it should not be installed in another gun unless it can meet the liner cutoff length requirement. Liners are shipped with the jacket of the liner extended the proper amount.

1. Remove the gas nozzle.
2. Remove the gas diffuser from the gun tube. If gas diffuser contains a small set screw, loosen the set screw.
3. Lay gun and cable out straight on a flat surface. Loosen set screw of the connector on the back end of the gun.
4. Insert the untrimmed Liner into the back end of the gun.

5. Seat Liner bushing into back of gun. Secure Liner by tightening set screw. Do not install the gas diffuser at this time.

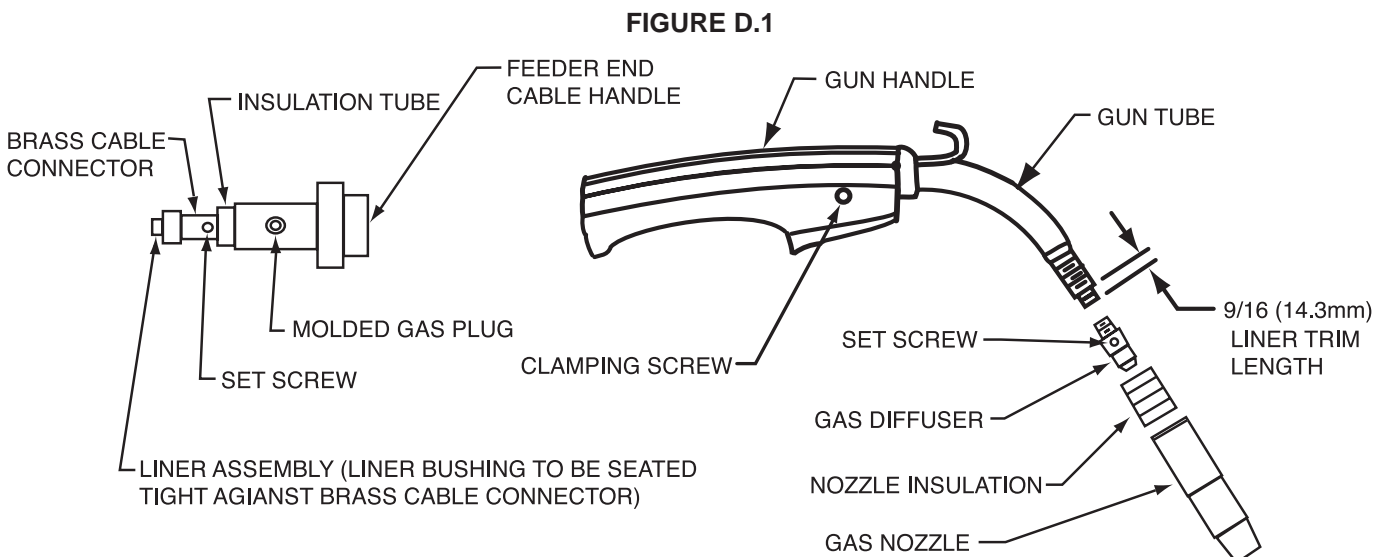
6. Lay the cable straight and trim Liner to 9/16". Remove burrs.

7. Secure the gas diffuser into the tube.

8. Tighten the set screw against the Liner.

## ⚠ CAUTION

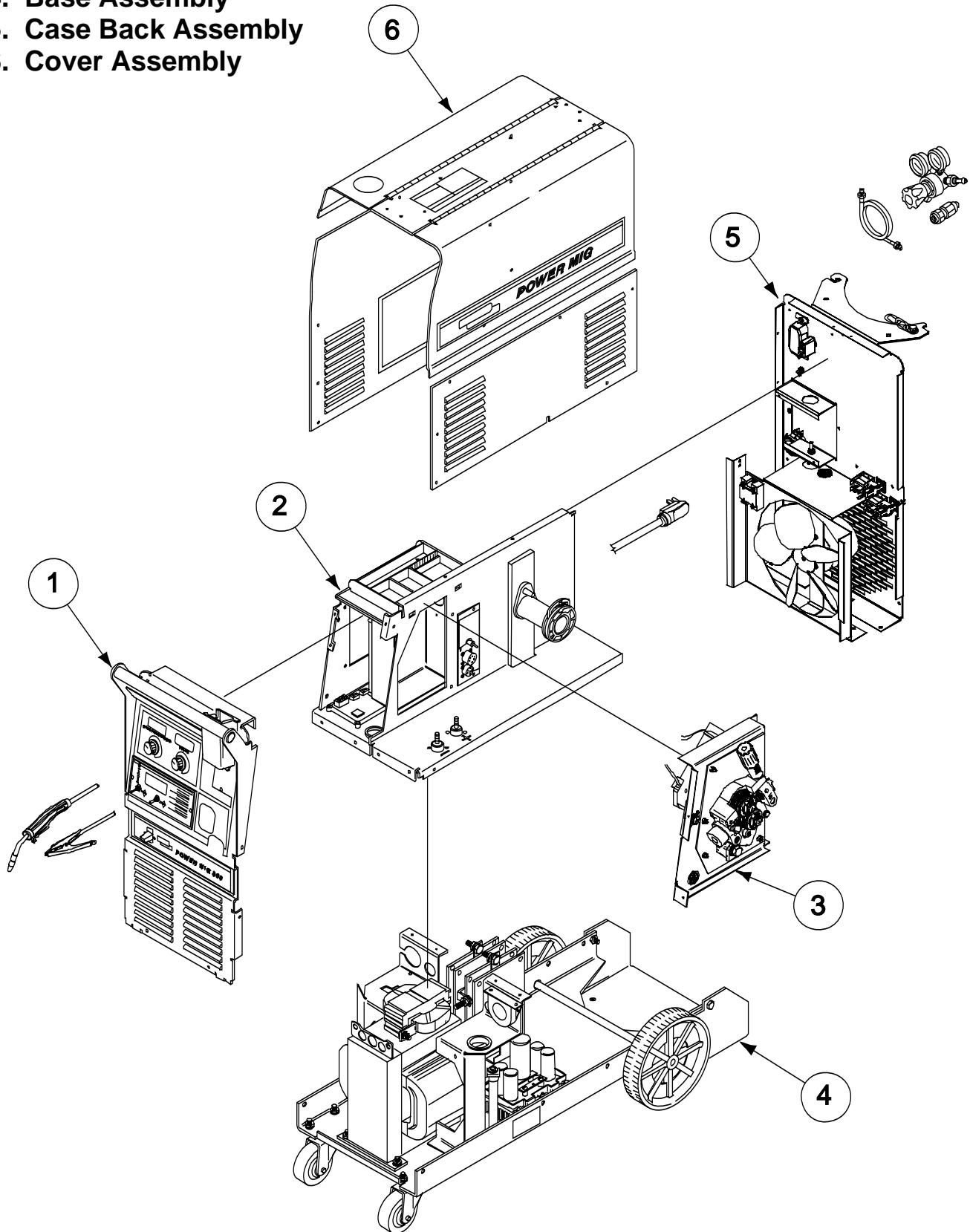
This screw should only be gently tightened. Over tightening will split or collapse the liner and cause poor wire feeding.



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**LINCOLN**  
ELECTRIC

- 1. Case Front Assembly
- 2. Center Assembly
- 3. Wire Drive Assembly
- 4. Base Assembly
- 5. Case Back Assembly
- 6. Cover Assembly



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Thermal Protection, Over Current Protection, and Wire Feeder

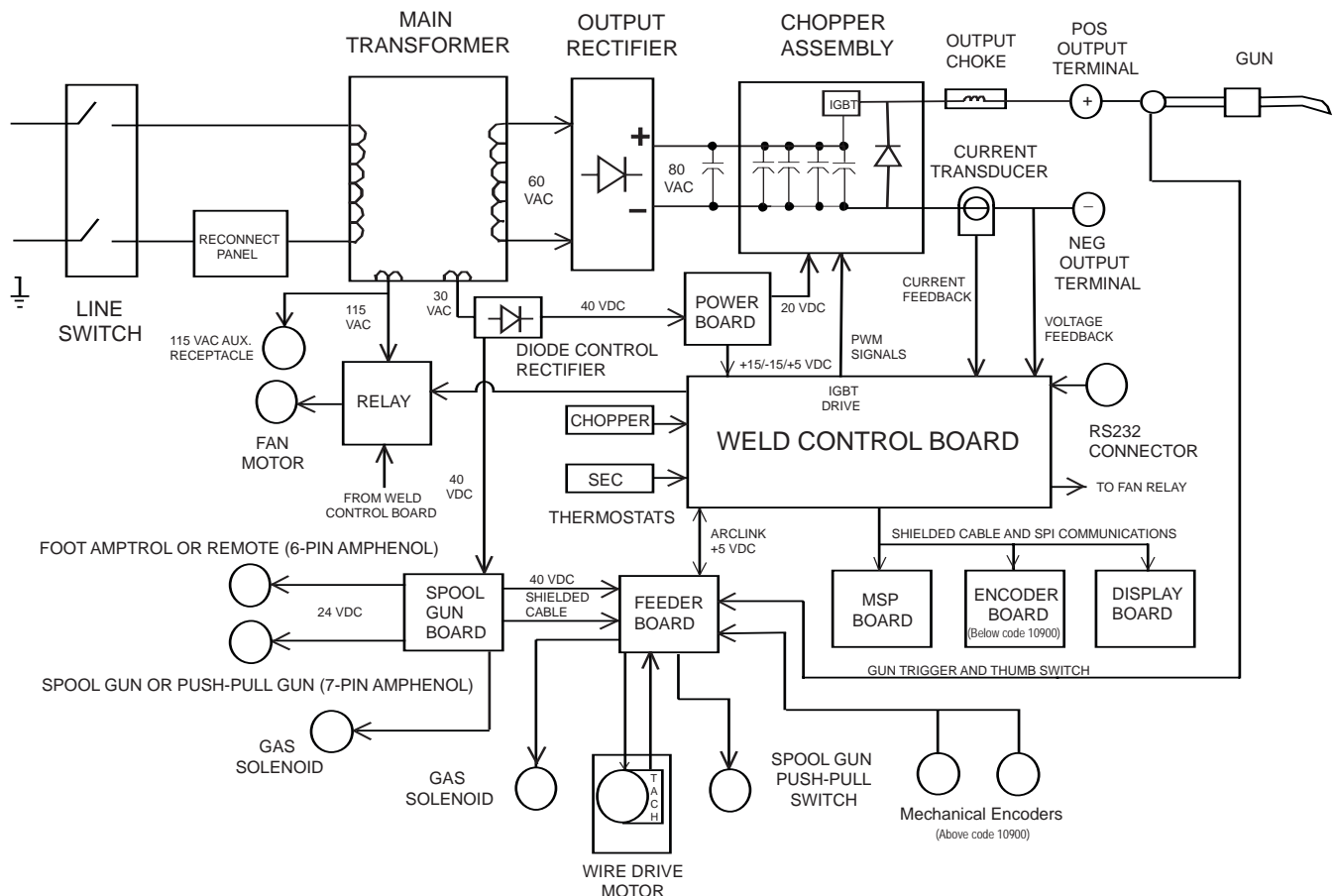
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**FIGURE E.1 – POWER MIG 350MP BLOCK LOGIC DIAGRAM**



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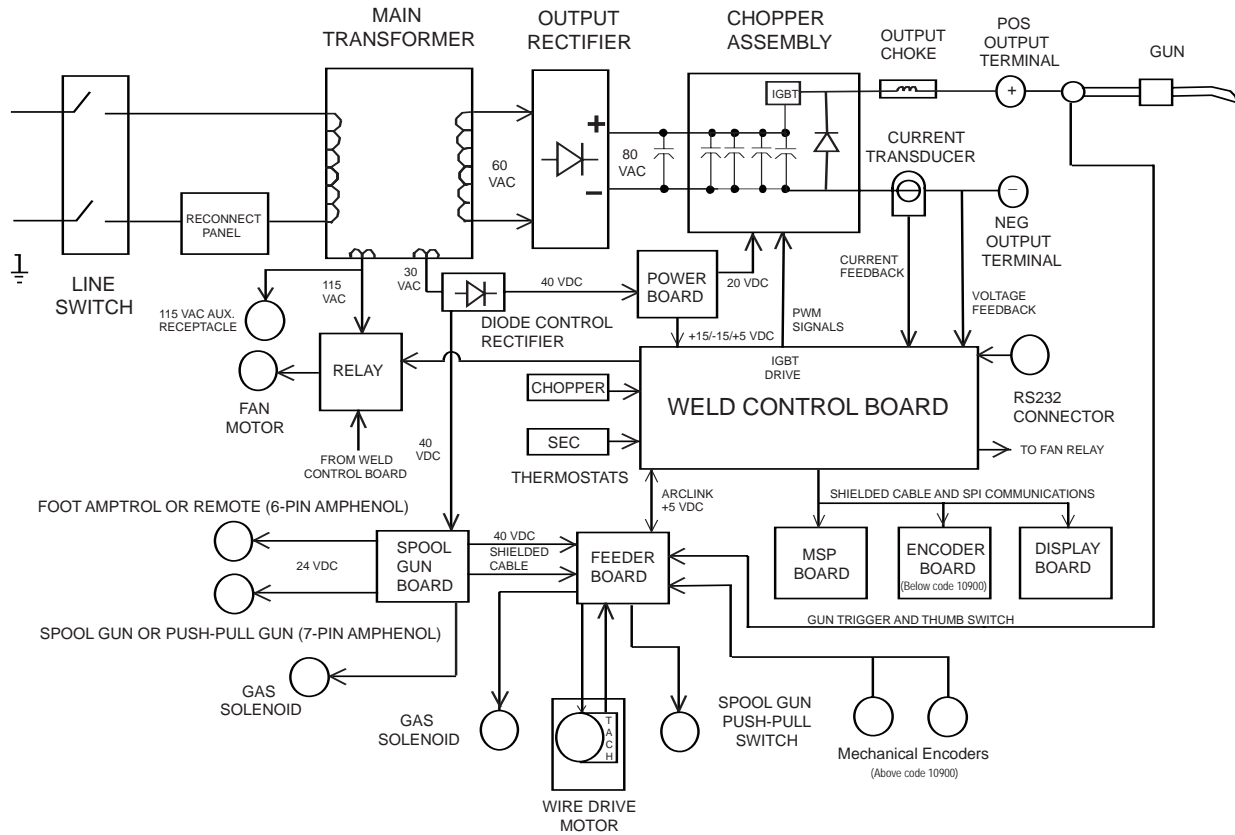
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# THEORY OF OPERATION

## FIGURE E.2 – GENERAL DESCRIPTION



## GENERAL DESCRIPTION

The Power MIG 350MP is a complete semiautomatic, multi-process DC arc welding machine offering CV and CC DC welding. It is rated for 350 amps, 32 volts, at 60% duty cycle. The standard machine is equipped to weld CC Stick, CC-GTAW, CV-FCAW, and synergic and non-synergic CV GMAW/GMAW-P, Pulse-on-Pulse, and Power Mode welding processes.

The digital microcomputer based control system allows easy and accurate adjustment of weld parameters through the multi-process panel located on the front of the machine. The Power MIG 350MP is equipped with a 6-pin connector for a foot amptrol or remotes and a 7-pin connector to allow operation of a spool gun or a push-pull gun for feeding aluminum wires.

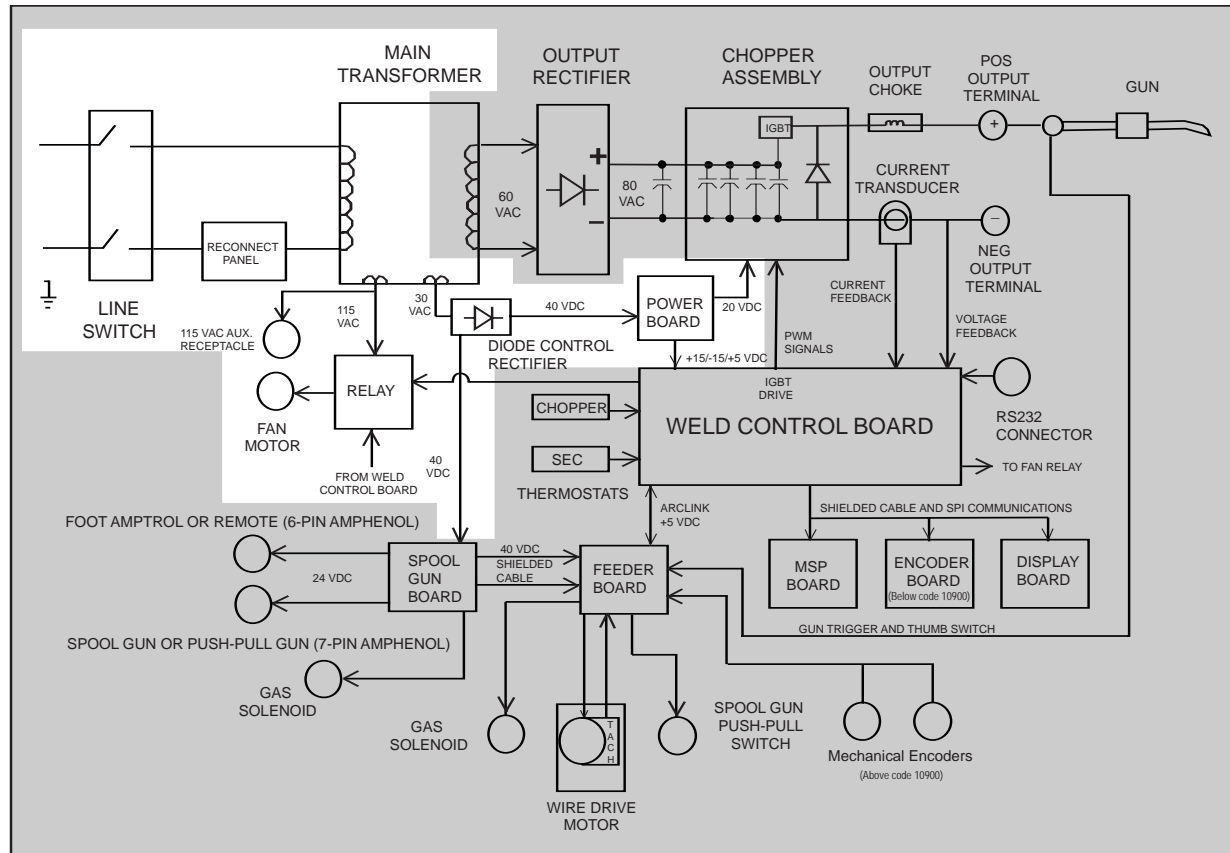
**NOTE:** Unshaded areas of Block Logic Diagram are the subject of discussion.

### POWER MIG 350MP





FIGURE E.3 – INPUT VOLTAGE AND MAIN TRANSFORMER



## INPUT VOLTAGE AND MAIN TRANSFORMER

Single-phase input power is brought into the rear of the Power MIG 350MP through a three-prong plug and input cable. A reconnect panel, also located on the rear of the machine, allows the user to configure the Power MIG 350MP for either 230V, 460V, or 575V input supply power. An ON/OFF line switch is located on the front panel. When the line switch is ON, AC input voltage is applied to the primary winding of the main transformer. The main transformer converts the high voltage, low current input power to a low voltage, high current output. The main transformer also has two isolated auxiliary windings. One supplies 30 VAC to a Diode Control Rectifier, which converts the 30 VAC to 40 VDC to supply the Power Board and the Spool Gun Board. The Power Board in turn supplies 20

VDC to the Chopper Board and +15 VDC, -15 VDC and +5 VDC to the Weld Control Board circuitry. The other auxiliary winding provides 115 VAC to operate a thermostatically controlled fan motor through a relay, which also receives signals from the Weld Control Board. The fan is designed to come on automatically when the trigger is pulled. The fan will stay on as needed for a minimum of six minutes after the weld arc is terminated. The fan will also stay on when the machine's welding and feeding are disabled during thermostatic over-temperature protection. The 115 VAC auxiliary receptacle also supplies power to the 115 VAC auxiliary receptacle located on the back of the machine. This offers 15 amps of auxiliary power. (**See Thermal and Overload Protection**)

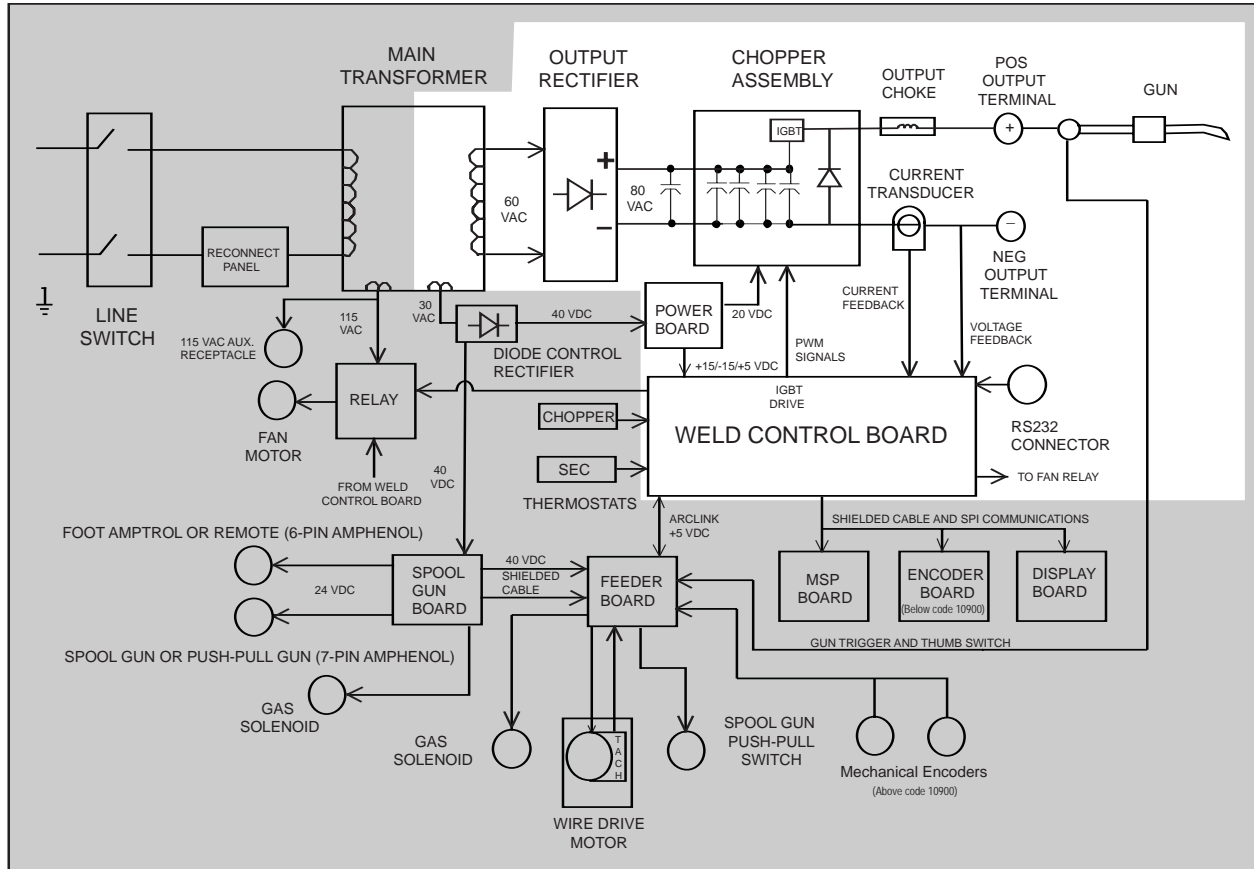
**NOTE:** Unshaded areas of Block Logic Diagram are the subject of discussion.

### POWER MIG 350MP



# THEORY OF OPERATION

FIGURE E.4 – OUTPUT RECTIFIER, CHOPPER ASSEMBLY AND FEEDBACK



## OUTPUT RECTIFIER, CHOPPER ASSEMBLY AND FEEDBACK

The 60 VAC output from the main transformer secondary is connected to an output rectifier. The resultant 80 VDC is applied to four parallel capacitors incorporated within the Chopper Assembly. These capacitors function as filters and also as power supplies for the insulated gate bipolar transistors or IGBT. See **IGBT Operation** in this section. The IGBT acts as a high-speed switch operating at 20KHZ. This device is switched on and off by the Weld Control Board through pulse width modulation circuitry. See **Pulse Width Modulation** in this section. This "chopped" DC output is applied through an output choke coil to the positive output terminal and through a current transducer to the negative output terminal. The choke functions as a current filter. A free-wheeling diode is incorporated in the Chopper Assembly to provide a current path for the stored energy in the choke when the IGBT is turned off. See **Chopper Technology Fundamentals** in this section.

Output voltage and current feedback information is fed to the Weld Control Board. This information is sensed from the current transducer and voltage sense circuitry on the output terminal circuits. If current or voltage become abnormally high, the Weld Control Board will shut off the IGBTs, thus disabling the machine's output.

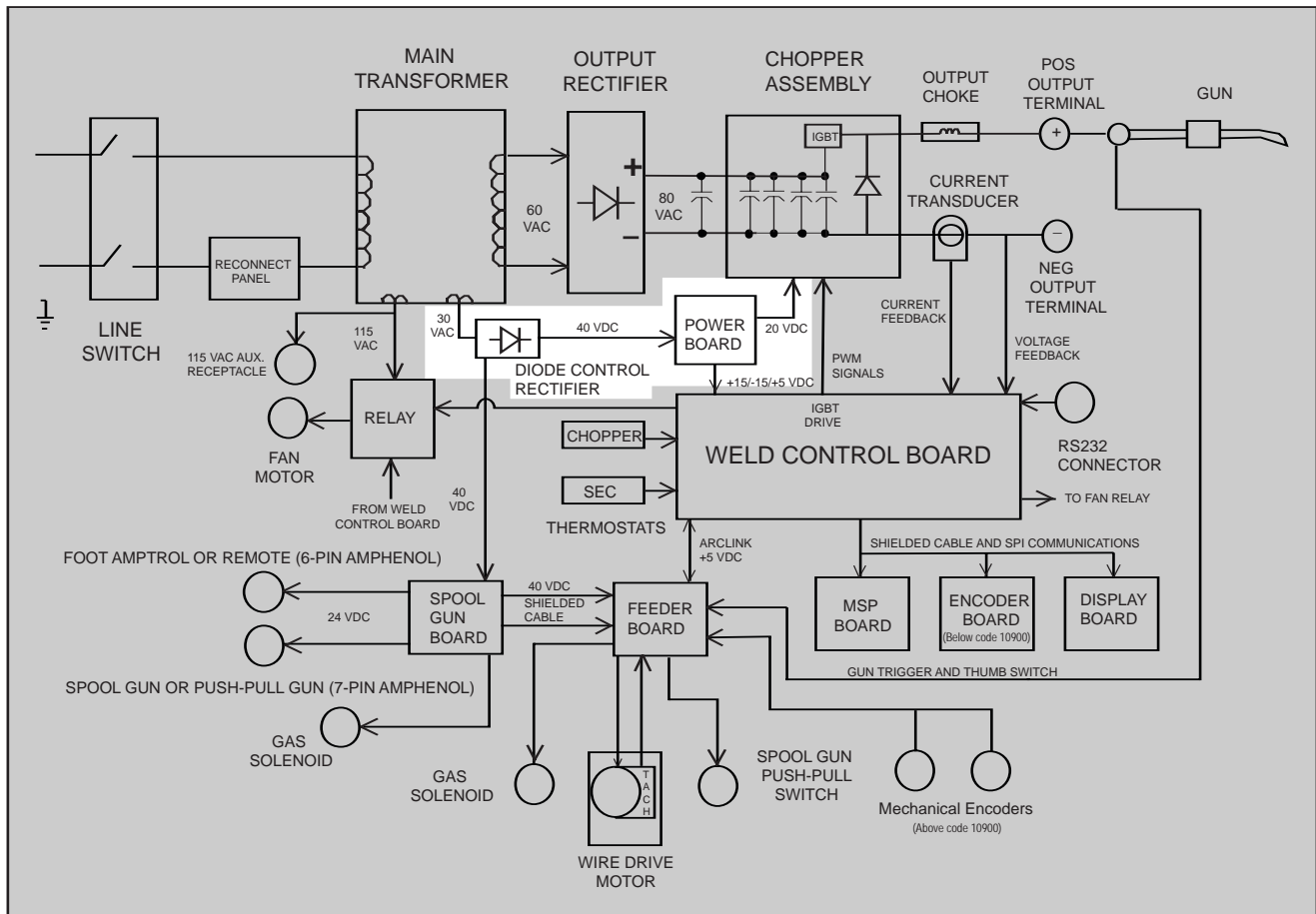
**NOTE:** Unshaded areas of Block Logic Diagram are the subject of discussion.

POWER MIG 350MP



# THEORY OF OPERATION

## FIGURE E.5 – DIODE CONTROL RECTIFIER AND POWER BOARD



## DIODE CONTROL RECTIFIER AND POWER BOARD

The Power Board receives approximately 40 VDC from the Diode Control Rectifier. In turn, the Power Board supplies a variety of regulated DC voltages to the Weld Control Board, which it uses to power its many circuits and communication functions. The Power Board also supplies +20 VDC to the Chopper Assembly.

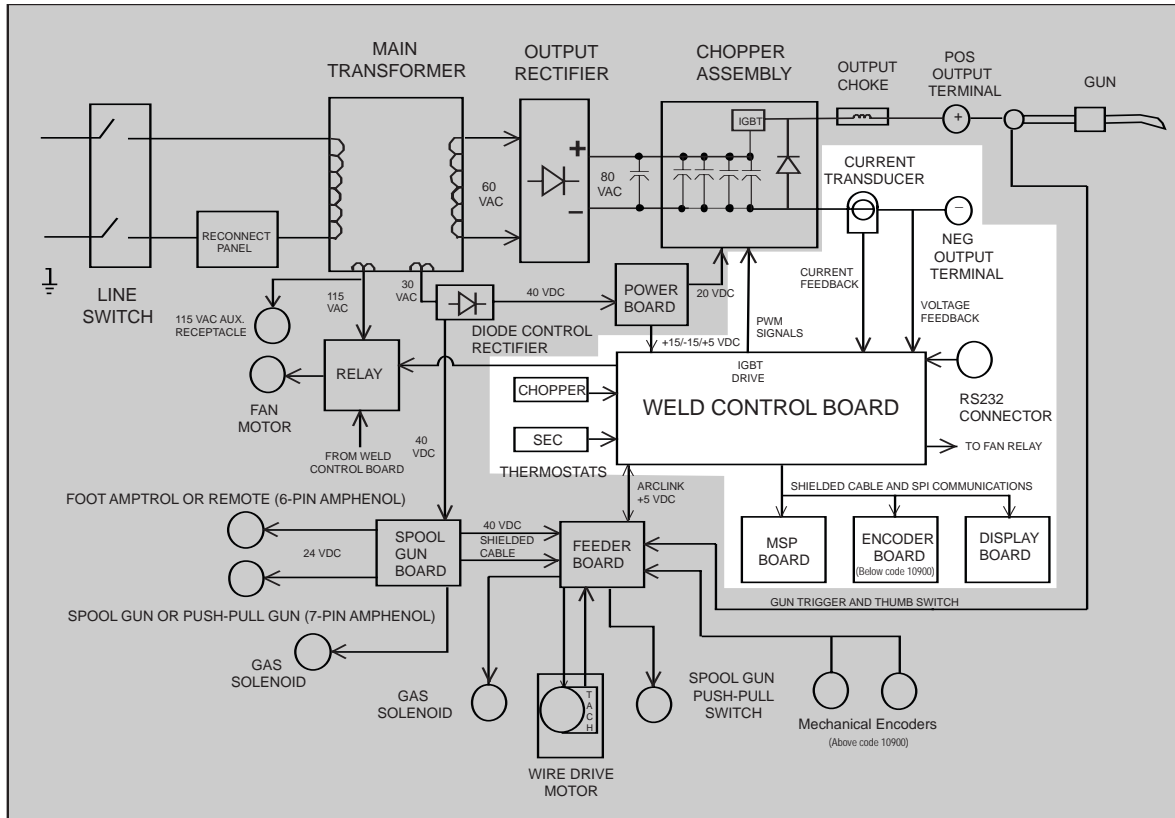
**NOTE:** Unshaded areas of Block Logic Diagram are the subject of discussion.

POWER MIG 350MP



# THEORY OF OPERATION

## FIGURE E.6 – WELD CONTROL BOARD



## WELD CONTROL BOARD

The Weld Control Board performs the primary interfacing functions to establish and maintain output control of the Power MIG 350MP machine. The function generator and weld files reside within the Weld Control Board hardware and software. Digital command signals and feedback information from other machine components are received and processed at the Weld Control Board. Software within the Weld Control Board processes the command and feedback information and sends the appropriate pulse width modulation (PWM) signals to the Chopper Assembly IGBT. (See **Pulse Width Modulation** in this section.) In this manner, a digitally controlled high-speed welding waveform is created.

In addition, the Weld Control Board monitors the Chopper thermostat and the Main Transformer secondary winding thermostat. In the event of a fault condition, the Weld Control Board will activate the thermal light and will disable or reduce the machine output.

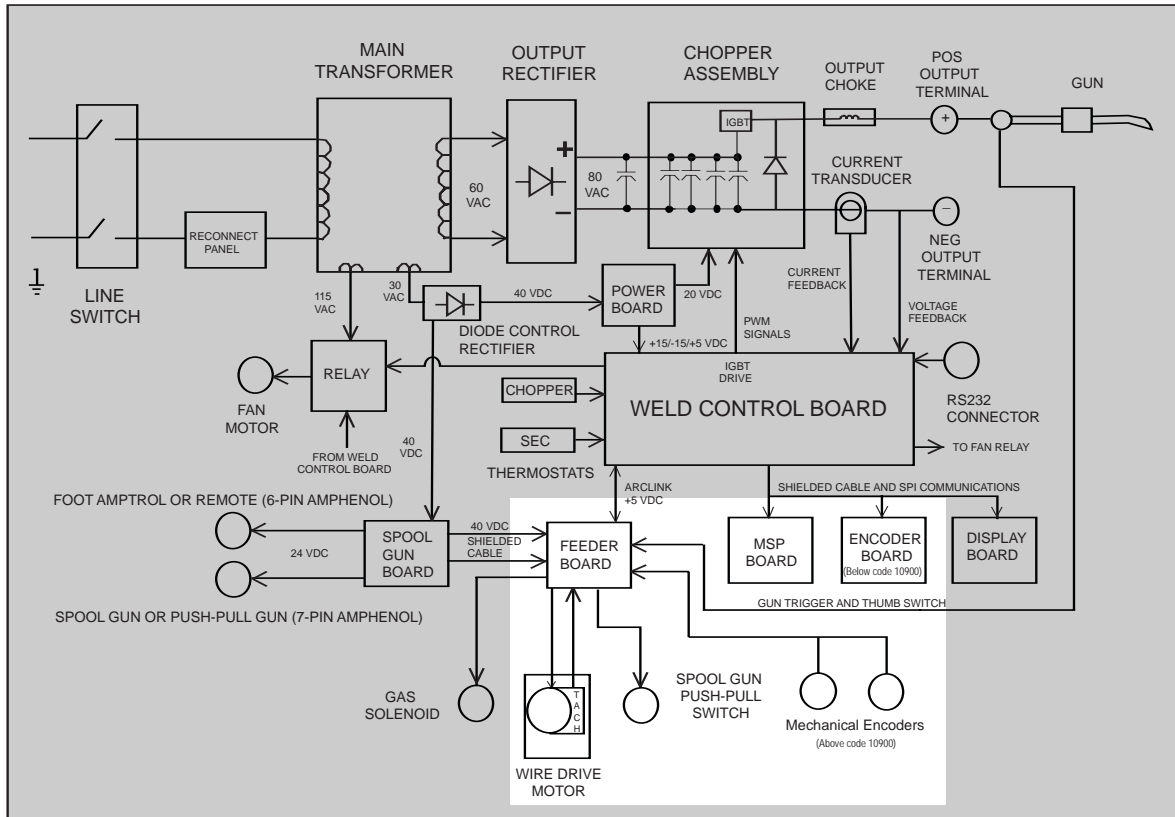
**NOTE:** Unshaded areas of Block Logic Diagram are the subject of discussion.

POWER MIG 350MP



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FIGURE E.7 – WIRE DRIVE MOTOR AND FEEDBACK



## WIRE DRIVE MOTOR AND FEEDBACK

The Wire Drive Motor is controlled by the Feeder Board and the Weld Control Board. A motor speed feedback signal is generated at the motor Tach and sent to the Feeder Board, which compares this feedback signal to the commands from the Encoder. It then sends the appropriate armature voltage to the Wire Drive Motor. This controlled wire drive speed in turn regulates the electrode wire feed speed through the gun.

**NOTE:** Unshaded areas of Block Logic Diagram are the subject of discussion.

POWER MIG 350MP



# THEORY OF OPERATION

## THERMAL PROTECTION

Two normally closed (NC) thermostats protect the machine from excessive operating temperatures. These thermostats are wired in series and are connected to the Weld Control Board. One of the thermostats is located on the Chopper Assembly Board, and one is on the secondary of the Main Transformer. Excessive temperatures may be caused by a lack of cooling air or by operating the machine beyond its duty cycle or output rating. If excessive operating temperatures should occur, the thermostats will prevent output from the machine. The yellow thermal light, located on the front of the machine, will be illuminated. The thermostats are self resetting once the machine cools sufficiently. If the thermostat shutdown was caused by excessive output or duty cycle and the fan is operating normally, the power switch may be left on and the reset should occur within a 15-minute period. If the fan is not turning or the intake air louvers are obstructed, the power must be removed from the machine and the fan condition or air obstruction corrected. The cooling fan runs only when necessary. The F.A.N. (fan as needed) system is controlled by the Weld Control Board via solid state relay.

## OVER CURRENT PROTECTION

If the average current exceeds 375 amps, the peak current will be limited to 100 amps until the system is re-triggered or the average current decreases to under 50 amps.

## WIRE FEEDER OVERLOAD PROTECTION

The Power MIG 350MP wire drive motor has its own solid state overload protection. If the motor becomes overloaded, the protection circuitry turns off the wire feed and the gas solenoid. Overload may result from improperly sized tip liner and drive rolls, obstructions or bends in the gun cable, and any other factors that would impede the wire feeding. To resume welding, simply pull the gun trigger. There is no circuit breaker to reset, as the protection is provided by reliable solid state electronics.

POWER MIG 350MP

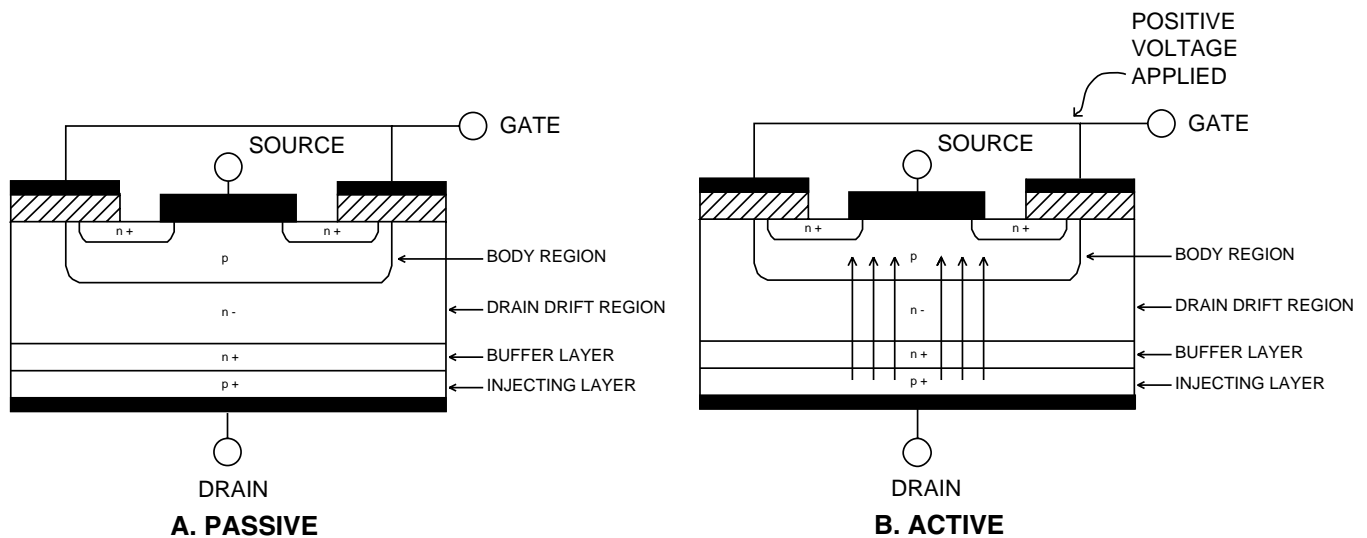


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# THEORY OF OPERATION

FIGURE E.8 – IGBT OPERATION



## INSULATED GATE BIPOLAR TRANSISTOR (IGBT) OPERATION

An IGBT is a type of transistor. IGBTs are semiconductors well suited for high frequency switching and high current applications.

Drawing A shows an IGBT in a passive mode. There is no gate signal, zero volts relative to the source, and therefore, no current flow. The drain terminal of the IGBT may be connected to a voltage supply; but since there is no conduction the circuit will not supply current to components connected to the source. The circuit is turned off like a light switch in the OFF position.

Drawing B shows the IGBT in an active mode. When the gate signal, a positive DC voltage relative to the source, is applied to the gate terminal of the IGBT, it is capable of conducting current. A voltage supply connected to the drain terminal will allow the IGBT to conduct and supply current to circuit components coupled to the source. Current will flow through the conducting IGBT to downstream components as long as the positive gate signal is present. This is similar to turning ON a light switch.

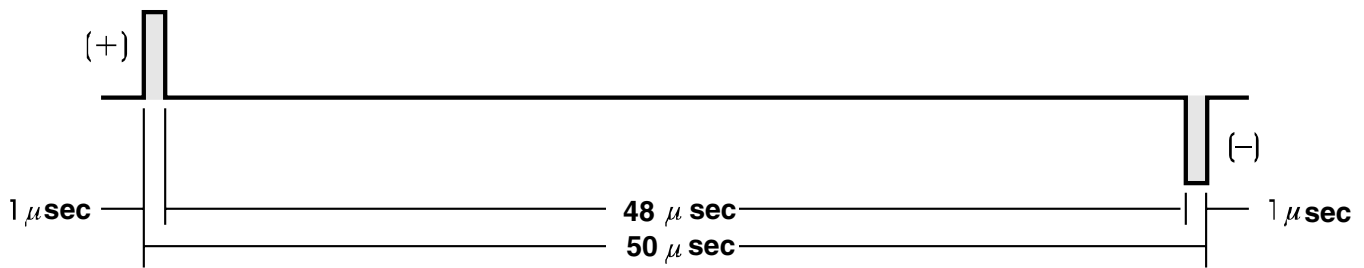
POWER MIG 350MP



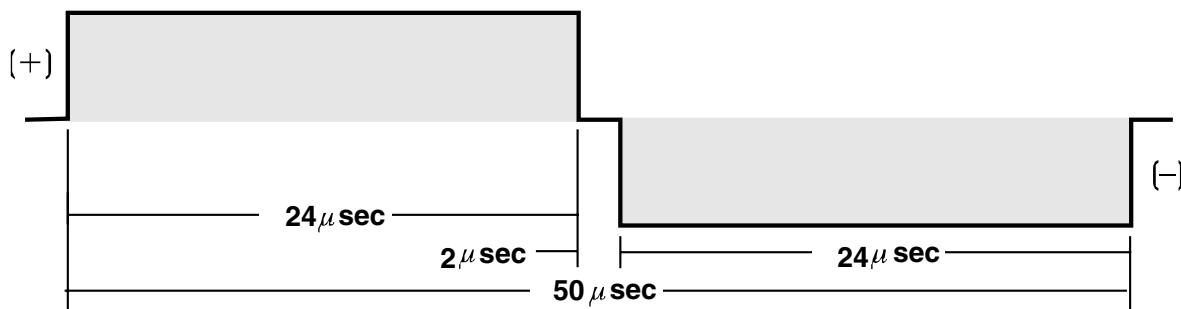
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# THEORY OF OPERATION

## FIGURE E.9 – TYPICAL IGBT OUTPUTS



### MINIMUM OUTPUT



### MAXIMUM OUTPUT

## PULSE WIDTH MODULATION

The term PULSE WIDTH MODULATION is used to describe how much time is devoted to conduction in the positive and negative portions of the cycle. Changing the pulse width is known as MODULATION. Pulse Width Modulation (PWM) is the varying of the pulse width over the allowed range of a cycle to affect the output of the machine.

### MINIMUM OUTPUT

By controlling the duration of the gate signal, the IGBT is turned on and off for different durations during a cycle. The top drawing above shows the minimum output signal possible over a 50-microsecond time period.

The positive portion of the signal represents one

IGBT group conducting for 1 microsecond. The negative portion is the other IGBT group. The dwell time (off time) is 48 microseconds (both IGBT groups off). Since only 2 microseconds of the 50-microsecond time period is devoted to conducting, the output power is minimized.

### MAXIMUM OUTPUT

By holding the gate signals on for 48 microseconds each and allowing only 2 microseconds of dwell time (off time) during the 50-microsecond cycle, the output is maximized. The darkened area under the top curve can be compared to the area under the bottom curve. The more dark area under the curve, the more power is present.

POWER MIG 350MP

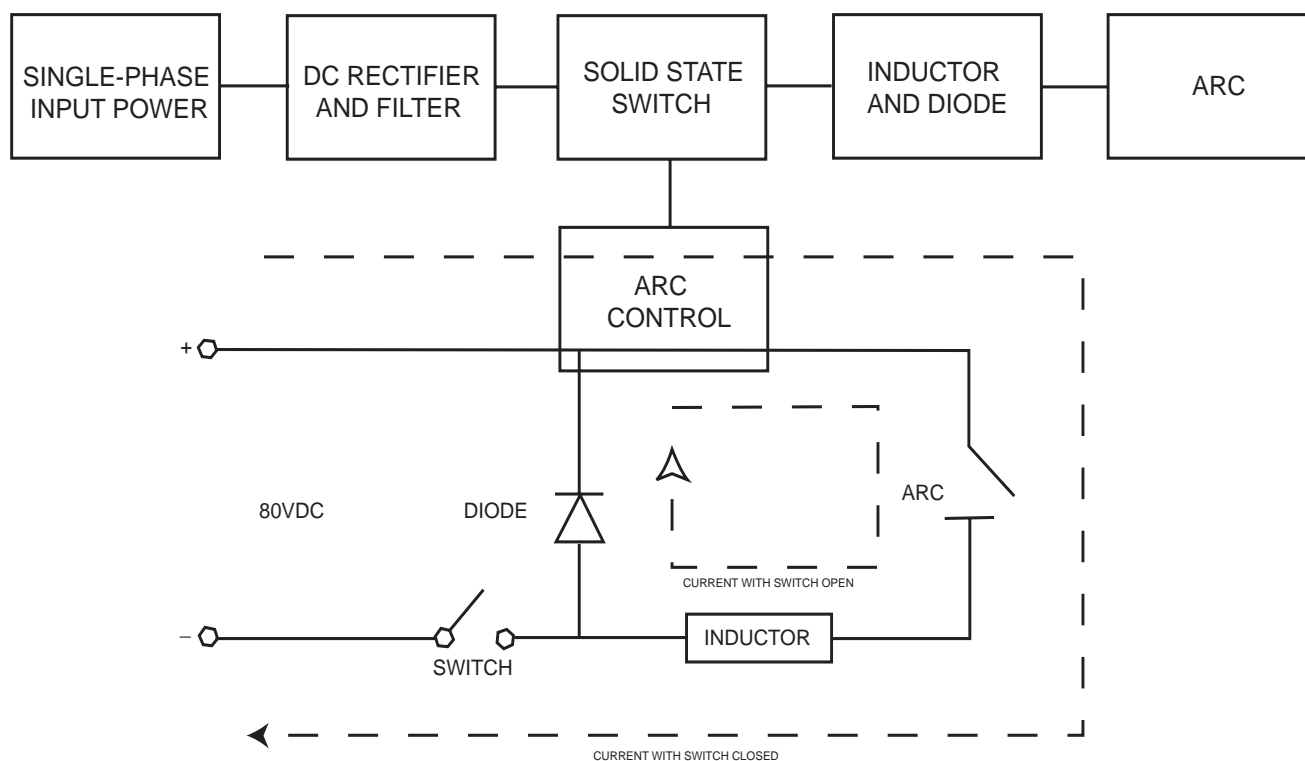


# THEORY OF OPERATION

## CHOPPER TECHNOLOGY FUNDAMENTALS

The new era of welding machines such as the Power MIG 350MP employ a technology whereby a DC source is turned on and off (chopped up) at high speed, then smoothed through an inductor to control an arc. Hence the name "Chopper." The biggest advantage of chopper technology is the high-speed control of the arc, similar to the inverter machines. A block diagram for this is as follows:

Figure E.10



In this system, the engine drives a three-phase alternator, which generates power that is rectified and filtered to produce about 80VDC. The current is applied through a solid state switch to an inductor. By turning the switch on and off, current in the inductor and the arc can be controlled. The above diagram depicts the current flow in the system when the switch is open and closed:

When the switch is closed, current is applied through the inductor to the arc. When the switch opens, current stored in the inductor sustains flow in the arc and through the diode. The repetition rate of switch closure is 20KHz, which allows ultra-fast control of the arc. By varying the ratio of on time versus off time of the switch (Duty Cycle), the current applied to the arc is controlled. This is the basis for Chopper Technology: Controlling the switch in such a way as to produce superior welding.

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# NOTES

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# TROUBLESHOOTING & REPAIR

## HOW TO USE TROUBLESHOOTING GUIDE



### WARNING

Service and repair should be performed by only Lincoln Electric Factory Trained Personnel. Unauthorized repairs performed on this equipment may result in danger to the technician and machine operator and will invalidate your factory warranty. For your safety and to avoid Electrical Shock, please observe all safety notes and precautions detailed throughout this manual.

This Troubleshooting Guide is provided to help you locate and repair possible machine malfunctions. Simply follow the three-step procedure listed below.

**Step 1. LOCATE PROBLEM (SYMPTOM).** Look under the column labeled "PROBLEM" (SYMPTOMS). This column describes possible symptoms that the machine may exhibit. Find the listing that best describes the symptom that the machine is exhibiting. Symptoms are grouped into four main categories: Output Problems, Function Problems, Wire Feeding, and Welding Problems.

**Step 2. PERFORM EXTERNAL TESTS.** The second column, labeled "POSSIBLE AREAS OF MISADJUSTMENT(S)", lists the obvious external possibilities that may contribute to the machine symptom. Perform these tests/checks in the order listed. In general, these tests can be conducted without removing the case cover.

**Step 3. PERFORM COMPONENT TESTS.** The last column, labeled "Recommended Course of Action" lists the most likely components that may have failed in your machine. It also specifies the appropriate test procedure to verify that the subject component is either good or bad. If there are a number of possible components, check the components in the order listed to eliminate one possibility at a time until you locate the cause of your problem.

All of the referenced test procedures referred to in the Troubleshooting Guide are described in detail at the end of this section. Refer to the Troubleshooting and Repair Table of Contents to locate each specific Test Procedure. All of the referred to test points, components, terminal strips, etc., can be found on the referenced electrical wiring diagrams and schematics. Refer to the **Machine Schematic** and **Electrical Diagrams** Section Table of Contents to locate the appropriate diagram.



### CAUTION

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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# TROUBLESHOOTING & REPAIR

## PC BOARD TROUBLESHOOTING PROCEDURES

### ⚠ WARNING



**ELECTRIC SHOCK  
can kill.**

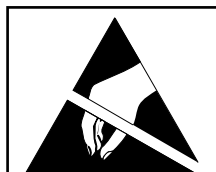
- Have an electrician install and service this equipment. Turn the input power OFF at the fuse box before working on equipment. Do not touch electrically hot parts.

### ⚠ CAUTION

Sometimes machine failures appear to be due to PC Board failures. These problems can sometimes be traced to poor electrical connections. To avoid problems when troubleshooting and replacing PC Boards, please use the following procedure:

1. Determine to the best of your technical ability that the PC Board is the most likely component causing the failure symptom.
2. Check for loose connections at the PC Board to assure that the PC Board is properly connected.
3. If the problem persists, replace the suspect PC Board using standard practices to avoid static electrical damage and electrical shock. Read the warning inside the static resistant bag and perform the following procedures:

#### PC board can be damaged by static electricity.



**ATTENTION  
Static-Sensitive  
Devices  
Handle only at  
Static-Safe  
Workstations**

- Remove your body's static charge before opening the static-shielding bag. Wear an anti-static wrist strap. For safety, use a 1 Meg ohm resistive cord connected to a grounded part of the equipment frame.

- If you don't have a wrist strap, touch an un-painted, grounded, part of the equipment frame. Keep touching the frame to prevent static build-up. Be sure not to touch any electrically live parts at the same time.

- Tools which come in contact with the PC Board must be either conductive, anti-static or static-dissipative.

- Remove the PC Board from the static-shielding bag and place it directly into the equipment. Don't set the PC Board on or near paper, plastic or cloth which could have a static charge. If the PC Board can't be installed immediately, put it back in the static-shielding bag.

- If the PC Board uses protective shorting jumpers, don't remove them until installation is complete.

- If you return a PC Board to The Lincoln Electric Company for credit, it must be in the static-shielding bag. This will prevent further damage and allow proper failure analysis.

4. Test the machine to determine if the failure symptom has been corrected by the replacement PC Board.

**NOTE:** It is desirable to have a spare (known good) PC board available for PC Board troubleshooting.

**NOTE:** Allow the machine to heat up so that all electrical components can reach their operating temperature.

5. Remove the replacement PC Board and substitute it with the original PC Board to recreate the original problem.

a. If the original problem does not reappear by substituting the original board, then the PC Board was not the problem. Continue to look for bad connections in the control wiring harness, junction blocks, and terminal strips.

b. If the original problem is recreated by the substitution of the original board, then the PC Board was the problem. Reinstall the replacement PC Board and test the machine.

6. Always indicate that this procedure was followed when warranty reports are to be submitted.

**NOTE:** Following this procedure and writing on the warranty report, "INSTALLED AND SWITCHED PC BOARDS TO VERIFY PROBLEM," will help avoid denial of legitimate PC Board warranty claims.

POWER MIG 350MP



# TROUBLESHOOTING & REPAIR

## TROUBLESHOOTING GUIDE

Observe Safety Guidelines detailed in the beginning of this manual.

PROBLEMS (SYMPTOMS)	POSSIBLE AREAS OF MISADJUSTMENT(S)	RECOMMENDED COURSE OF ACTION
OUTPUT PROBLEMS		
Major physical or electrical damage is evident.	1. Contact your local Lincoln Authorized Field Service Facility.	1. Contact the Lincoln Electric Service Department at 1-888-935-3877.
Machine is dead - no welding output and no wire feed when gun trigger is pulled.	<ol style="list-style-type: none"> <li>1. Make certain that the input power switch is in the "ON" position.</li> <li>2. Check the input voltage at the machine. Input voltage must match the rating plate and the reconnect panel.</li> <li>3. Blown or missing fuses in the input line.</li> <li>4. Check for thermal light on case front. Thermostats may be open due to machine overheating. If machine operates normally after a cooling off period then check for proper fan operation and ventilation. Make certain that the machine's duty cycle is not being exceeded.</li> <li>5. Remove the gun trigger connection and jump the two connections at the machine. If you have a wirefeed gun, it may be faulty. Replace.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check for the correct input voltage at the line switch. (L1-L2) See Wiring Diagram.</li> <li>2. Check for loose or faulty connections between the line switch and the reconnect panel.</li> <li>3. Perform the <b>Main Transformer Test</b>.</li> <li>4. Check the red LED's (1 &amp; 2) on the digital power supply board. They should be lit indicating that DC voltage is being applied to plugs J42 and J43. See Wiring Diagram.  If LED's 1 &amp; 2 are not lit check for the presence of 42 VDC at plug J41 pin 2(+) and pin 1(-). If the 42 VDC is present and LED's 1 &amp; 2 are not lit the digital power supply board may be faulty.  If the 42 VDC is not present at plug J41 perform the <b>Control Rectifier Test</b>.</li> </ol>

**CAUTION**

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

**POWER MIG 350MP**



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# TROUBLESHOOTING & REPAIR

## TROUBLESHOOTING GUIDE

Observe Safety Guidelines  
detailed in the beginning of this manual.

PROBLEMS (SYMPTOMS)	POSSIBLE AREAS OF MISADJUSTMENT(S)	RECOMMENDED COURSE OF ACTION
OUTPUT PROBLEMS		
<p>No welding output but wire feeds normally when gun trigger is pulled.</p>	<ol style="list-style-type: none"> <li>1. Check the input voltage at the machine. Input voltage must match the rating plate and the reconnect panel.</li> <li>2. The gun may be faulty. Check for continuity.</li> <li>3. Check continuity through the work lead.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check for loose or broken connections at the output terminals, the choke and all heavy current carrying leads. See the Machine Schematic.</li> <li>2. Make sure that the transformer secondary leads are securely connected to the Output Rectifier assembly.</li> <li>3. Check for OCV at output studs when trigger is pulled. If OCV is present, the gun may be faulty. Replace.</li> <li>4. Check for 57VAC at the input of output rectifier. If reading is not correct Perform <b>Main Transformer Tests</b>. If you measure approximately 57 VAC, check for 80VDC at the output of the output rectifier. If reading is not correct perform the <b>Output Rectifier Assembly Tests</b>. If 80VDC is there Perform <b>Chopper Board Test</b>.</li> <li>5. Check for 15VDC input to the Control Board at leads 12J4 (412) to 10J4 (410), -15VDC at leads 11J4 (411) to 10J4 (410), 5VDC at leads 8J4 (408) to 10J4 (410). If missing a voltage check wiring back to Digital Power Supply PCB. If voltage is ok, the Control Board may be faulty. Replace.</li> </ol>

⚠ CAUTION

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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Observe Safety Guidelines detailed in the beginning of this manual.

## TROUBLESHOOTING GUIDE

PROBLEMS (SYMPTOMS)	POSSIBLE AREAS OF MISADJUSTMENT(S)	RECOMMENDED COURSE OF ACTION
<b>OUTPUT PROBLEMS</b>		
Wire feeds but welding output is low causing wire to "stub". Welds are "cold". Machine cannot obtain full rated output of 350 amps at 32 volts.	<ol style="list-style-type: none"> <li>1. Make sure that the proper wire and procedures are being used.</li> <li>2. Check gun and work cable for loose or faulty connections.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check for loose or faulty connections of the heavy current carrying leads. See Wiring Diagram</li> <li>2. Perform the <b>Current Transducer Test</b></li> <li>3. Perform <b>Output Waveform Test</b>.</li> <li>4. Perform the <b>Output Rectifier Assembly Tests</b></li> <li>5. The Control Board may be faulty. Replace.</li> </ol>
The output voltage and wire feed is present continuously or pulsing when gun trigger is NOT activated.	<ol style="list-style-type: none"> <li>1. Remove the gun. If the problem is resolved, the gun trigger circuit is faulty. Repair or replace.</li> <li>2. If problem persists when gun assembly is removed from machine, then the problem is within the POWER MIG 350MP.</li> </ol>	<ol style="list-style-type: none"> <li>1. Find J85 on Feed Head Board and unplug. If the problem still exist Feed Head Board may be faulty.</li> </ol>
The output voltage is present continuously when gun trigger is NOT activated. The wire is not feeding.		<ol style="list-style-type: none"> <li>1. Find J6 on Control PCB and unplug. If output voltage is not present change Control PCB</li> <li>2. Perform the <b>Chopper Board Test</b>.</li> </ol>

 **CAUTION**

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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# TROUBLESHOOTING & REPAIR

## TROUBLESHOOTING GUIDE

Observe Safety Guidelines  
detailed in the beginning of this manual.

PROBLEMS (SYMPTOMS)	POSSIBLE AREAS OF MISADJUSTMENT(S)	RECOMMENDED COURSE OF ACTION
FUNCTION PROBLEMS		
No control of arc voltage. Wire feeding is normal.	1. The arc voltage encoder may be dirty. Rotate several times and check if problem is resolved.	1. The arc voltage encoder may be faulty. <b>Perform Encoder Test.</b> 2. Perform the <b>Chopper Board Test.</b> 3. The Control board may be faulty. Replace.
There is no gas flow when gun trigger is pulled. Wire feeds and weld voltage is present.	1. Check gas source and hoses for leaks or kinks. 2. Check regulator on the tank for the pressure being set to high.	1. Check for 6.5 VDC when trigger is pulled at feedhead Board, Plug J83-3 lead 833 and J83-4 lead 834. See Wiring Diagram. If you read 12 VDC solenoid may be open or a bad connection. Check wiring. Check the gas solenoid by disconnecting it from the Feeder Board (Plug J83-3 & 4) and applying a 12 VDC external supply to the gas solenoid. If the solenoid does NOT activate then it may be faulty. Replace. 2. If 6.5VDC is not present the Feeder board may be faulty. Replace.
There is no voltage available at the 115VAC receptacle.	1. Check the 15 Amp circuit breaker. Reset if necessary.	1. Check the 15 Amp circuit breaker. 2. Check for loose or faulty connection. See wiring diagram. 3. Perform the <b>Main Transformer Test.</b>

⚠ CAUTION

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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Observe Safety Guidelines detailed in the beginning of this manual.

**TROUBLESHOOTING GUIDE**

<b>PROBLEMS (SYMPTOMS)</b>	<b>POSSIBLE AREAS OF MISADJUSTMENT(S)</b>	<b>RECOMMENDED COURSE OF ACTION</b>
<b>WIRE FEEDING PROBLEMS</b>		
<p>No control of wire feed speed. Other machine functions are normal.</p>	<ol style="list-style-type: none"> <li>1. The wire feed speed encoder control may be dirty. Rotate several times and check if problem is resolved.</li> </ol>	<ol style="list-style-type: none"> <li>1. Perform the <i>Wire Drive Motor and Tachometer Feedback Test</i>.</li> <li>2. The Wire Speed Encoder may be faulty. Perform <i>Encoder Test</i>.</li> <li>3. The Feeder Head Board may be faulty. Replace.</li> </ol>
<p>There is no wire feed when gun trigger is pulled. Normal open circuit voltage is present.</p>	<ol style="list-style-type: none"> <li>1. Check for wire jam at drive rolls.</li> <li>2. If the drive rolls are turning then check for a mechanical restriction in the wire feed path.</li> <li>3. The gun liner may be clogged. Check or replace.</li> </ol>	<ol style="list-style-type: none"> <li>1. Perform the <i>Wire Drive Motor and Tachometer Feedback Test</i>.</li> <li>2. The Wire Speed Control Encoder may be faulty. Perform <i>Encoder Test</i></li> <li>3. The Feeder Head Board may be faulty. Replace.</li> </ol>
<p>The machine stops feeding wire while welding.</p>	<ol style="list-style-type: none"> <li>1. Check for adequate wire supply.</li> <li>2. Check for mechanical restrictions in the wire feeding path. The gun may be clogged.</li> <li>3. Make sure the gun liner and tip are correct for wire size being used.</li> <li>4. Check spindle for ease of rotation.</li> <li>5. Check to see if the spot timer has been activated.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check the motor armature current. Normal armature current is 2.0 to 2.7 amps maximum. If the motor armature current is normal the Feeder Board may be faulty. Replace.</li> <li>2. If the motor armature current is high (over 2.7 amps) and there are NO restrictions in the wire feeding path then the motor or gear box may be defective. Replace.</li> </ol>

 **CAUTION**

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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# TROUBLESHOOTING & REPAIR

## TROUBLESHOOTING GUIDE

Observe Safety Guidelines detailed in the beginning of this manual.

PROBLEMS (SYMPTOMS)	POSSIBLE AREAS OF MISADJUSTMENT(S)	RECOMMENDED COURSE OF ACTION
<b>WELDING PROBLEMS</b>		
The arc is unstable and or "hunting."	<ol style="list-style-type: none"> <li>1. Check for worn or melted contact tip.</li> <li>2. Check for loose or faulty connections on the work and electrode cables.</li> <li>3. Make sure electrode polarity or welding process being used is correct.</li> <li>4. Check for rusty or dirty wire.</li> <li>5. Make sure machine settings are correct for process being used. (shielding gas, wire type, wire size).</li> </ol>	<ol style="list-style-type: none"> <li>1. Check for loose connections at the output terminals, the chokes, and all heavy current carrying leads. See the Machine Diagram.</li> <li>2. Make sure that the transformer secondary leads are securely connected to the Output Rectifier assembly.</li> <li>3. Check the <b>Output Voltage Waveforms</b>. If waveforms are not correct Perform the <b>Output Rectifier Assembly Tests</b>.</li> <li>4. Reload latest software. Contact a Lincoln Electric sales representative for latest software.</li> <li>5. The Control board may be faulty. Replace.</li> </ol>
Weld bead is narrow or ropy. May have porosity with electrode stubbing into plate.	<ol style="list-style-type: none"> <li>1. Make sure the weld procedure and electrode polarity is correct for the process being used. Welding voltage may be too low for wire feed speed being used.</li> <li>2. Make sure shielding gas is correct and flow is proper.</li> <li>3. Make sure the weld joint is not "contaminated".</li> </ol>	<ol style="list-style-type: none"> <li>1. Check the <b>Output Voltage Waveforms</b>. If waveforms are not correct Perform the <b>Output Rectifier Assembly Tests</b>.</li> <li>2. Reload latest software. Contact a Lincoln Electric sales representative for latest software.</li> <li>3. The Control board may be faulty. Replace.</li> </ol>

 **CAUTION**

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# TROUBLESHOOTING & REPAIR

Observe Safety Guidelines detailed in the beginning of this manual.

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PROBLEMS (SYMPTOMS)	POSSIBLE AREAS OF MISADJUSTMENT(S)	RECOMMENDED COURSE OF ACTION
<b>WELDING PROBLEMS</b>		
The contact tip seizes in the gas dif-fuser.	<ol style="list-style-type: none"> <li>1. The tip being over heated due to excessive current and/or high duty cycle welding.</li> <li>2. A light application of high temper-ature anti-seize lubricant (such as Lincoln E2607 Graphite Grease) may be applied to the contact tip threads.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check the <b>Output Voltage Waveforms</b>.</li> </ol>
The welding arc is variable and sluggish.	<ol style="list-style-type: none"> <li>1. Check the welding cable connec-tions for loose or faulty connec-tions.</li> <li>2. Make sure the wire feed speed, voltage, and shielding gas are correct for the process being used.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check the OCV and <b>Output Voltage Waverforms</b>. If wave-forms are not correct Perform the <b>Output Rectifier Assembly Tests</b>.</li> <li>2. Reload latest software from a Lincoln Electric sales represen-tative</li> <li>3. The Control Board may be faulty. Replace.</li> </ol>
The arc striking is poor.	<ol style="list-style-type: none"> <li>1. Check the welding cable con-nections for loose or faulty con-nections.</li> <li>2. Make sure the wire feed speed, voltage, and shielding gas are correct for the process being used.</li> <li>3. Run in settings may need to be adjusted.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check the <b>Output Voltage Waveforms</b>. If waveforms are not correct Perform the <b>Output Rectifier Assembly Tests</b>.</li> <li>2. Reload latest software from a Lincoln Electric sales represen-tative</li> <li>3. The Control board may be faulty. Replace.</li> </ol>

**CAUTION**

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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TRUBLESHOOTING GUIDE

PROBLEMS (SYMPTOMS)	POSSIBLE AREAS OF MISADJUSTMENT(S)	RECOMMENDED COURSE OF ACTION
<b>PUSH PULL WIRE FEEDING PROBLEMS</b>		
<p>While loading wire, the rear drive rolls stop while pushing wire through the torch.</p>	<ol style="list-style-type: none"> <li>1. Check torch cable for kinks. Torch cable should be laid out relatively straight.</li> <li>2. Check to see that the spindle brake is not set too tight. There should be an aluminum spacer behind the spindle brake. Refer to the push-pull connection kit for this spacer.</li> <li>3. Check the wire at the spool. Make sure the wire is not crossed and is de-reeling properly.</li> <li>4. Increase wire feed speed to 350-400 ipm.</li> <li>5. If problem continues after a thru d are checked then the Stall Factor Number needs to be increased. See <b>Stall Factor Number Adjustment</b>.</li> </ol>	
<p>While loading wire, the wire bird nests before the wire gets all the way through the torch.</p>	<ol style="list-style-type: none"> <li>1. Check torch cable for kinks. Torch cable should be laid out relatively straight.</li> <li>2. Make sure liner conduit is inserted all the way into the rear wire drive so that it is up against the inner black plastic wire guide.</li> <li>3. Inner black plastic wire guide is worn out. Replace guide.</li> <li>4. Slow down wire feed speed while pushing wire up through the liner. Recommended setting = 350MP ipm.</li> <li>5. Clean or replace contact tip.</li> </ol>	

 **CAUTION**

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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# TROUBLESHOOTING & REPAIR

Observe Safety Guidelines detailed in the beginning of this manual.

## TROUBLESHOOTING GUIDE

PROBLEMS (SYMPTOMS)	POSSIBLE AREAS OF MISADJUSTMENT(S)	RECOMMENDED COURSE OF ACTION
PUSH PULL WIRE FEEDING PROBLEMS		
While loading wire the wire bird nests if the wire misses the outlet guide while shooting the gap in the torch.	<ol style="list-style-type: none"> <li>1. Straighten the first six inches of the wire before feeding it into the rear wire drive.</li> <li>2. Make sure the torch drive rolls are tightened slightly to help the wire jump the gap.</li> <li>3. Slow down wire feed speed while pushing wire through torch liner. Recommended setting = 350 ipm.</li> <li>4. If problem continues after a thru c are checked then the Stall Factor Number needs to be decreased. See <b><i>Stall Factor Number Adjustment.</i></b></li> </ol>	
Arc length varies while welding (arc length is not constant).	<ol style="list-style-type: none"> <li>1. Power Mig 350MP drive rolls set to tight. The tension arm should be set at 1 to 1-1/2.</li> <li>2. Check to see that the spindle brake is not set too tight. There should be an aluminum spacer behind the spindle brake. Refer to the push-pull connection kit for this spacer.</li> <li>3. Clean or replace contact tip.</li> <li>4. If problem continues after a thru c are checked then the Stall Factor Number needs to be increased. See <b><i>Stall Factor Number Adjustment.</i></b></li> </ol>	

**CAUTION**

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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## TROUBLESHOOTING GUIDE

PROBLEMS (SYMPTOMS)	POSSIBLE AREAS OF MISADJUSTMENT(S)	RECOMMENDED COURSE OF ACTION
PUSH PULL WIRE FEEDING PROBLEMS		
During welding the wire continues to burn back to the tip.	<ol style="list-style-type: none"> <li>1. Check to see that the spindle brake is not set too tight. There should be an aluminum spacer behind the spindle brake. Refer to the push-pull connection kit for this spacer.</li> <li>2. Power Mig 350MP drive rolls set too tight. The tension arm should be set at 1 to 1-1/2.</li> <li>3. Push-pull torch drive rolls set too tight. Refer to owners manual for proper setting.</li> <li>4. If pulse welding the trim value may be set too high.</li> <li>5. Clean or replace contact tip.</li> <li>6. If problem continues after a thru e are checked then the Stall Factor Number needs to be increased. <b>See Stall Factor Number Adjustment.</b></li> </ol>	
Wire bird nests while welding.	<ol style="list-style-type: none"> <li>1. Torch liner conduit not inserted all the way so that it is touching the inner black plastic wire guide.</li> <li>2. Inner black plastic wire guide is worn out. Replace guide.</li> <li>3. Push-pull torch drive rolls set too tight. Refer to owners manual for proper setting.</li> <li>4. If problem continues after a thru c are checked then lower your Stall Factor Number. <b>See Stall Factor Number Adjustment.</b></li> </ol>	

⚠ CAUTION

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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# TROUBLESHOOTING & REPAIR

## PUSH PULL WIRE FEEDING PROBLEMS

**STALL FACTOR** - an adjustment to the Power Mig 350MP that allows the welder to adjust the maximum amount of power going to the rear drive motor. The purpose is to send only enough power to the rear drive motor to pull the wire off the spool and get the wire up the torch liner.

### STALL FACTOR NUMBER ADJUSTMENT

1. Turn the Power Mig 350MP off.
2. Hold the Push-pull torch trigger in and turn the power back on. Continue to hold the trigger in while machine powers up.
3. Once the machine displays "SF" in the left display and a number 5 to 35 in the right display the trigger can be released.
4. Use the volts /trim knob to adjust the Stall Factor Number.
5. Once the Stall Factor Number is adjusted push the select switch up.
6. The display should scroll the word "SAVEd" if the number was changed. The display will scroll "no CHANGE" if the SF number was not changed.
7. The machine should automatically switch back to normal operation after it is done saving the SF number.

### POWER MIG 350MP "CLEAR ALL" PROCEDURE

1. Hold "select" switch up while powering up machine.
2. Release "select" switch when displays show "PrESSPin".
3. Turn the right "encoder knob" until displays show "CLrAll".
4. Toggle the "select" switch up and release.
5. Machine will reset itself.

## CAUTION

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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# TROUBLESHOOTING & REPAIR

Observe Safety Guidelines detailed in the beginning of this manual.

## TROUBLESHOOTING GUIDE

FAULT CODES	DESCRIPTION / DEFINITION	CORRECTIVE ACTION	SERVICE FACILITY CORRECTIVE ACTION
<b>WELDING PROBLEMS</b>			
39	Glitch on the primary over current fault interrupt; possibly caused by noise or a signal level.	Check the machine ground. Check for cuts or marks on input cord.	Check input cord for cuts or marks. Check input cord connections at reconnect panel.
44	Main CPU problem. The DSP has detected a problem with the CPU.	Check the machine ground. Check for cuts or marks on input cord.	Check input cord for cuts or marks. Check input cord connections at reconnect panel. If still bad replace Control PCB.
47	Glitch on the CAP/heart beat interrupt; possibly caused by noise or a signal level right at the trip threshold.	Turn machine off and let sit for 60 second and then turn back on .	Run Scrolling dash Test. If still bad replace Control PCB.
81	Motor overload-average motor current exceeded 8.00 amps for more than 0.50 seconds.	Verify motor armature is not binding. Verify wire spool is not binding.	Check current at drive motor exceeds 8 amps change drive motor. If under 8 amps for 0.50 seconds change Feeder Board.
82	Motor over current-average motor current exceeded 3.50 amps for more than 10.0 seconds.	Verify motor armature is not binding. Verify wire spool is not binding.	Check current at drive motor exceeds 3.50amps for 10.0 seconds change drive motor.
214	Feed Head Board can't be found.	Turn the machine off and back on to reset the machine. If condition persists, contact and authorized Lincoln Field Service Facility.	Using machine schematic Check LED 8 on Control Bd. If not on, check for +5VDC at leads 1103 & 1104. If LED 8 is on check for 42VDC at Feed Head Bd. If there, Feed Head Bd. may be faulty.
7135	MSP can't be found.	Turn the machine off and back on to reset the machine.	Check for bad connections at MSP panel. The MSP panel may be faulty. Replace.
7138	Display Board can't be found.	Turn the machine off and back on to reset the machine.	Check for bad connections at Display Board. The Display Board may be faulty. Replace.
-----	Scrolling dashes	Perform Clear all test.	Perform Clear all test.

### CAUTION

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

#### POWER MIG 350MP



## CHOPPER BOARD CAPACITOR DISCHARGE PROCEDURE



### WARNING

Service and repair should be performed by only Lincoln Electric factory trained personnel. Unauthorized repairs performed on this equipment may result in danger to the technician or machine operator and will invalidate your factory warranty. For your safety and to avoid electrical shock, please observe all safety notes and precautions detailed throughout this manual.

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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### DESCRIPTION

This procedure will insure that the five large capacitors on the Chopper Board have been discharged. This procedure should be performed whenever work is to be attempted on or near the Chopper Board.

### MATERIALS NEEDED

- 3/8" Nut Driver
- Volt/Ohmmeter
- Resistor (25 Ohms and 25 Watts Minimum)
- Jumper Leads
- Wiring Diagram

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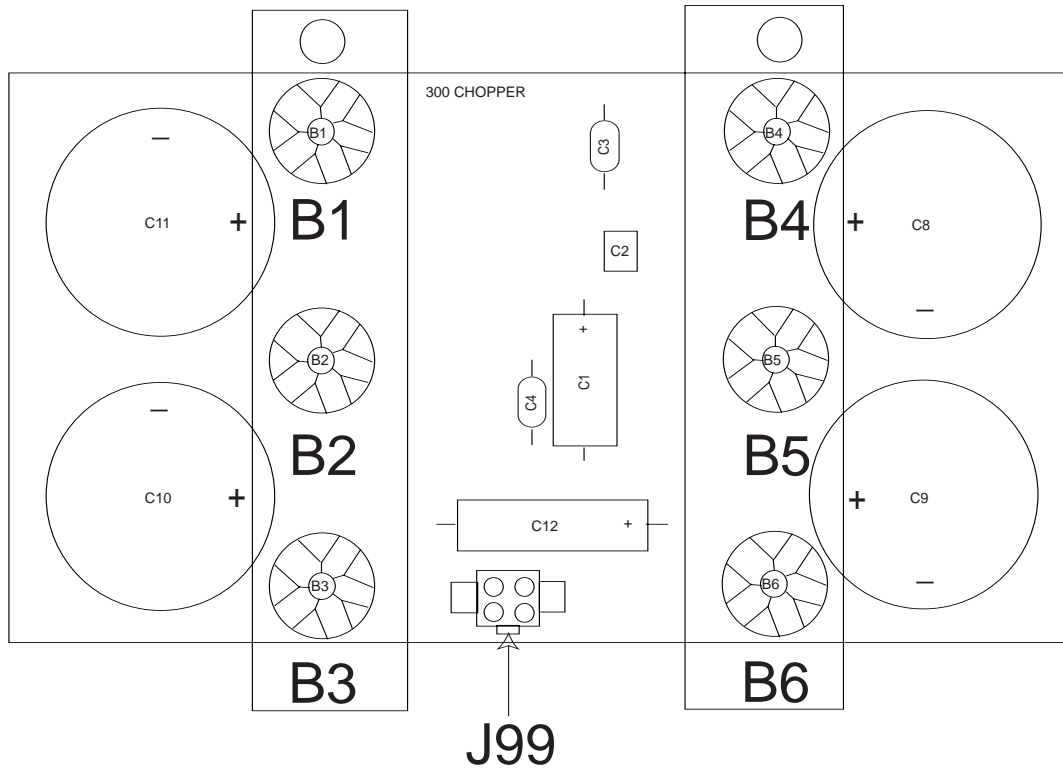




# TROUBLESHOOTING & REPAIR

## CHOPPER BOARD CAPACITOR DISCHARGE PROCEDURE *(continued)*

FIGURE F.1 – CHOPPER BOARD CAPACITOR TERMINAL DISCHARGE



### PROCEDURE

#### **⚠ WARNING**

**ELECTRIC SHOCK can kill.**

High voltage is present when input power is applied to the machine.

Refer to Figure F.1.

1. Remove main input power supply to the machine.
2. Lift the hinged right side case cover.
3. Using the 3/8" nut driver, remove the bottom right case cover.
4. Locate the Chopper Board with capacitors mounted on the center of the machine base, right side. See Figure F.1.

5. Using the resistor and jumper leads, CAREFULLY discharge the capacitor terminals. There are 5 capacitors. **NEVER USE A SHORTING STRAP FOR THIS PURPOSE.** DO NOT TOUCH THE TERMINALS WITH YOUR BARE HANDS.

To discharge the capacitors, hold the jumper leads to the following terminals for a minimum of 10 seconds each. See Figure F.1 and the Wiring Diagram.

Capacitors	Terminals
C10 and C11	B1 and B2
C5	B1 and B5
C8 and C9	B4 and B5

6. Using the volt/ohmmeter, check the voltage across terminals B1 and B2 and B1 and B5 and B4 and B5. Each reading should now be zero volts.

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# TROUBLESHOOTING & REPAIR

## MAIN TRANSFORMER TEST



### WARNING

Service and repair should be performed by only Lincoln Electric factory trained personnel. Unauthorized repairs performed on this equipment may result in danger to the technician or machine operator and will invalidate your factory warranty. For your safety and to avoid electrical shock, please observe all safety notes and precautions detailed throughout this manual.

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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### TEST DESCRIPTION

This test will determine if the correct voltages are being applied to the primary windings of the main transformer and induced on the secondary and auxiliary windings.

### MATERIALS NEEDED

- 3/8" Nut Driver
- 5/16" Nut Driver
- Volt/Ohmmeter

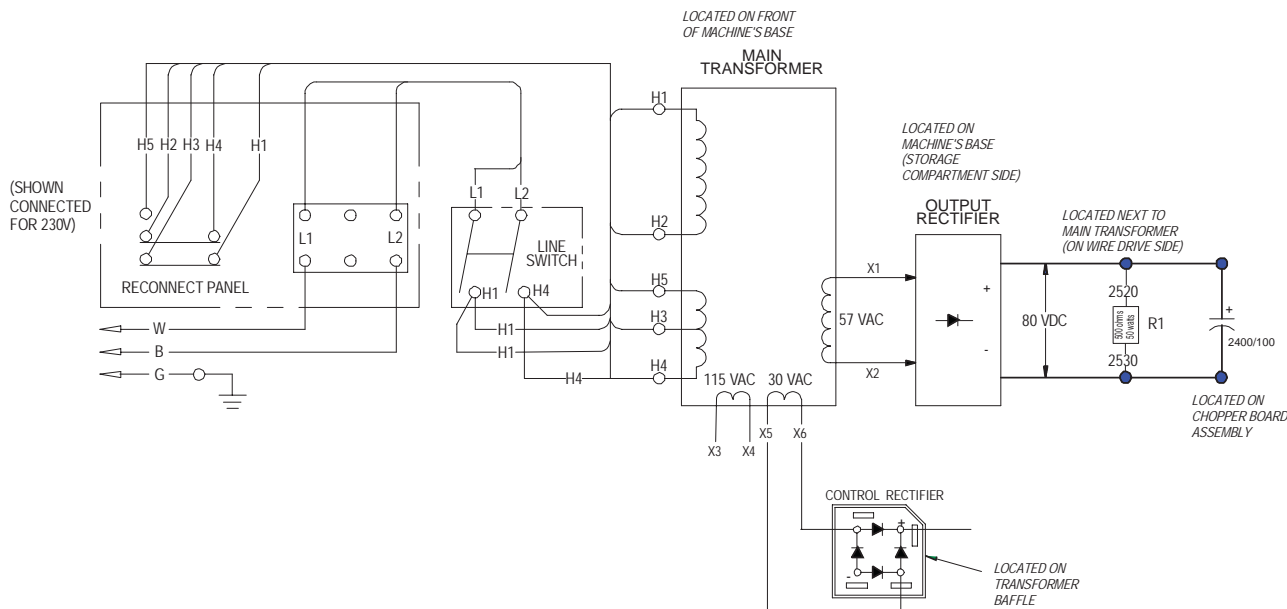
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# TROUBLESHOOTING & REPAIR

## MAIN TRANSFORMER TEST (continued)

FIGURE F.2 – MAIN TRANSFORMER TEST POINT LOCATIONS



### PROCEDURE

**WARNING**

The ON/OFF POWER SWITCH will be "hot" during these tests.

**NOTE:** Secondary voltages will vary proportionately with the primary input voltage.

1. Disconnect the main input power supply to the machine.
2. Perform the Case Cover Removal procedure.
3. Remove the tool tray with a 5/16" nut driver (3 screws).

#### TEST INPUT VOLTAGE TO THE MAIN TRANSFORMER PRIMARY WINDING:

4. Confirm the reconnect panel is connected properly for the correct voltage. See reconnect panel connection diagram located on back of machine above reconnect door.

5. Test for correct input voltage between L1 lead at the LINE SWITCH to L2. Voltage tested will vary depending on the input voltage connection. See Wiring diagram for test point locations.

- \* If the voltage is incorrect, check for loose or broken leads between the reconnect panel and the ON/OFF POWER SWITCH. Also, test the ON/OFF POWER SWITCH for proper operation.
- \* If the voltage is correct, check for the same voltage at H1 and H4 and at the bottom of the LINE SWITCH with the switch in the ON position.
- \* If the voltage is incorrect, check for loose or broken leads between the reconnect panel and the LINE SWITCH.
- \* If the correct voltage is being applied to the main transformer primary winding, proceed to the table below for the secondary winding output voltage tests.

Leads	Description	Expected Voltage
X1-X2	Power to output rectifier	57 VAC
X3-X4	Power to fan motor & 115 VAC receptacle	115 VAC
X5-X6	Power to control rectifier	30 VAC

If the correct voltage is being applied to the main transformer and one or more of the secondary voltages is missing or incorrect, the main transformer may be faulty. Replace the main transformer.

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## CHOPPER BOARD TEST



### WARNING

Service and repair should be performed by only Lincoln Electric factory trained personnel. Unauthorized repairs performed on this equipment may result in danger to the technician or machine operator and will invalidate your factory warranty. For your safety and to avoid electrical shock, please observe all safety notes and precautions detailed throughout this manual.

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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### TEST DESCRIPTION

This test will help determine if the power module IGBT on the Chopper Board is shorted. This test will also check for input voltage and if the PWM signal is present to activate the IGBT. It will also determine if the Chopper Board is receiving the correct input voltages.

### MATERIALS NEEDED

Volt/Ohmmeter (Analog)  
3/8" Socket Wrench and 6" Extension  
7/16" Nut Driver

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# TROUBLESHOOTING & REPAIR

## CHOPPER BOARD TEST (continued)

### TEST PROCEDURE

1. Disconnect the main AC input power to the machine.
2. Remove the case side panels with a 3/8" nut driver.
3. Locate plug J99. (Later machine do not have J99).
4. Make the following voltage test. From the table below.
5. Turn the machine off between each test:
  - a. Carefully insert the meter probes into the back of each Molex plug cavity.

FROM LEAD	TO LEAD	EXPECTED VOLTAGE
437+(1J99)	431-(4J99)	20VDC

If 20 VDC is not present check Digital Power Supply. See the Wiring Diagram.

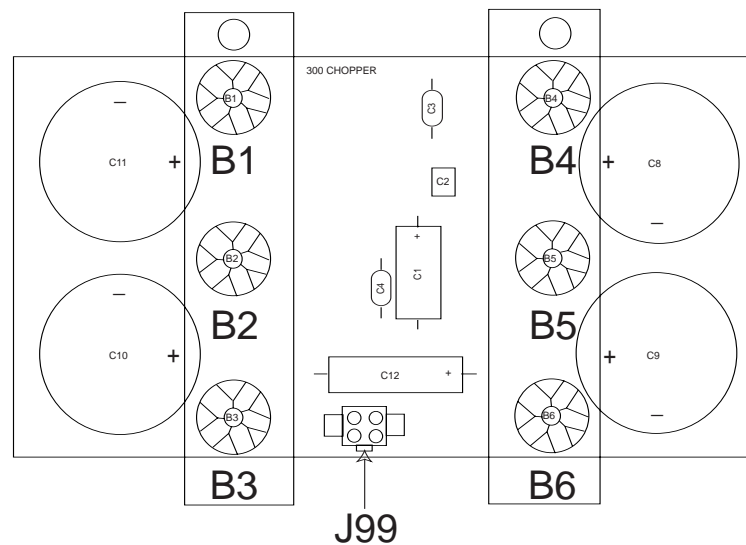
### RESISTANCE TEST

1. Perform the Capacitor Discharge Procedure.
2. Remove input power to the machine.
3. Perform the resistance tests in Table F.1.

**Table F.1– CHOPPER BOARD RESISTANCE TEST TABLE**

Test Point	Test Point	Expected Reading
B5(+)	B6(-)	6 K ohms - 9K ohms
B6(+)	B5(-)	6 K ohms - 9K ohms
B4(+)	B5(-)	200 K ohms or Higher
B5(+)	B4(-)	400 K ohms or Higher
B4(+)	B6(-)	200 K ohms or Higher
B6(+)	B4(-)	400 K ohms or Higher
B2(+)	B3(-)	6 K ohms - 9K ohms
B3(+)	B2(-)	6 K ohms - 9K ohms
B4(+)	B2(-)	200 K ohms or Higher
B2(+)	B4(-)	400 K ohms or Higher
B4(+)	B3(-)	200 K ohms or Higher
B3(+)	B4(-)	400 K ohms or Higher

**FIGURE F.3 – CHOPPER BOARD CONNECTIONS**



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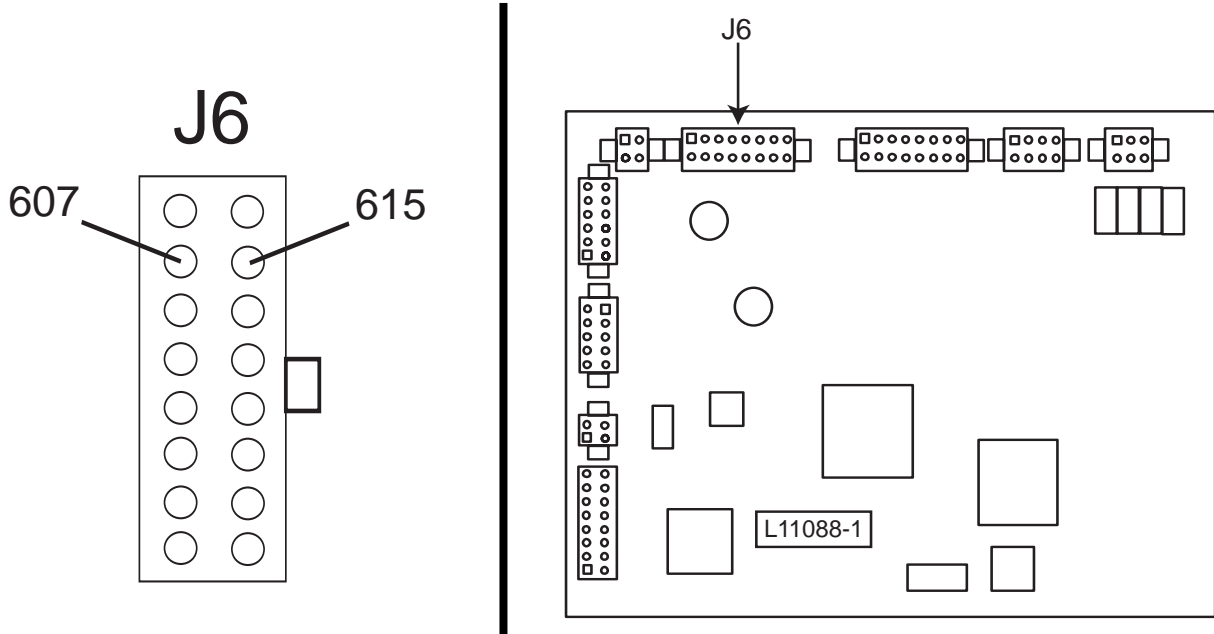


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# TROUBLESHOOTING & REPAIR

## CHOPPER BOARD TEST (continued)

FIGURE F.4



### PWM SIGNAL TEST

1. Locate 607 (7J6) and 615 (15J6) on the control board. See Figure F.4.
2. Perform the following voltage test or hertz readings when the trigger is pulled.

From Lead	To Lead	Expected Voltage
607 (7J6)	615 (15J6)	1.8-2 VDC 20 KHZ

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# TROUBLESHOOTING & REPAIR

## CONTROL RECTIFIER TEST



### WARNING

Service and repair should be performed by only Lincoln Electric factory trained personnel. Unauthorized repairs performed on this equipment may result in danger to the technician or machine operator and will invalidate your factory warranty. For your safety and to avoid electrical shock, please observe all safety notes and precautions detailed throughout this manual.

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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### DESCRIPTION

This test will determine if the correct AC voltages are being applied to the Rectifier Diode Bridge and supplied from the Rectifier Diode Bridge to the Digital Power Supply board.

### MATERIALS NEEDED

Volt/Ohmmeter  
3/8" Nut Driver  
Power MIG 350MP Machine Schematic

POWER MIG 350MP







# TROUBLESHOOTING & REPAIR

## OUTPUT RECTIFIER ASSEMBLY TEST



### WARNING

Service and repair should be performed by only Lincoln Electric factory trained personnel. Unauthorized repairs performed on this equipment may result in danger to the technician or machine operator and will invalidate your factory warranty. For your safety and to avoid electrical shock, please observe all safety notes and precautions detailed throughout this manual.

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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### TEST DESCRIPTION

This test will determine if the Output Rectifier is shorted. See the **Oscilloscope Waveforms** section of this manual for normal and abnormal output waveforms.

### MATERIALS NEEDED

- 3/8" Nut Driver
- 5/16" Nut Driver
- 1/2" Wrench
- Power MIG 350 Wiring Diagram (See the Machine Schematic in this manual.
- Analog Volt/Ohmmeter (If Digital Meter is used you must use in Diode Check Mode  
Do not use Ohms Scale)

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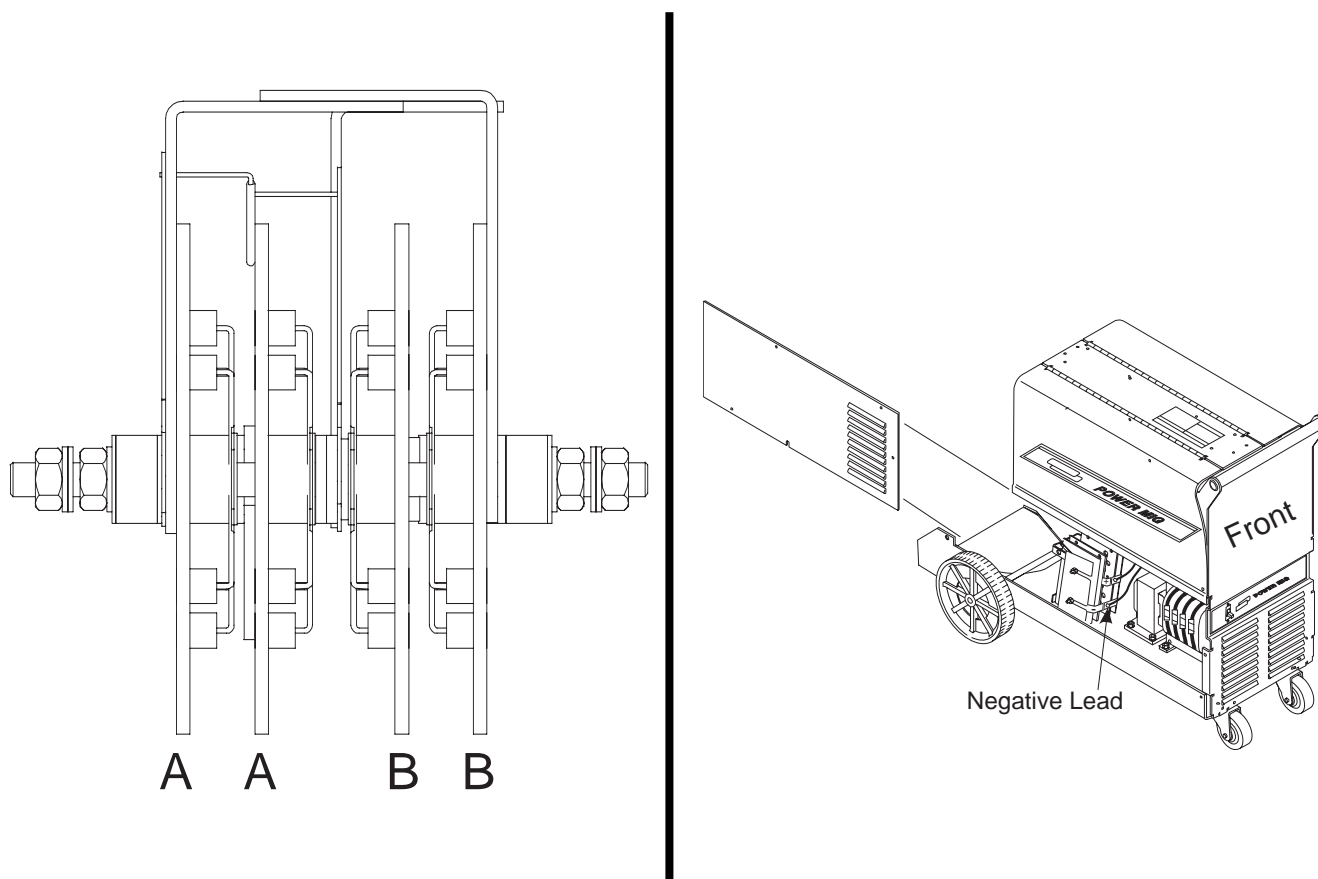


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# TROUBLESHOOTING & REPAIR

## OUTPUT RECTIFIER ASSEMBLY TEST (continued)

FIGURE F.7- OUTPUT RECTIFIER ASSEMBLY LOCATION



### TEST PROCEDURE

1. Disconnect the main AC input power to the machine.
2. Perform the **Chopper Assembly Capacitor Discharge procedure**.
3. Locate and disconnect the negative lead from the output rectifier bridge assembly.
4. Test for shorted or leaky diodes by checking from the outside plate (A) to inside plate (A) then reverse your leads and recheck the same plates. Do the same to plate B. The readings should be high resistance in one polarity and low resistance in the opposite polarity. See Figure F.7.
5. If any of the diodes are leaky or shorted the output rectifier assembly should be replaced.
6. When the test is complete, replace the negative output previously removed.
7. Replace case side.

**Note:** Do not disassemble the rectifier assembly.

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# TROUBLESHOOTING & REPAIR

## WIRE DRIVE MOTOR AND TACHOMETER FEEDBACK TEST



### WARNING

Service and repair should be performed by only Lincoln Electric factory trained personnel. Unauthorized repairs performed on this equipment may result in danger to the technician or machine operator and will invalidate your factory warranty. For your safety and to avoid electrical shock, please observe all safety notes and precautions detailed throughout this manual.

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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### TEST DESCRIPTION

This test will determine if the wire drive motor and voltage feedback circuits are functioning properly.

### MATERIALS NEEDED

5/16" Nut Driver  
Volt/Ohmmeter

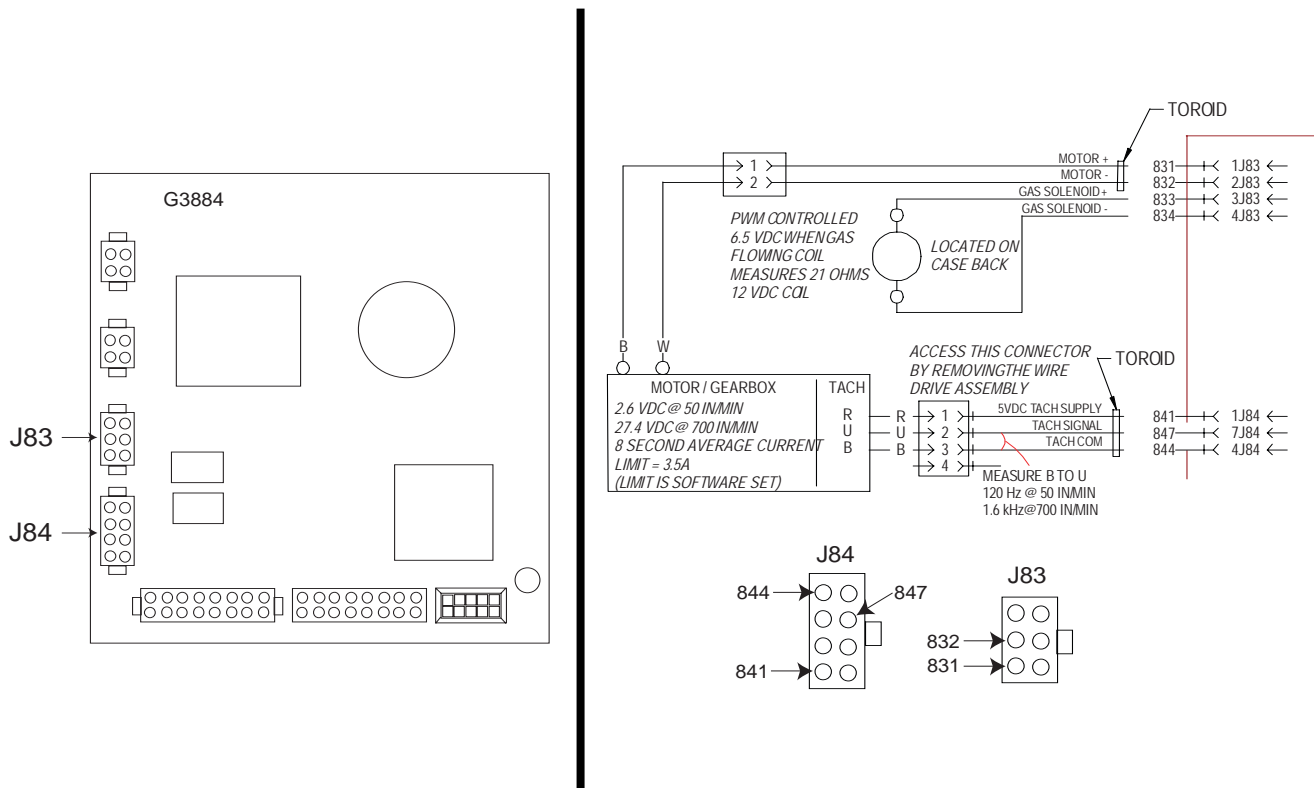
POWER MIG 350MP



# TROUBLESHOOTING & REPAIR

## WIRE DRIVE MOTOR AND TACHOMETER FEEDBACK TEST (continued)

FIGURE F. 8 – PLUG J83 AND J84 LOCATIONS ON FEEDER BOARD



### TEST PROCEDURE

NOTE: POLARITY MUST BE OBSERVED FOR THESE TESTS.

#### TEST FOR CORRECT WIRE DRIVE MOTOR ARMATURE VOLTAGE

1. Disconnect main input power to the machine.
2. Open the side panels and remove the tool tray using a 5/16" nut Driver.
3. Locate the following leads on plug J83:
4. Locate leads 831(black) and 832(white) on plug J83.
5. Connect the main power to the machine.
7. Make the following voltage tests. From the table below.
8. Carefully insert the meter probes into the back of each Molex plug pin cavity to perform the test.
9. Turn the machine ON and pull the gun trigger to conduct this voltage test.

FROM LEAD	TO LEAD	EXPECTED VOLTAGE
831 + (1J83)	832 - (2J83)	2.5-27 VDC (varies depending on wire feed speed)

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# TROUBLESHOOTING & REPAIR

## WIRE DRIVE MOTOR AND TACHOMETER FEEDBACK TEST *(continued)*

### TEST FOR SUPPLY VOLTAGE TO TACHOMETER AND FEEDBACK VOLTAGE

1. Locate the following leads on Plug J84. Leads 841 (1J84) and 844 (4J84)
2. Make the following voltage tests. From the table below.
3. Turn the machine OFF between each test.
4. Carefully insert the meter probes into the back of each Molex plug pin cavity. This is the tach supply voltage.

FROM LEAD	TO LEAD	EXPECTED VOLTAGE
841 + (1J84)	844 - (4J84)	5 VDC

5. If the 5 VDC is present, go to next step. If no voltage is measured Feeder Head Board may be bad. Check connections back to Feed Head Board.
6. Locate the leads on Plug J84 noted in the table below.
7. Carefully insert the meter probes into the back of each Molex plug pin cavity
8. Turn the machine ON and pull the gun trigger to conduct the voltage test.
9. If the 1.5 to 3.5 VDC is present, the tachometer circuit is sending the correct feedback signal to the Feeder Board. Replace the Feeder Board.

FROM LEAD	TO LEAD	EXPECTED VOLTAGE
847 + (7J84)	844 - (4J84)	1.5 to 3.5 VDC

10. If the 1.5 to 3.5 VDC is not present or not correct, the Feeder Board is not receiving the proper feedback voltage from the tachometer circuit. Check the leads from the tachometer circuit to the Feeder Board for loose or broken connections.
11. If the leads are okay, the tachometer circuit may be faulty, replace the Tach Sensor.

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## ENCODER PC BOARD TEST



### WARNING

Service and repair should be performed by only Lincoln Electric factory trained personnel. Unauthorized repairs performed on this equipment may result in danger to the technician or machine operator and will invalidate your factory warranty. For your safety and to avoid electrical shock, please observe all safety notes and precautions detailed throughout this manual.

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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### DESCRIPTION

This test will help determine if the encoders are functioning properly for machines above code 10562 only.

### MATERIALS NEEDED

Volt/Ohmmeter (Analog Recommended)  
5/16" Nut Driver

POWER MIG 350MP

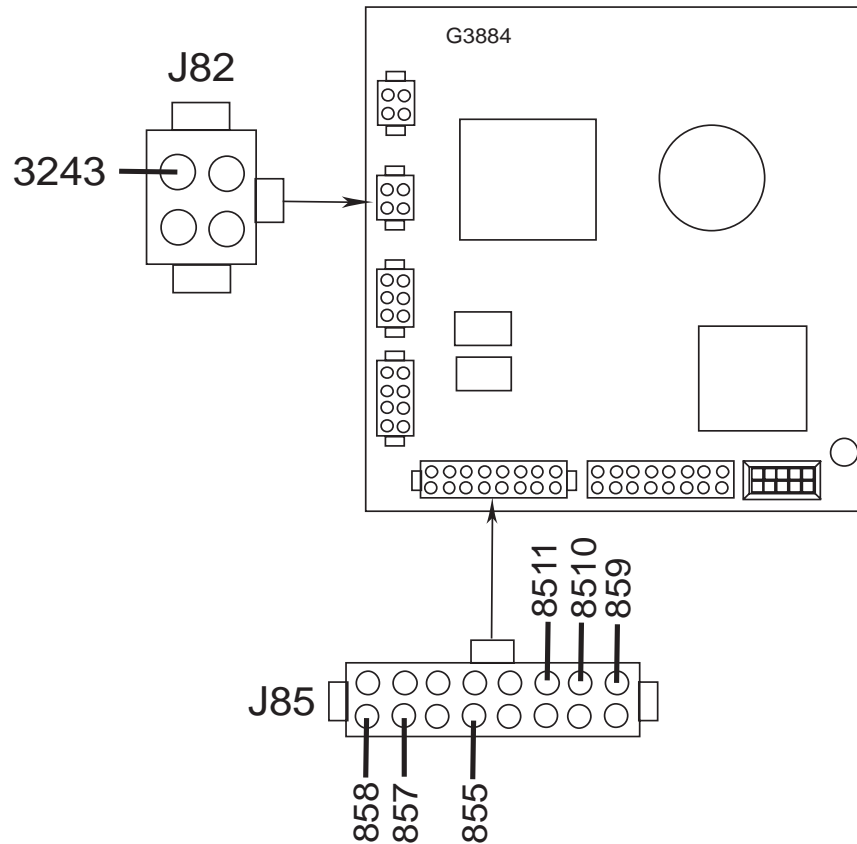




# TROUBLESHOOTING & REPAIR

## ENCODER PC BOARD TEST (continued)

FIGURE F. 9 - FEEDHEAD P.C. BOARD



### TEST PROCEDURE

1. Disconnect the main AC input power to the machine.
2. Locate the following leads on Plug J85 and J86 located on the feedhead P.C. Board. See Figure F.9.
3. Connect main input power to the machine.
4. Make the following voltage tests. From the tables on following page.
5. Turn the machine OFF between each test.
6. Carefully insert the meter probes into the back of each Molex plug pin cavity.
7. As you turn the encoder **slowly** the voltage will change from zero to 15 volts, to zero, to 15 volts etc. as you continue to turn the encoder.

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# TROUBLESHOOTING & REPAIR

## ENCODER PC BOARD TEST *(continued)*

VOLT/TRIM ENCODER #1			
FROM LEAD	TO LEAD	EXPECTED VOLTAGE	ACTION
855 5J85	3243 3J82	15 VDC	If you do not read 15 VDC on the first reading of encoder #1 or #2 then check lead connections. If lead connections check OK, then Feeder Board may be faulty, replace Feeder Board.
8511 11J85	3243 3J82	0 OR 15 VDC	As you turn the encoder #1 or #2 slowly you should see your meter go from 0 to 15, 0 to 15 as you turn the encoder. If not, check the lead connections. If the lead connection check OK then, change the encoder.
858 8J85	3243 3J82	0 OR 15 VDC	

WMF/AMPS ENCODER #2			
FROM LEAD	TO LEAD	EXPECTED VOLTAGE	ACTION
859 9J85	3243 3J82	15 VDC	If you do not read 15 VDC on the first reading of encoder #1 or #2 then check lead connections. If lead connections check OK, then Feeder Board may be faulty, replace Feeder Board.
857 7J85	3243 3J82	0 OR 15 VDC	As you turn the encoder #1 or #2 slowly you should see your meter go from 0 to 15, 0 to 15 as you turn the encoder. If not, check the lead connections. If the lead connection check OK then, change the encoder.

POWER MIG 350MP



# TROUBLESHOOTING & REPAIR

## CURRENT TRANSDUCER TEST



### WARNING

Service and repair should be performed by only Lincoln Electric factory trained personnel. Unauthorized repairs performed on this equipment may result in danger to the technician or machine operator and will invalidate your factory warranty. For your safety and to avoid electrical shock, please observe all safety notes and precautions detailed throughout this manual.

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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### DESCRIPTION

This test will determine if the current transducer and associated wiring are functioning correctly.

### MATERIALS NEEDED

Volt/Ohmmeter  
3/8" Nut Driver

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# TROUBLESHOOTING & REPAIR

## CURRENT TRANSDUCER TEST (*continued*)

Table F.2 – Current Transducer Feedback Voltage

OUTPUT LOAD CURRENT	EXPECTED TRANSDUCER FEEDBACK VOLTAGE
500	4.0
450	3.6
400	3.2
350	2.8
300	2.4
250	2.0
200	1.6
150	1.2
100	0.8

POWER MIG 350MP



# TROUBLESHOOTING & REPAIR

## POWER MIG 350MP SCROLLING DASHES TEST



### WARNING

Service and repair should be performed by only Lincoln Electric factory trained personnel. Unauthorized repairs performed on this equipment may result in danger to the technician or machine operator and will invalidate your factory warranty. For your safety and to avoid electrical shock, please observe all safety notes and precautions detailed throughout this manual.

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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### DESCRIPTION

ERROR CODE: Scrolling dashes on the Power MIG 350MP perform the appropriate clear all procedure as follows.

### MATERIALS NEEDED

None

POWER MIG 350MP



# TROUBLESHOOTING & REPAIR

## POWER MIG 350MP SCROLLING DASHES TEST (*continued*)

### TEST PROCEDURES:

1. Hold "select" switch up while powering up machine.
2. Release "select" switch when displays show "PrESSPin".
3. Turn the right "encoder knob" until displays show "CLrAll".
4. Toggle the "select" switch up and release.
5. Machine will reset itself.

POWER MIG 350MP



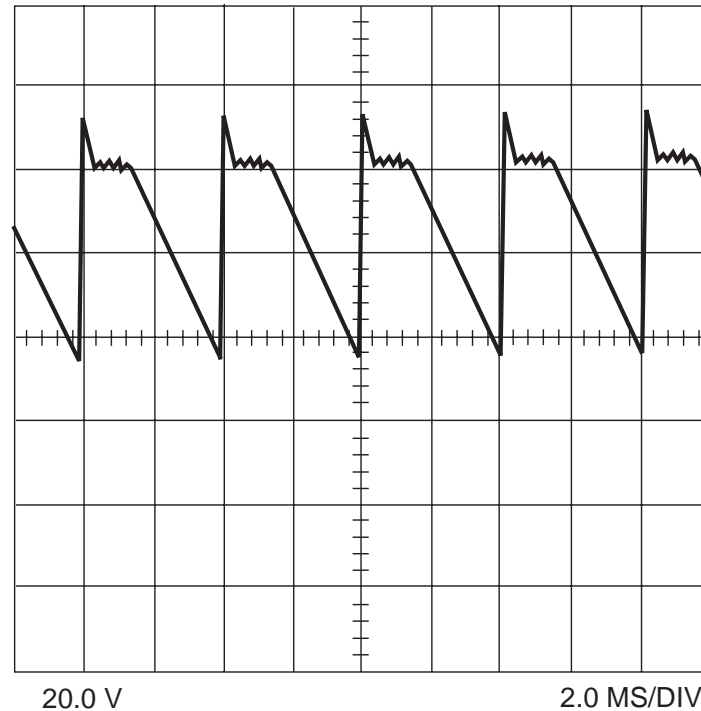
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# TROUBLESHOOTING & REPAIR

## OSCILLOSCOPE WAVEFORMS MUST BE TAKEN IN MODE 201

### NORMAL OPEN CIRCUIT VOLTAGE WAVEFORM



This is a typical DC output voltage waveform generated from a properly operating machine. Note that each vertical division represents 20 volts and that each horizontal division represents 2.00 milliseconds in time.

**NOTE:** Scope probes connected at the machine output terminals: (+) probe to electrode, (-) probe to work.

#### SCOPE SETTINGS

Volts/Div .....	20V/Div.
Horizontal Sweep ..	2.0 ms/Div.
Coupling .....	DC
Trigger .....	Internal

#### TEST SET-UP

Power MIG 350MP in mode 201. Mode 201 is a constant current test mode.

1. Toggle and hold the Mode Select switch in the up position.
2. Turn on the Power MIG 350MP.
3. Once the display reads "Pres Spin" release the mode select switch. Rotate the output knob until the display reads "ALL node".
4. Toggle the Mode Select switch once and wait for the machine to reset, then toggle the MODE SET switch until the MSPIII panel reads 201. Disengage the idler arm on the wire drive so no wire will feed.

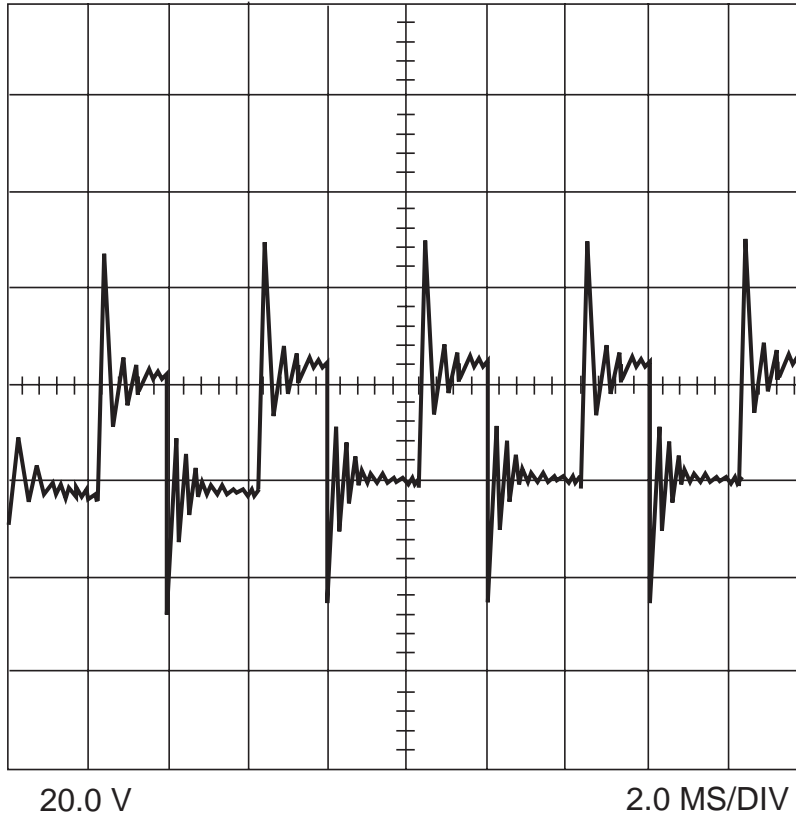
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# TROUBLESHOOTING & REPAIR

## TYPICAL OUTPUT VOLTAGE WAVEFORM - MACHINE LOADED

MACHINE LOADED TO 250 AMPS AT 26 VDC



This is a typical DC output voltage waveform generated from a properly operating machine. Note that each vertical division represents 20 volts and that each horizontal division represents 2.00 milliseconds in time.

**NOTE:** Scope probes connected at the machine output terminals: (+) probe to electrode, (-) probe to work.

### SCOPE SETTINGS

Volts/Div.....	20V/Div.
Horizontal Sweep..	2.0 ms/Div.
Coupling.....	DC
Trigger .....	Internal

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# TROUBLESHOOTING & REPAIR

## MOTOR & GEAR BOX ASSEMBLY REMOVAL AND REPLACEMENT



### WARNING

Service and repair should be performed by only Lincoln Electric factory trained personnel. Unauthorized repairs performed on this equipment may result in danger to the technician or machine operator and will invalidate your factory warranty. For your safety and to avoid electrical shock, please observe all safety notes and precautions detailed throughout this manual.

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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### DESCRIPTION

This test will aid the technician in the removal and replacement of the Motor and Gear box assembly.

### MATERIALS NEEDED

- 3/8" Nut Driver
- 5/16" Nut Driver
- 9/16" Wrench
- 7/16" Wrench
- Small Slot Head Screwdriver
- Large Phillips Head Screwdriver
- Pliers
- Wiring Diagram

POWER MIG 350MP



# TROUBLESHOOTING & REPAIR

## MOTOR & GEAR BOX ASSEMBLY REMOVAL AND REPLACEMENT *(continued)*

### REMOVAL PROCEDURE

#### **⚠ WARNING**

#### **ELECTRIC SHOCK can kill.**

High voltage is present when input power is applied to the machine.

-----

1. Disconnect main input power to the machine.
2. Remove the wire gun and wire.
3. Lift the tool tray door to allow access to the tool tray.
4. Using the 5/16" nut driver, remove the tool tray (3 screws) to gain access to the motor/gearbox assembly.
5. Disconnect motor leads 831 and 832 and tach leads 841, 844 and 847 at their in-line connectors. See the Wiring Diagram.
6. Using a 9/16" wrench, remove the bolt, lock washer, flat washer and positive lead from the wire drive assembly. Using pliers, remove the hose clamp and flex hose from the wire drive assembly. (Depends on the type of gun being used).
7. Rotate the adjustment arm assembly counterclockwise to release the tension on the idle arm.
8. Swing the idle arm up and away from the wire drive assembly.
9. Remove the outer guide assembly from the wire drive assembly by loosening the thumb screws until the outer guide can be removed. Rotate the molded keeper until the ears line up with the slots on the drive roll, then pull the drive roll off the shaft assembly. Now slide off the inner guide. See **Figure F.12**.
10. Using a 9/16" wrench to remove nut that holds molded drive roll shaft assembly to the wire drive assembly. Remove the molded drive roll shaft assembly from the wire drive assembly.
11. Using a 7/16" wrench remove panel covering the gear.
12. Using a Phillips head screwdriver remove gear.
13. Using a Phillips head screwdriver, remove the 3 pan head screws and lock washers securing the motor/gearbox assembly to the wire drive assembly.
14. Grasp the motor/gearbox assembly and wiggle it gently back and forth until it separates from the wire drive assembly.
15. Using a 3/8" nut driver remove 6 nuts that hold cover. Remove panel to expose drive motor.

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# TROUBLESHOOTING & REPAIR

## MOTOR & GEAR BOX ASSEMBLY REMOVAL AND REPLACEMENT *(continued)*

### REPLACEMENT PROCEDURE

1. Bolt the wire drive assembly to the wire drive compartment.
2. Secure the wire drive compartment to the divider panel welded assembly.
3. Mount the motor/gearbox assembly to the wire drive assembly and attach with screws.
4. Assemble the drive roll components to the wire drive assembly.
5. Attach the flex hose and clamp.
6. Attach the tool tray.
7. Attach the wire gun and wire.

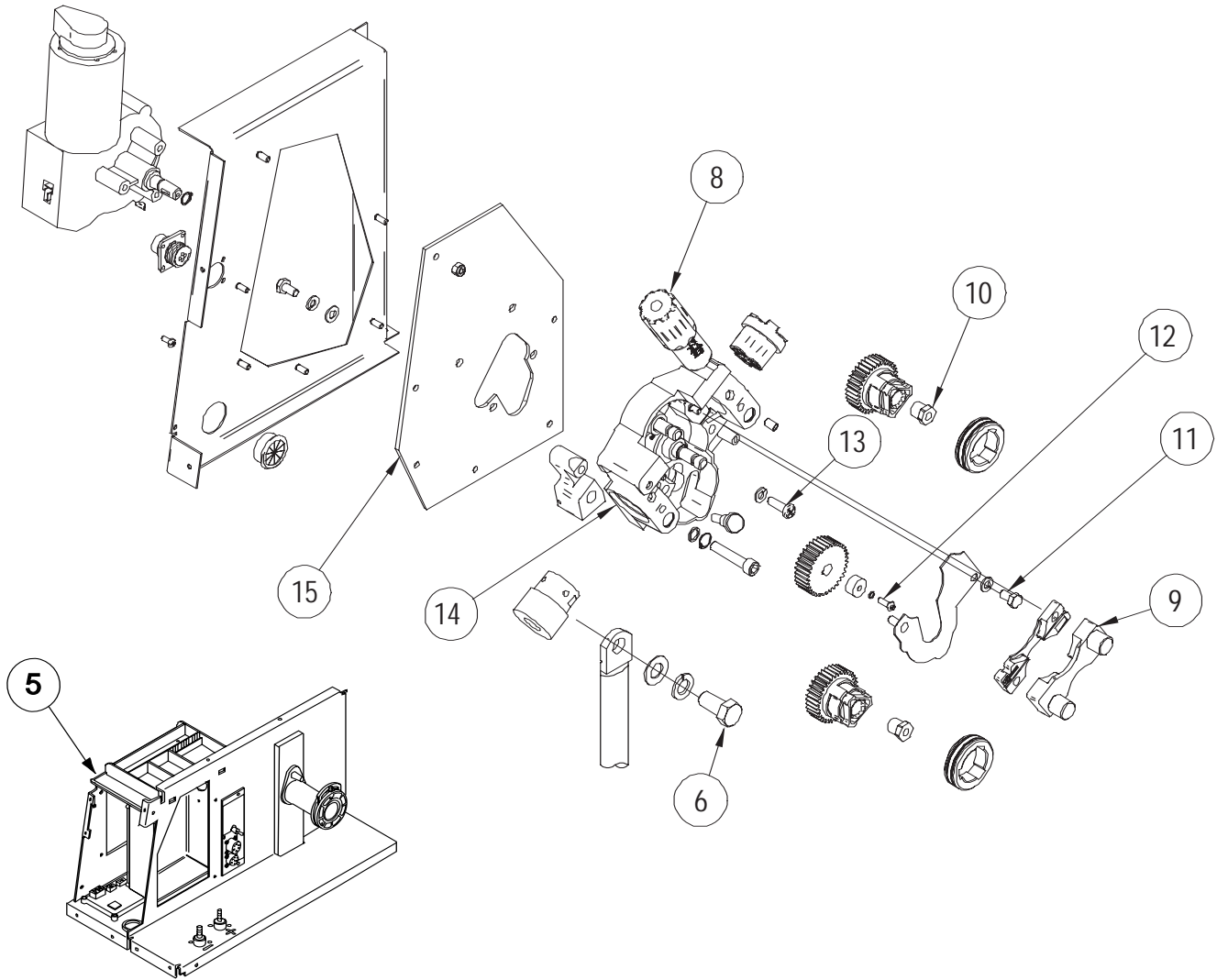
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# TROUBLESHOOTING & REPAIR

## MOTOR & GEAR BOX ASSEMBLY REMOVAL AND REPLACEMENT *(continued)*

FIGURE F.11



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# TROUBLESHOOTING & REPAIR

## OUTPUT RECTIFIER REMOVAL AND REPLACEMENT



### WARNING

Service and repair should be performed by only Lincoln Electric factory trained personnel. Unauthorized repairs performed on this equipment may result in danger to the technician or machine operator and will invalidate your factory warranty. For your safety and to avoid electrical shock, please observe all safety notes and precautions detailed throughout this manual.

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

### DESCRIPTION

The procedure will aid the technician in the removal and replacement of the output rectifier assembly.

### MATERIALS NEEDED

- 1/2" Open End Wrench
- 1/2" Socket Wrench and Extension
- 3/8" Nut Driver
- 3/8" Open End Wrench
- Slot Head Screwdriver
- Diagonal Cutters
- Dow Corning #340 Compound

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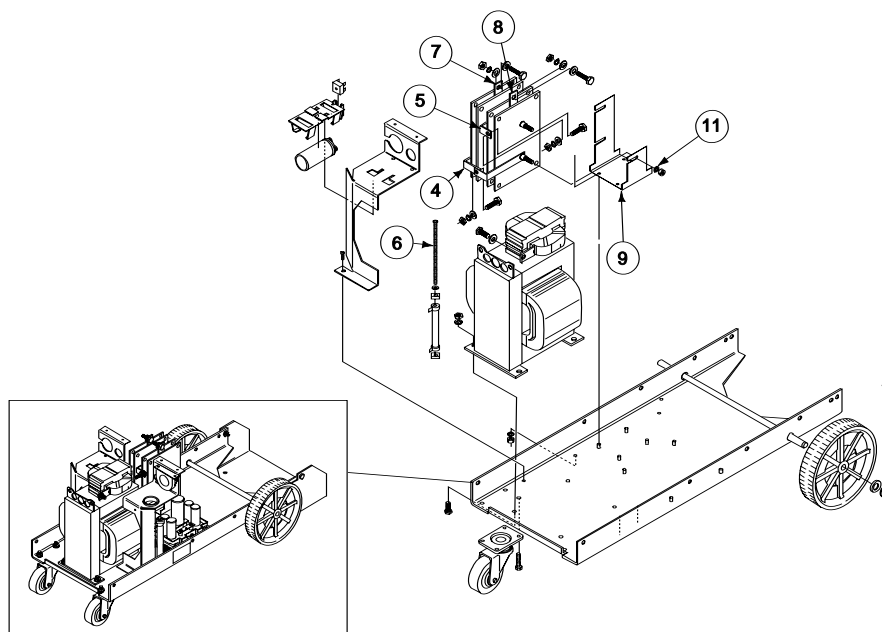




# TROUBLESHOOTING & REPAIR

## OUTPUT RECTIFIER REMOVAL AND REPLACEMENT (continued)

FIGURE F.12



### ⚠ WARNING

#### ELECTRIC SHOCK can kill.

High voltage is present when input power is applied to the machine.

**Note:** Cut cable ties as needed to improve access.

See Figure F.12 for the following procedure.

1. Disconnect main input power from the machine.
2. Perform the **Chopper Board Capacitor Discharge Procedure**.
3. Remove the right side panel using a 3/8" nut driver. (as viewed from the front of machine).
4. Using the 1/2" wrenches, remove heavy lead B1 and small resistor lead 2530 from the output rectifier lower terminal, marked negative (-). For reassembly, note placement of the fasteners: bolt, flat washer, heavy lead, small lead, terminal, flat washer, lock washer, nut.
5. Using the 1/2" wrenches, remove heavy lead B5 and small resistor lead 2520 from the output rectifier terminal marked positive (+). For reassembly, note placement of the fasteners: bolt, flat washer, heavy lead, small lead, terminal, flat washer, lock washer, nut.
6. Using a slot head screwdriver and a 3/8" wrench, remove Resistor R1 from the machine base. This will provide additional clearance for accessing fasteners and removing the rectifier. For reassembly, note order of the components for the resistor: screw, star washer, plastic insulator, resistor, plastic insulator. This assembly rests on top of the machine base. From beneath the base a flat washer, lock washer, and nut attach to the screw. It is a good practice to loosely assemble the parts and set the resistor aside until ready to be reassembled.
7. Using a 1/2" wrench and a 1/2" socket wrench with extension, remove heavy lead X2 from the terminal at the top of the rectifier, near side. For reassembly, note placement of the fasteners: bolt, flat washer, heavy lead, terminal, lock washer, nut.
8. Using a 1/2" wrench and a 1/2" socket wrench with extension, remove heavy lead X1 (from the output choke) from the other terminal at the top of the rectifier, nearer to the chopper board assembly. For reassembly, note placement of the fasteners: bolt, flat washer, heavy lead, terminal, lock washer, nut.
9. Using a 3/8" wrench, remove the 4 nuts and lock

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# TROUBLESHOOTING & REPAIR

## OUTPUT RECTIFIER REMOVAL AND REPLACEMENT *(continued)*

washers holding the rectifier bracket to the machine base.

10. Clear the leads and carefully remove the output rectifier assembly.
11. With a 1/2" wrench, loosen the 3 nuts holding the rectifier to its bracket.

### REPLACEMENT PROCEDURE

NOTE: When installing the output rectifier assembly, apply a thin coating of Dow Corning #340 compound to the electrical connections.

1. Fit the new output rectifier into its bracket.
2. Install the output rectifier. Fasten it to the machine base with 4 lock washers and nuts.
3. Install heavy leads X1 and X2 to the terminals at the top of the output rectifier. X1 mounts to the terminal nearer to the chopper board assembly. Note placement of fasteners as described above.
4. Install resistor R1.
5. Install heavy lead B5 and resistor lead 2520 to the lower terminal, marked (+).
6. Install heavy lead B1 and resistor lead 2530 to the upper terminal, marked (-).
7. Replace any cable ties removed for disassembly.
8. Install the case side panels.

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# TROUBLESHOOTING & REPAIR

## CHOPPER BOARD ASSEMBLY REMOVAL AND REPLACEMENT

### WARNING

Service and repair should be performed by only Lincoln Electric factory trained personnel. Unauthorized repairs performed on this equipment may result in danger to the technician or machine operator and will invalidate your factory warranty. For your safety and to avoid electrical shock, please observe all safety notes and precautions detailed throughout this manual.

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

### DESCRIPTION

The following procedure will aid the technician in the removal and replacement of the Chopper Board assembly. The assembly is replaced as a unit; there are no serviceable parts.

### MATERIALS NEEDED

- 5/16" Nut Driver
- 3/8" Nut Driver or Wrench
- 7/16" Open End Wrench
- 1/2" Open End Wrench
- 1/2" Socket Wrench, Universal Tool, and Extension
- 3/8" Nut Driver
- 3/8" Open End Wrench
- Diagonal Cutters
- Wiring Diagram

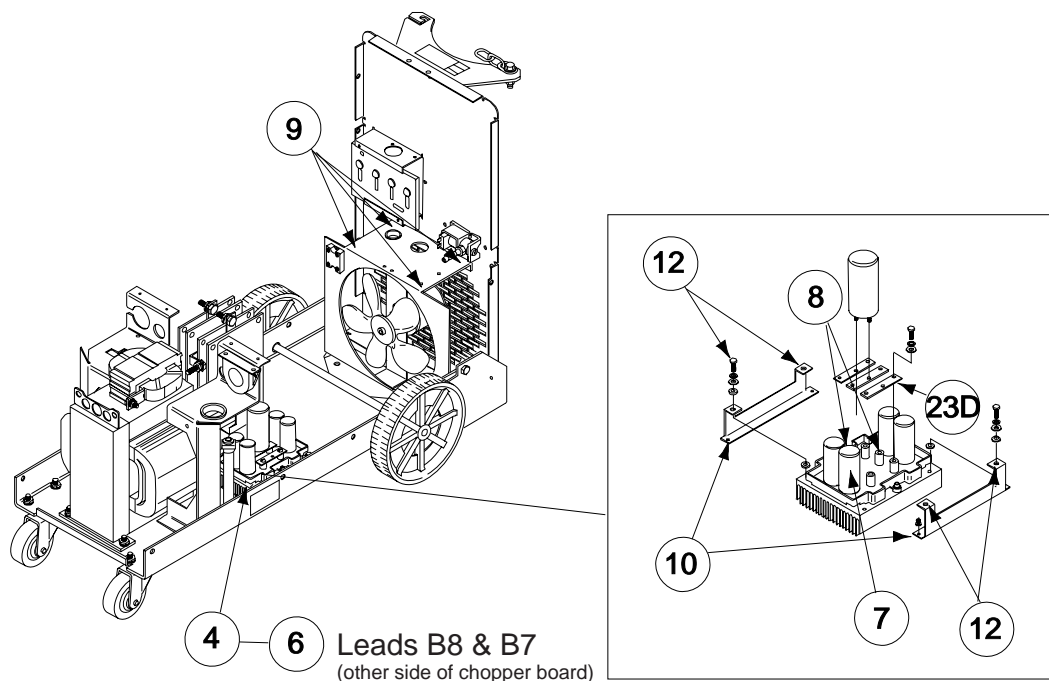
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# TROUBLESHOOTING & REPAIR

## CHOPPER BOARD ASSEMBLY REMOVAL AND REPLACEMENT *(continued)*

FIGURE F.13 – CHOPPER BOARD ASSEMBLY DETAILS



### REMOVAL PROCEDURE

#### **⚠ WARNING**

**ELECTRIC SHOCK can kill.**

High voltage is present when input power is applied to the machine.

**Note:** Cut cable ties as needed to improve access.

See Figure F.13 for the following procedure.

1. Disconnect main input power from the machine.
2. Perform the **Chopper Board Capacitor Discharge Procedure**.
3. Remove the case side panels using a 3/8" nut driver.
4. Label and disconnect thermostat leads 503 and 503A.
5. Unplug J99 from the chopper board.
6. Disconnect lead 607 from terminal B8 and lead 613 from terminal B7 at their in-line connectors.
7. Using a 7/16" wrench, remove heavy lead B8 (to negative output terminal) and B2 (to choke) from the chopper board.
8. Using a 7/16" wrench, remove heavy leads B1 and B5 (to output rectifier) from the chopper board.
9. Using the 5/16" nut driver, remove the 4 screws holding the fan baffle to the machine base. This will allow you to move the baffle back out of the way to access the right rear nut on the chopper assembly bracket.
10. Using the 3/8" wrench or nut driver, remove the 4 nuts holding the chopper assembly brackets to the machine base.
11. Carefully remove the chopper assembly from the machine.
12. Using a 7/16" wrench, remove the 2 support brackets from the chopper board assembly.

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# TROUBLESHOOTING & REPAIR

## CHOPPER BOARD ASSEMBLY REMOVAL AND REPLACEMENT *(continued)*

### REPLACEMENT PROCEDURE

1. Attach the chopper assembly brackets to the new chopper assembly.
2. Install the chopper board assembly. Fasten it to the machine base with 4 lock washers and nuts.
3. Install heavy leads B1 and B5.
4. Install heavy leads B6 and B2.
5. Connect lead 607 (B8) and lead 613 (B7) at their in-line connectors.
6. Connect plug J99.
7. Connect thermostat leads 503 and 503A.
8. Install the case side panels.

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# TROUBLESHOOTING & REPAIR

## MAIN TRANSFORMER AND OUTPUT CHOKE REMOVAL AND REPLACEMENT



### WARNING

Service and repair should be performed by only Lincoln Electric factory trained personnel. Unauthorized repairs performed on this equipment may result in danger to the technician or machine operator and will invalidate your factory warranty. For your safety and to avoid electrical shock, please observe all safety notes and precautions detailed throughout this manual.

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

### DESCRIPTION

The procedure will aid the technician in the removal and replacement of the main transformer and choke assembly.

### MATERIALS NEEDED

- 5/16" Nut Driver
- 3/8" Nut Driver or Open End Wrench
- 1/2" Open End Wrench
- 1/2" Socket Wrench and Extension
- 9/16" Open End Wrench
- Diagonal Cutters
- Phillips Head Screwdriver

POWER MIG 350MP



# TROUBLESHOOTING & REPAIR

## MAIN TRANSFORMER AND OUTPUT CHOKE REMOVAL AND REPLACEMENT *(continued)*

### REMOVAL PROCEDURE

#### WARNING

#### ELECTRIC SHOCK can kill.

High voltage is present when input power is applied to the machine.

**Note:** Cut cable ties as needed to improve access.

### PREPARATION

1. Disconnect main input power from the machine.
2. Remove the case side panels using a 3/8" nut driver.
3. Perform the **Chopper Board Capacitor Discharge Procedure**.
4. Remove the case top using a 3/8" nut driver.

5. Remove gun.
6. Remove work lead from output stud.

### CASE FRONT ASSEMBLY REMOVAL

7. Remove the case front assembly as follows:
  - a. Using a phillips head screwdriver, remove the 2 screws holding the line switch to the case front.
  - b. Using a 5/16" nut driver, remove 10 screws holding the case front to the machine base and center assembly.
  - c. Lift the case front upward and forward slightly, then disconnect plug J34 from the MSP3 mode select panel. The case front assembly can now be removed. **See Figure F.14.**

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# TROUBLESHOOTING & REPAIR

## MAIN TRANSFORMER AND OUTPUT CHOKE REMOVAL AND REPLACEMENT *(continued)*

### LEAD DISCONNECTION

8. Using a phillips head screwdriver, remove fan lead X4 from fan relay terminal #1 and disconnect fan lead X3 from its in-line connector at the fan motor. Cut cable ties as needed pull the leads through the baffles to clear them.
9. Using a 1/2" wrench, disconnect leads X1 and X2 from the output rectifier. Note the order of the fasteners for reassembly: bolt, flat washer, heavy lead, terminal, lock washer, nut.
10. Disconnect leads X5 and X6 from the control rectifier (spade connectors).
11. Disconnect thermostat leads 502 and 503A from their in-line connectors (right side of the machine).
12. Using a 3/8" nut driver, disconnect leads H2, H3, and H5 from the reconnect panel terminals 2, 3, and 5.
13. Using a 3/8" nut driver, disconnect leads H1 and H4 from the back of the line switch. Looking at the back of the switch, H1 is at the bottom right and H4 is at the bottom left. Note that leads H1 and H4, which go to the reconnect panel, attach at these same terminals.
14. Using a 1/2" wrench and socket wrench, disconnect heavy lead B2 from the choke.
15. Using a 9/16" wrench and socket wrench, disconnect the heavy lead from the choke to the positive output terminal. It is not necessary to remove any other leads; screw the bolt with leads still attached back into the positive output terminal until reassembly.

### MAIN TRANSFORMER AND CHOKE ASSEMBLY REMOVAL

16. Using a 1/2" socket wrench, remove 4 nuts and lock washers that hold the main transformer to the machine base. Also remove the 4 in. bolts from underneath.
17. Using a 5/16" nutdriver, remove the 2 screws that hold the right and left transformer baffle in place (1 screw each). The center assembly and rear

assembly can now be lifted enough to allow the main transformer and choke assembly to be removed.

18. With the help of an assistant, lift the front of the center assembly and slide the main transformer and choke assembly out through the front of the machine. Use care -- the assembly is very heavy.

### REPLACEMENT PROCEDURE

For lead reassembly steps, also see the Wiring Diagram.

1. With the help of an assistant, carefully slide the new transformer/choke assembly into place. Attach it to the machine base with 4 bolts, lock washers, and nuts.
2. Attach the right and left transformer baffles to the machine base (1 screw each side).
3. Connect the heavy lead from the top of the choke to the positive output terminal.
4. Connect heavy lead B2 to the choke.
5. Connect leads H1 and H4 to the back of the line switch. See disassembly step for details.
6. Connect leads H2, H3, and H5 to the reconnect panel.
7. Connect thermostat leads 502 and 503A at their in-line connectors (right side of the machine).
8. Connect leads X5 and X6 to the control rectifier (spade connectors).
9. Connect leads X1 and X2 to the output rectifier. Note the order of the fasteners: bolt, flat washer, heavy lead, terminal, lock washer, nut.
10. Connect fan lead X4 to fan relay terminal 1 and fan lead X3 at its in line connector at the fan motor.
11. Install the case front assembly. Connect plug J34 and mount the line switch.
12. Install new cable ties as needed.
13. Install the case sides and top.

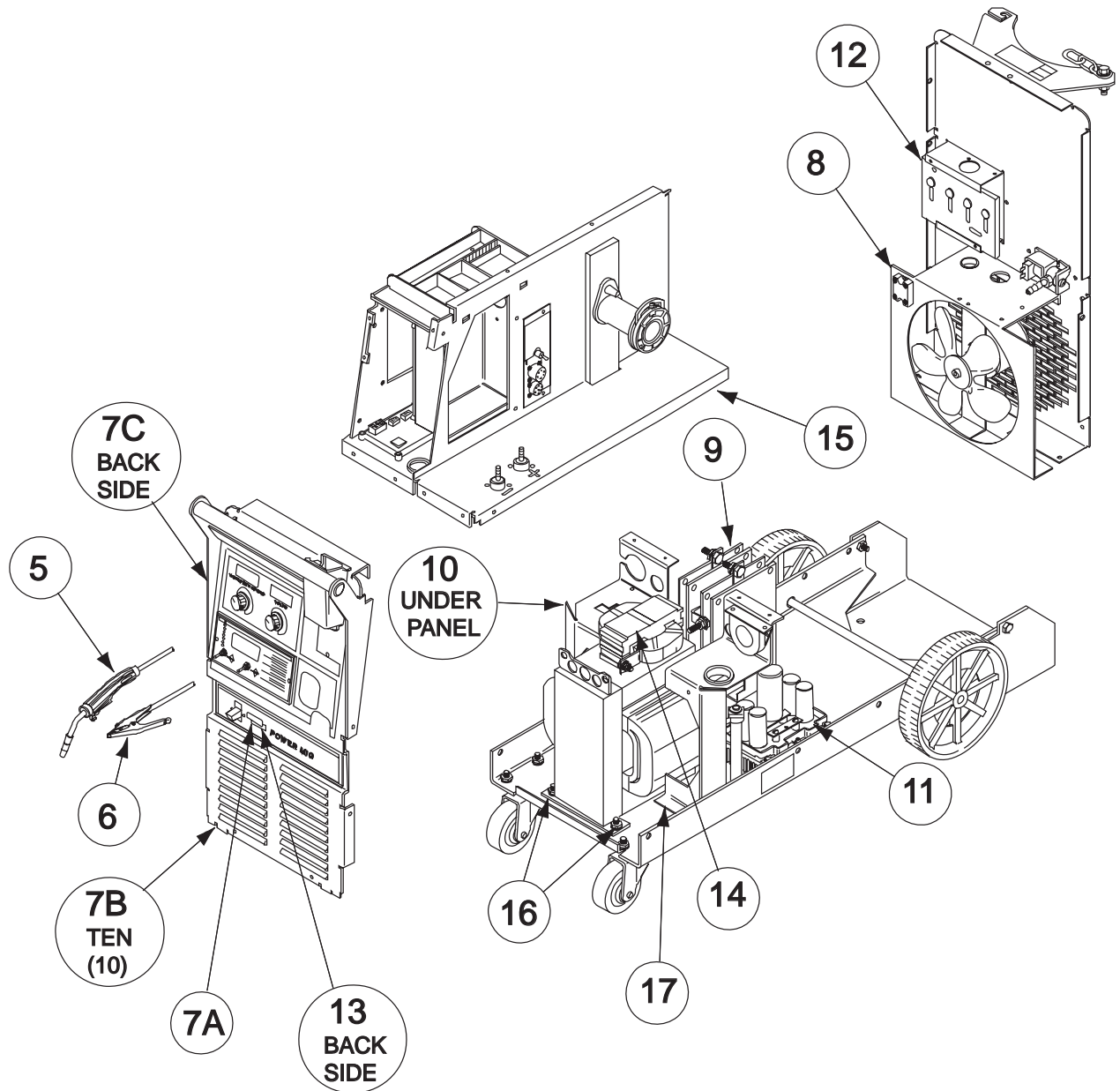
POWER MIG 350MP



# TROUBLESHOOTING & REPAIR

## MAIN TRANSFORMER AND OUTPUT CHOKE REMOVAL AND REPLACEMENT (continued)

FIGURE F.14



POWER MIG 350MP



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Return to Master TOC

# TROUBLESHOOTING & REPAIR

## FAN MOTOR ASSEMBLY REMOVAL AND REPLACEMENT



### WARNING

Service and repair should be performed by only Lincoln Electric factory trained personnel. Unauthorized repairs performed on this equipment may result in danger to the technician or machine operator and will invalidate your factory warranty. For your safety and to avoid electrical shock, please observe all safety notes and precautions detailed throughout this manual.

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

### DESCRIPTION

The procedure will aid the technician in the removal and replacement of the fan motor assembly.

### MATERIALS NEEDED

- 3/8" Nut Driver
- 11/32" Open End Wrench
- Diagonal Cutters
- Slot or Phillips Head Screwdriver

POWER MIG 350MP

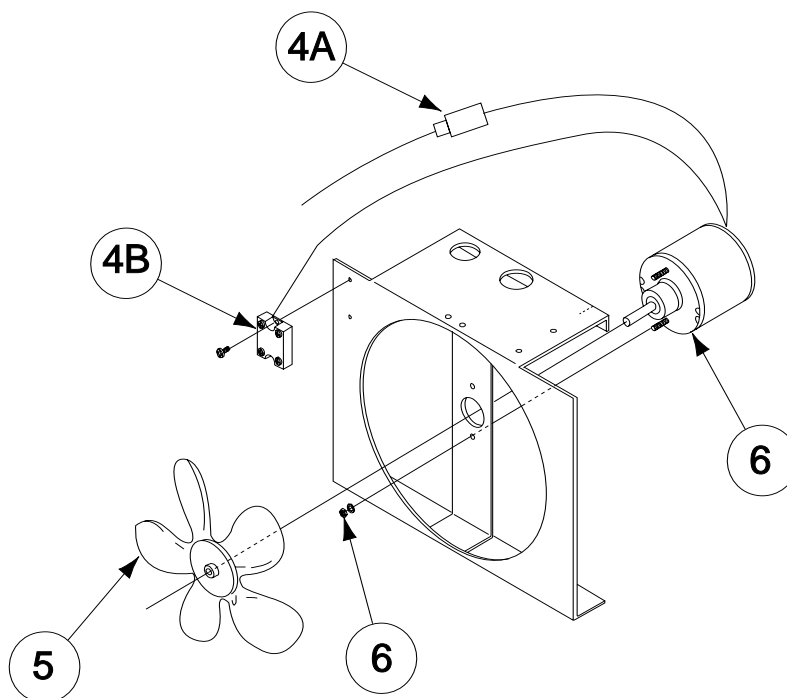


# TROUBLESHOOTING & REPAIR

## FAN MOTOR ASSEMBLY REMOVAL AND REPLACEMENT

(continued)

FIGURE F.15 – FAN MOTOR ASSEMBLY REMOVAL



### REMOVAL PROCEDURE

1. Disconnect main input power to the machine.
2. Remove the case side panels using a 3/8" nut driver.
3. Cut the wire tie from around the fan motor leads.
4. Disconnect fan motor leads:
  - a. Unplug the black lead from its in-line connector.
  - b. Using a slot or phillips head screwdriver, disconnect the white lead at the fan relay. See Figure F.15.
5. Remove the fan blade. Note the position of the fan on the shaft for reassembly.
  - a. Using a slot head screwdriver, loosen the fan blade clamp.
  - b. Slide the fan blade off the motor shaft.

6. Remove the fan motor.
  - a. Loosen and remove the two nuts and lock washers from the motor mounting bracket using a 11/32" open end wrench.
  - b. When the motor is free from the mounting bracket, slide the motor from the Power MIG unit.

### REPLACEMENT PROCEDURE

1. Attach the fan motor to the mounting bracket.
2. Install the fan blade and tighten the fan blade clamp. Ensure the fan is in the same position on the shaft as it was prior to removal. Spin the fan to be sure it is free to rotate.
3. Connect the fan motor leads: black at its in-line connector and white at fan relay terminal 1.
4. Install the case sides.

POWER MIG 350MP



# TROUBLESHOOTING & REPAIR

## VOLTAGE & CURRENT CALIBRATION PROCEDURE



### WARNING

Service and repair should be performed by only Lincoln Electric factory trained personnel. Unauthorized repairs performed on this equipment may result in danger to the technician or machine operator and will invalidate your factory warranty. For your safety and to avoid electrical shock, please observe all safety notes and precautions detailed throughout this manual.

If for any reason you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. Call 1-888-935-3877.

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### DESCRIPTION

This test will determine if the machine is capable of producing welding output as well as check and adjust, if necessary, the voltage and or current calibration.

### MATERIALS NEEDED

Resistive Load Bank  
Calibrated Test Voltmeter  
Calibrated Test Ammeter

POWER MIG 350MP



# TROUBLESHOOTING & REPAIR

## VOLTAGE & CURRENT CALIBRATION PROCEDURE (*continued*)

### CALIBRATION CHECK

The calibration of the Power MIG 350MP can be checked using a resistive load bank with the Power MIG 350MP in mode 200. Mode 200 is a constant current test mode.

1. Toggle and hold the mode select switch in the up position.
2. Turn on the Power MIG 350MP.
3. Once the display reads "PrESSpin" release the mode select switch. Rotate the output knob until the display reads "ALL nodE".
4. Toggle the Mode Select switch once and wait for the machine to reset, then toggle the MODE SET switch until the MSPill panel reads 200. Disengage the idler arm on the wire drive so no wire will feed.
5. With the machine in mode 200 apply a resistive to the welding output terminals (approx. .106 ohms) set the machine output to 250 amps and enable the weld terminals by pressing the trigger switch.
6. Using the test meters note the output voltage and current.
7. The Power MIG 350MP voltmeter must match the test meter reading to within +/- 1 volt.
8. The Power MIG 350MP ammeter must match the test meter within +/- 5 amps.
9. If the volt meter does not meet the specification then proceed to the **Voltage Calibration Procedure**.
10. If the ammeter does not meet the specification then proceed to the **Current Calibration Procedure**.

NOTE: Before attempting to calibrate the voltage or current setting of the Power MIG, be sure to read the entire voltage or current calibration procedure. If the steps are not completed quickly, the machine will automatically leave the calibration mode without changing the calibration settings. The voltage and current calibration settings of the Power MIG are completely independent of each other. Adjusting one will not affect the other.

### VOLTAGE CALIBRATION

1. Connect the resistive load bank (approximately .106 ohms) and test voltmeter to the welding output terminals.
2. Toggle and hold in the mode select switch in the up position.
3. Turn on the Power Mig 350MP.
4. Once the display reads "Pres Spin" release the mode select switch. Rotate the output knob until the display reads "vol cAL".
5. Release the mode select switch once.
6. The left display will change to "VcAL" to indicate that voltage calibration is in progress.
7. The right hand display will scroll the following message: Adj rEnc SorEAL vol = 20V.
8. Adjust output control knob until the actual output voltage reading on the test volt meter is 20 volts +/- .5 volts.

POWER MIG 350MP



## TROUBLESHOOTING & REPAIR

### VOLTAGE & CURRENT CALIBRATION PROCEDURE (*continued*)

9. Wait for the machine's output to be automatically turned off and then back on.
10. Adjust the output control knob again if necessary to make the actual voltage output 20 volts +/- .5 volts.
11. Wait for the machine's output to be automatically turned off and then back on.
12. Repeat the above two steps if necessary.
13. Toggle the mode select switch up and release the switch to save the calibration setting.
14. The right display will display the message "VcAL SAVEd". Within 5 seconds, hold the mode set switch in the up position until the right display stops blinking.
15. The machine will reset to normal operation after a few seconds.

NOTE: If the mode select switch is not toggled within 30 seconds after adjusting the output control knob, the machine will leave the calibration mode and use the previous calibration settings.

### CURRENT CALIBRATION PROCEDURE

1. Connect the resistive load bank of approx. .106 ohms and test ammeter to the welding output terminals.
2. Toggle and hold the mode select button in the up position.
3. Turn on the Power MIG 350MP.
4. Once the display reads "PrESSpin" release the mode select switch. Rotate the output knob until the display reads "cur cAL".

5. Toggle the Mode Select switch once.
6. The left display will change to "IcAL" to indicate that current calibration is in progress.
7. The right hand display will scroll the following message: Adj rEnc SorEAL cur = 250A.
8. Adjust the right hand output control knob until the actual output current reading on the test ammeter is 250 amps +/- 2A.
9. Wait for the machine's output to be automatically turned off and then back on.
10. Adjust the output control knob again if necessary to make the actual output current reading on the test ammeter 250 amps +/- 2A.
11. Wait for the machine's output to be automatically turned off and then back on.
12. Repeat the above two steps if necessary.
13. Toggle the mode select switch up and release the switch to save the calibration setting.
14. The right display will display the message "IcAL SAVEd". Within 5 seconds, hold the mode set switch in the up position until the right display stops blinking.
15. The machine will reset to normal operation after a few seconds.

NOTE: If the mode select switch is not toggled within 30 seconds after adjusting the output control knob, the machine will leave the calibration mode and use the previous calibration settings.

### POWER MIG 350MP





# TROUBLESHOOTING & REPAIR

## RETEST AFTER REPAIR

Retest a machine:

- If it is rejected under test for any reason that requires you to remove any part which could affect the machine's electrical characteristics.

OR

- If you repair or replace any electrical components.

<b>TEST MODE</b>
5

### INPUT IDLE WATTS AND AMPS

Input Volts/Hertz	Maximum Idle Watts	Maximum Idle Amps
230/60	400	4.25

### OPEN CIRCUIT VOLTAGE

45-49 VDC
-----------

### WIRE SPEED RANGE

50 - 700 IPM (1.27 - 17.8 m/minute)
-------------------------------------

### OUTPUT

AMPS	VOLTS
200A	27-30

### 115VAC RECEPTACLE

AMPS	VOLTS
15A	110-125VAC

POWER MIG 350MP



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POWER MIG 350MP



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\* NOTE: Many PC Board Assemblies are now totally encapsulated and are therefore considered to be unserviceable. The Assembly drawings are provided for reference only.

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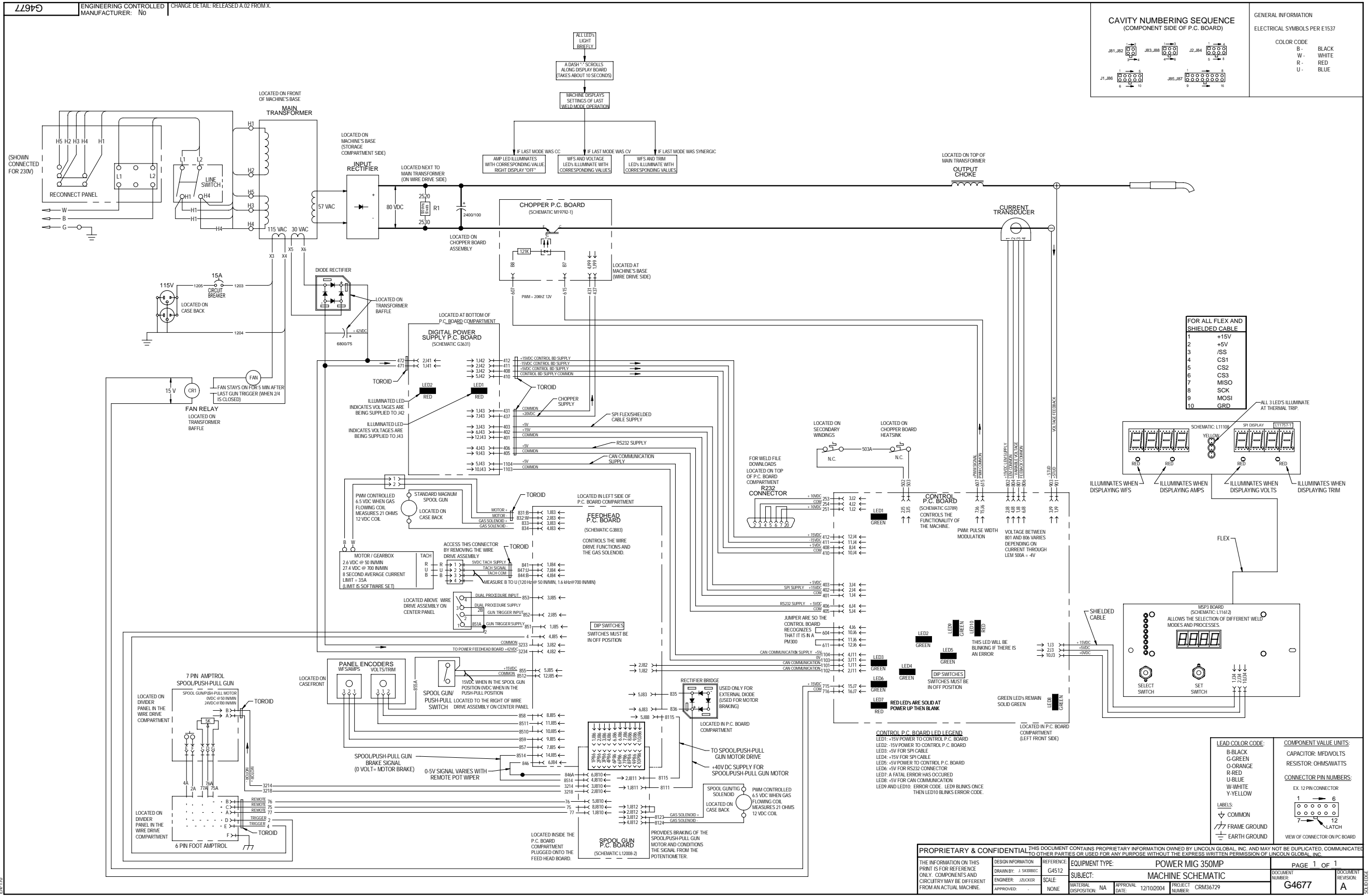
SCHEMATIC - ENTIRE MACHINE

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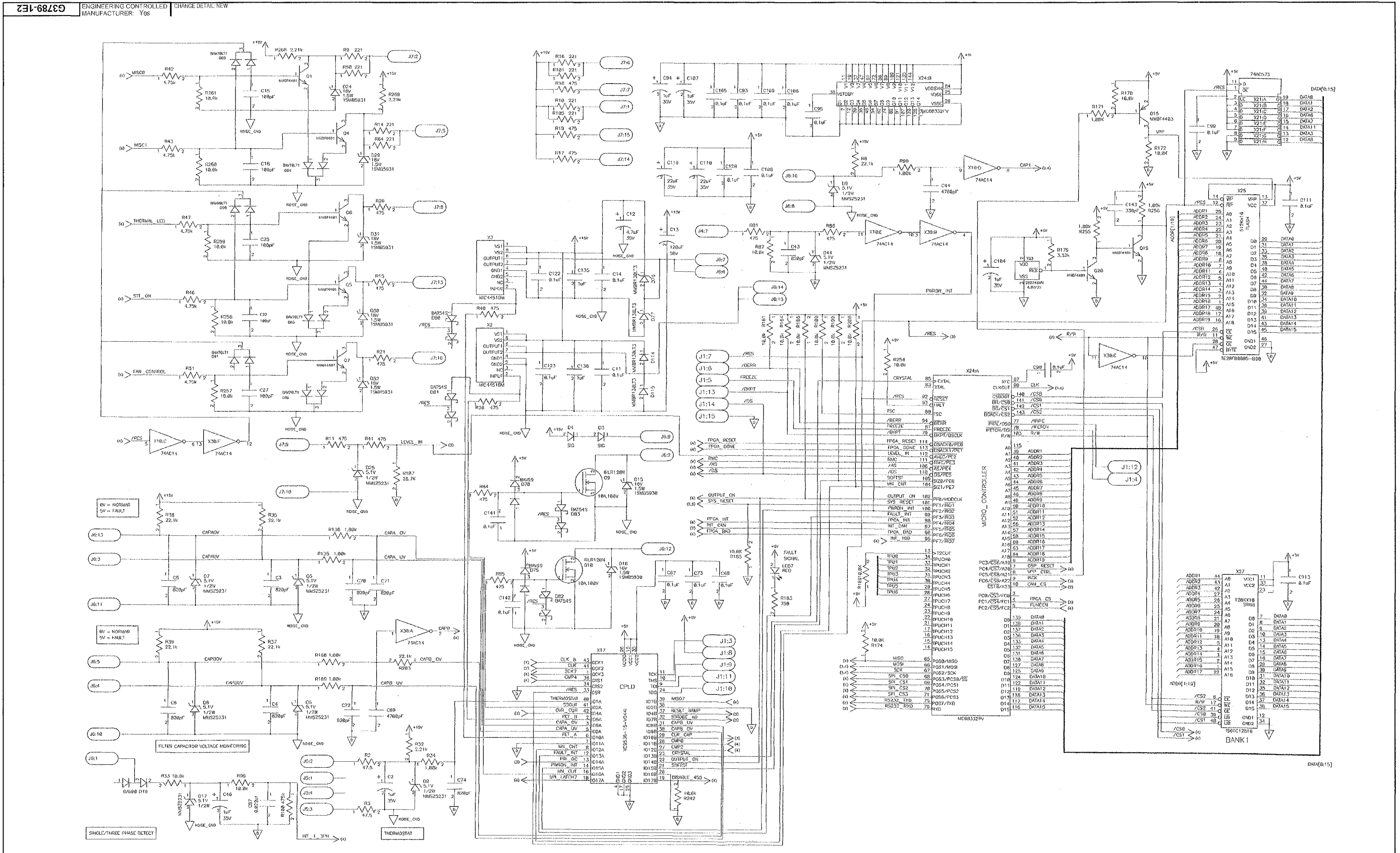
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NOTE: This diagram is for reference only. It may not be accurate for all machines covered by this manual.



SCHEMATIC - CONTROL PC BOARD (G3789-1E2/1)



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G3789-1E2	SCHEMATIC DIGITAL CONTROL	G3789-1E2	NONE	A

NOTE: This diagram is for reference only. It may not be accurate for all machines covered by this manual.









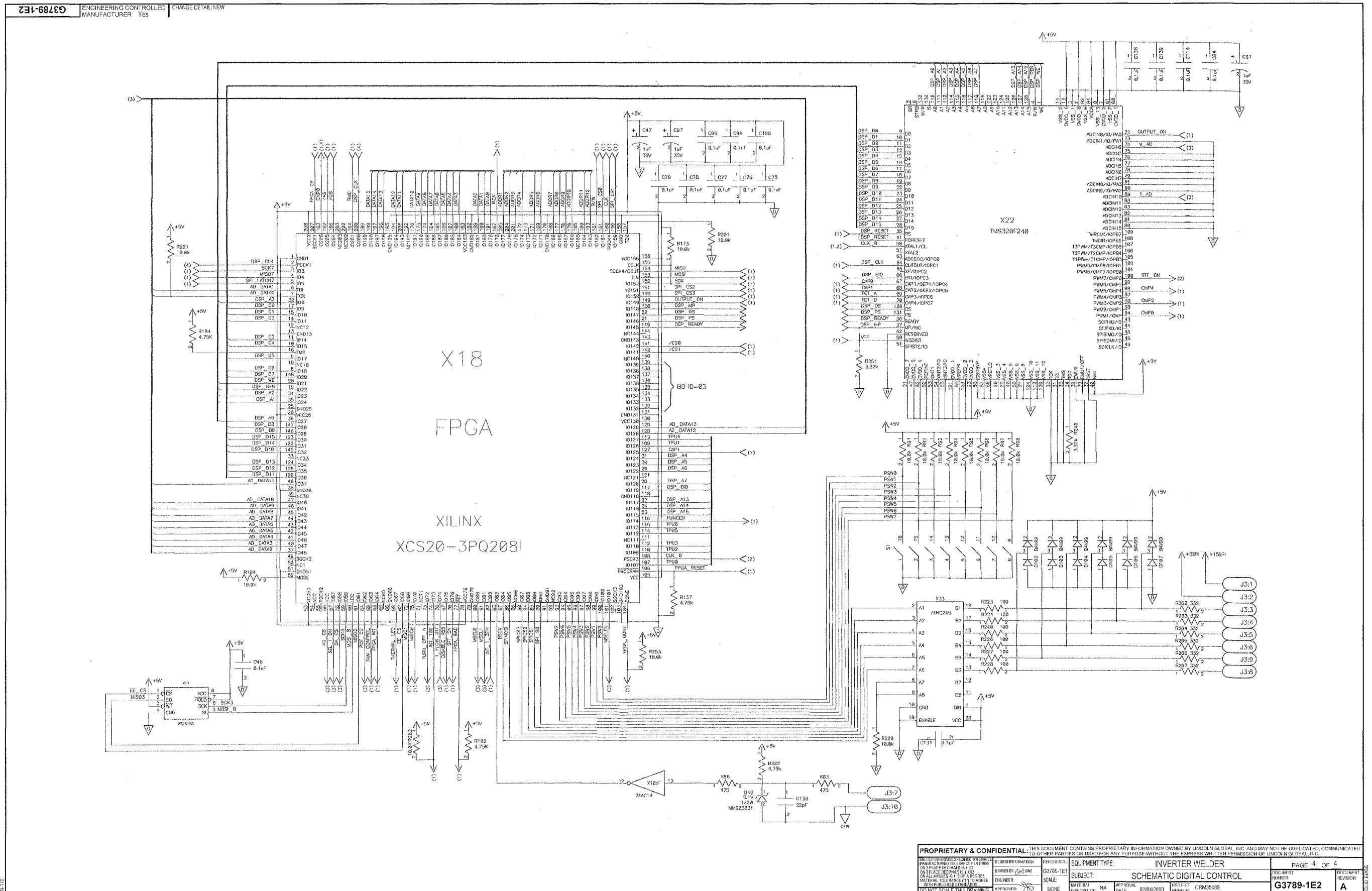
SCHEMATIC - CONTROL PC BOARD (G3789-1E2/4)

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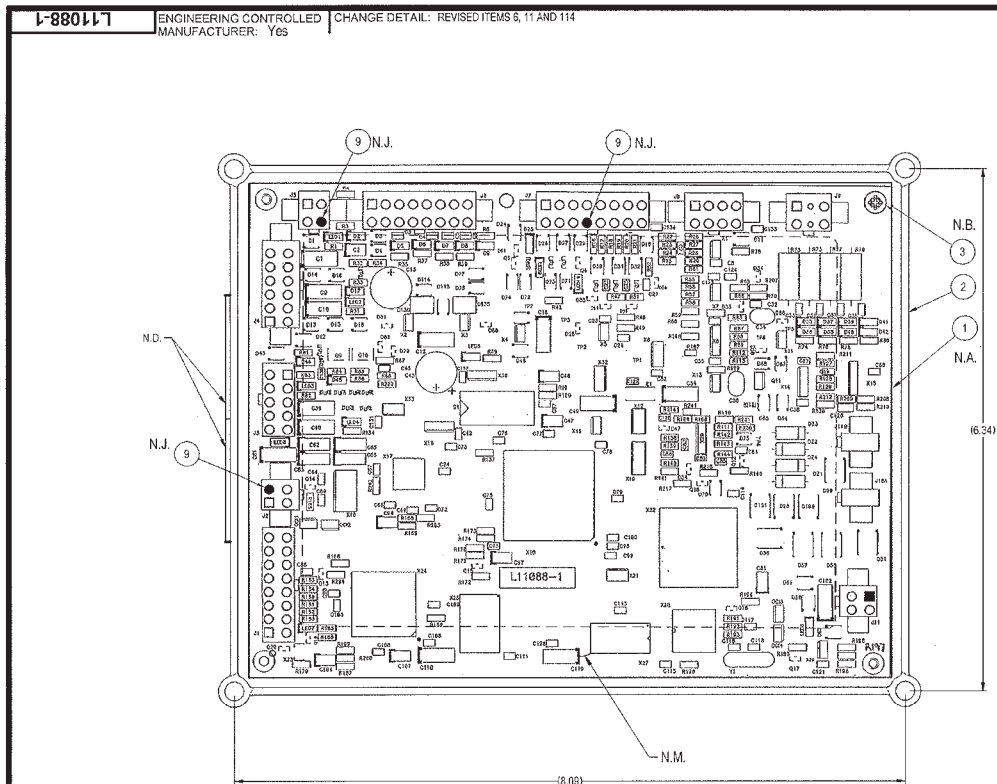


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DESIGN INFORMATION	REVISIONS	EQUIPMENT TYPE	INVERTER WELDER
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APPROVED	DATE	PROJECT NUMBER	CRMS5089
DATE	DATE	REVISION	REVISION
		G3789-1E2	A

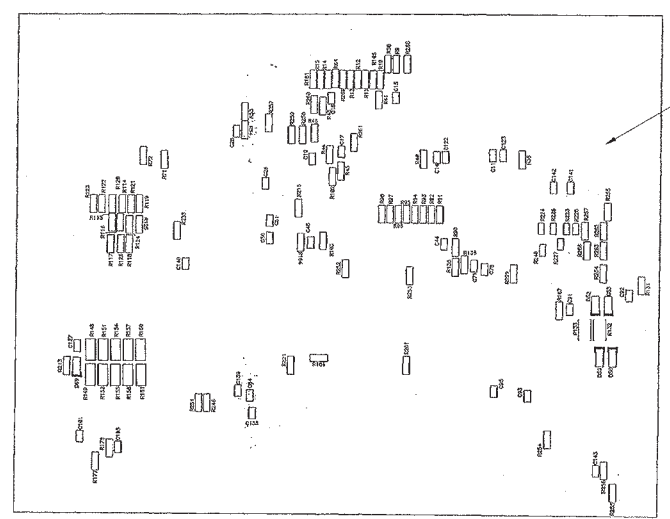
NOTE: This diagram is for reference only. It may not be accurate for all machines covered by this manual.



PC BOARD ASSEMBLY - CONTROL (L11088-1)



COMPONENT SIDE



OPPOSITE COMPONENT SIDE (BACKSIDE)

ITEM	PART NO.	REQ'D	DESCRIPTION	REFERENCE-DESIGNATOR
1	L11088-1	1	DIGITAL CONTROL, P.C. BD. BLANK (REF. ONLY)	
2	M19436-1	1	POTTING TRAY	
3	S28025-50	2	SELF TAPPING SCREW	
4	E2627	6.01 oz	EPOXY ENCAPSULATION RESIN	
5	E3839	0.01 oz	ELECTRICAL INSULATING COMPOUND	
6	S26282-2	1	FLASH SOFTWARE	
7	S24804-3	1	CPUD FIRMWARE	
9	S24871	3	PLUG, KEYING PLUG	
FOR ITEMS LISTED BELOW REFER TO ELECTRICAL DATABASE FOR COMPONENT SPECIFICATIONS				
10	E1858-4	2	LAB. TH153-423-3 BRADY PLY	Barcode Labels
11	S25020-15SMT	4	SCAP, 220F, 50V, COG, 5%, TR, NI	C18 C18 C18 C18
12	S25024-10SMT	4	SCAP, 220F, 10V, 75%, 10%	C19 C19 C19 C19
13	S25024-5SMT	9	SCAP, 100F, 50V, 10%, TR, NP	C19 C19 C19 C19 C19 C19 C19 C19 C19
14	S25022-23SMT	1	SCAP, 1000F, CER, 120V, 50V, X7R, 10%	C19
15	S13490-183	1	SCAP, 1000F, 25V, 20%, RADIAL, AE	C19
16	S13490-173	2	CAP, 1uF, RA, 35V, 10%, NP	C19 C19
17	S25020-3SMT	69	SCAP, 0.1uF, 50V, 50%, X7R, 10%, TR	C7 C8 C9 C10 C11 C12 C13 C14 C15 C16 C17 C18 C19 C20 C21 C22 C23 C24 C25 C26 C27 C28 C29 C30 C31 C32 C33 C34 C35 C36 C37 C38 C39 C40 C41 C42 C43 C44 C45 C46 C47 C48 C49 C50 C51 C52 C53 C54 C55 C56 C57 C58 C59 C60 C61 C62 C63 C64 C65 C66 C67 C68 C69 C70 C71 C72 C73 C74 C75 C76 C77 C78 C79 C80 C81 C82 C83 C84 C85 C86 C87 C88 C89 C90 C91 C92 C93 C94 C95 C96 C97 C98 C99 C100 C101 C102 C103 C104 C105 C106 C107 C108 C109 C110 C111 C112 C113 C114 C115 C116 C117 C118 C119 C120 C121 C122 C123 C124 C125 C126 C127 C128 C129 C130 C131 C132 C133 C134 C135 C136 C137 C138 C139 C140 C141 C142 C143 C144 C145 C146 C147 C148 C149 C150 C151 C152 C153 C154 C155 C156 C157 C158 C159 C160 C161 C162 C163 C164 C165 C166 C167 C168 C169 C170 C171 C172 C173 C174 C175 C176 C177 C178 C179 C180 C181 C182 C183 C184 C185 C186 C187 C188 C189 C190 C191 C192 C193 C194 C195 C196 C197 C198 C199 C200 C201 C202 C203 C204 C205 C206 C207 C208 C209 C210 C211 C212 C213 C214 C215 C216 C217 C218 C219 C220 C221 C222 C223 C224 C225 C226 C227 C228 C229 C230 C231 C232 C233 C234 C235 C236 C237 C238 C239 C240 C241 C242 C243 C244 C245 C246 C247 C248 C249 C250 C251 C252 C253 C254 C255 C256 C257 C258 C259 C260 C261 C262 C263 C264 C265 C266 C267 C268 C269 C270 C271 C272 C273 C274 C275 C276 C277 C278 C279 C280 C281 C282 C283 C284 C285 C286 C287 C288 C289 C290 C291 C292 C293 C294 C295 C296 C297 C298 C299 C300 C301 C302 C303 C304 C305 C306 C307 C308 C309 C310 C311 C312 C313 C314 C315 C316 C317 C318 C319 C320 C321 C322 C323 C324 C325 C326 C327 C328 C329 C330 C331 C332 C333 C334 C335 C336 C337 C338 C339 C340 C341 C342 C343 C344 C345 C346 C347 C348 C349 C350 C351 C352 C353 C354 C355 C356 C357 C358 C359 C360 C361 C362 C363 C364 C365 C366 C367 C368 C369 C370 C371 C372 C373 C374 C375 C376 C377 C378 C379 C380 C381 C382 C383 C384 C385 C386 C387 C388 C389 C390 C391 C392 C393 C394 C395 C396 C397 C398 C399 C400 C401 C402 C403 C404 C405 C406 C407 C408 C409 C410 C411 C412 C413 C414 C415 C416 C417 C418 C419 C420 C421 C422 C423 C424 C425 C426 C427 C428 C429 C430 C431 C432 C433 C434 C435 C436 C437 C438 C439 C440 C441 C442 C443 C444 C445 C446 C447 C448 C449 C450 C451 C452 C453 C454 C455 C456 C457 C458 C459 C460 C461 C462 C463 C464 C465 C466 C467 C468 C469 C470 C471 C472 C473 C474 C475 C476 C477 C478 C479 C480 C481 C482 C483 C484 C485 C486 C487 C488 C489 C490 C491 C492 C493 C494 C495 C496 C497 C498 C499 C500 C501 C502 C503 C504 C505 C506 C507 C508 C509 C510 C511 C512 C513 C514 C515 C516 C517 C518 C519 C520 C521 C522 C523 C524 C525 C526 C527 C528 C529 C530 C531 C532 C533 C534 C535 C536 C537 C538 C539 C540 C541 C542 C543 C544 C545 C546 C547 C548 C549 C550 C551 C552 C553 C554 C555 C556 C557 C558 C559 C560 C561 C562 C563 C564 C565 C566 C567 C568 C569 C570 C571 C572 C573 C574 C575 C576 C577 C578 C579 C580 C581 C582 C583 C584 C585 C586 C587 C588 C589 C590 C591 C592 C593 C594 C595 C596 C597 C598 C599 C600 C601 C602 C603 C604 C605 C606 C607 C608 C609 C610 C611 C612 C613 C614 C615 C616 C617 C618 C619 C620 C621 C622 C623 C624 C625 C626 C627 C628 C629 C630 C631 C632 C633 C634 C635 C636 C637 C638 C639 C640 C641 C642 C643 C644 C645 C646 C647 C648 C649 C650 C651 C652 C653 C654 C655 C656 C657 C658 C659 C660 C661 C662 C663 C664 C665 C666 C667 C668 C669 C670 C671 C672 C673 C674 C675 C676 C677 C678 C679 C680 C681 C682 C683 C684 C685 C686 C687 C688 C689 C690 C691 C692 C693 C694 C695 C696 C697 C698 C699 C700 C701 C702 C703 C704 C705 C706 C707 C708 C709 C710 C711 C712 C713 C714 C715 C716 C717 C718 C719 C720 C721 C722 C723 C724 C725 C726 C727 C728 C729 C730 C731 C732 C733 C734 C735 C736 C737 C738 C739 C740 C741 C742 C743 C744 C745 C746 C747 C748 C749 C750 C751 C752 C753 C754 C755 C756 C757 C758 C759 C760 C761 C762 C763 C764 C765 C766 C767 C768 C769 C770 C771 C772 C773 C774 C775 C776 C777 C778 C779 C780 C781 C782 C783 C784 C785 C786 C787 C788 C789 C790 C791 C792 C793 C794 C795 C796 C797 C798 C799 C800 C801 C802 C803 C804 C805 C806 C807 C808 C809 C810 C811 C812 C813 C814 C815 C816 C817 C818 C819 C820 C821 C822 C823 C824 C825 C826 C827 C828 C829 C830 C831 C832 C833 C834 C835 C836 C837 C838 C839 C840 C841 C842 C843 C844 C845 C846 C847 C848 C849 C850 C851 C852 C853 C854 C855 C856 C857 C858 C859 C860 C861 C862 C863 C864 C865 C866 C867 C868 C869 C870 C871 C872 C873 C874 C875 C876 C877 C878 C879 C880 C881 C882 C883 C884 C885 C886 C887 C888 C889 C890 C891 C892 C893 C894 C895 C896 C897 C898 C899 C900 C901 C902 C903 C904 C905 C906 C907 C908 C909 C910 C911 C912 C913 C914 C915 C916 C917 C918 C919 C920 C921 C922 C923 C924 C925 C926 C927 C928 C929 C930 C931 C932 C933 C934 C935 C936 C937 C938 C939 C940 C941 C942 C943 C944 C945 C946 C947 C948 C949 C950 C951 C952 C953 C954 C955 C956 C957 C958 C959 C960 C961 C962 C963 C964 C965 C966 C967 C968 C969 C970 C971 C972 C973 C974 C975 C976 C977 C978 C979 C980 C981 C982 C983 C984 C985 C986 C987 C988 C989 C990 C991 C992 C993 C994 C995 C996 C997 C998 C999

ITEM	PART NO.	REQ'D	DESCRIPTION	REFERENCE-DESIGNATOR
78	S25001-1005SMT	2	SRES, 1M, 1206, 1%, 18W, TR	R217 R211
79	S25000-1005SMT	5	SRES, 100,000, 1%, 170W, TR	R223 R234 R240 R226 R227 R228
80	S25001-4752SMT	8	SRES, 47.5K, 1206, 1%, 18W, TR	R230 R227 R28 R26 R33 R29 R110 R57
81	S25001-2211SMT	2	SRES, 2.21K, 1206, 1%, 18W, TR	R24 R23
82	S25001-3320SMT	6	SRES, 332, 1206, 1%, 14W, TR	R25 R13 R12 R32 R1 R31 R134 R66 R268 R369
83	S25001-4752SMT	2	SRES, 47.5K, 1206, 1%, 14W, TR	R267 R283 R254 R265 R256 R267
84	S25001-2212SMT	6	SRES, 22.1K, 1206, 1%, 18W, TR, NP	R3 R2
85	S25001-1603SMT	10	SRES, 100K, 1206, 1%, 18W, 200PPM, NI	R37 R36 R35 R283 R8 R39
86	S25001-2210SMT	13	SRES, 22.1, 1206, 1%, 18W, TR	R55 R111 R49 R108 R115 R124 R142 R208 R207 R109
87	S25001-1603SMT	4	SRES, 100, 1206, 1%, 18W, TR, NP	R62 R44 R52 R50
88	S25001-3322SMT	3	SRES, 33.2K, 1206, 1%, 18W, TR, NP	R63 R66 R233
89	S25001-1213SMT	1	SRES, 12.1K, 1206, 1%, 14W, TR	R70
90	S25003-1603	4	SRES, 100K, 1X, 5%, 1024H, VOLT, TR	R73 R79 R75 R77
91	S15859-8	1	SWT, 7805, 5.0V, SPST, SP, NP	S1
92	S15128-13SMT	1	SIC, OP-27C, OPAMP, SO8, TR, NP	X1
93	S25055-35SMT	2	SIC, 74VHC14, NP	X10 X30
94	S25059-25SMT	1	SIC, 26128, SERIAL, E2PR, NP	X11
95	M15105-9SMT	1	SIC, 745 (old package)	X12
96	S25057-35SMT	2	SIC, AD747, SPST, CMOS, SWT, SO8	X13 X31
97	S25059-25SMT	1	SIC, MCM4516M	X23
98	S25053-12SMT	1	SIC, MCM4548, RECEIVER/DRIVER, S	X16
99	S25070-35SMT	1	SIC, X28556-15 VQ44	X17
100	XXXX	1	Programmed Device	X17
101	XXXX	2	LABEL	X17, X35 LABEL
102	S25070-48SMT	1	SIC, XC520, FPGA	X18
103	S25065-25SMT	1	SIC, AD7828, DUAL, 12BIT, 200KSPS	X19
104	S15019-21SMT	2	SIC, MCM4516M	X23
105	S25055-25SMT	1	SIC, 74AC125, OCTAL, TRANS, J, AT	X23
106	S25070-75SMT	1	SIC, TMS320F240PQ3, NP	X22
107	S25068-75SMT	1	SIC, 4.5V, 2N, VOLT, DETECTOR, SO	X23
108	M15101-14SMT	1	SIC, MCM58332	X24
109	S25069-38SMT	1	SIC, 28F0005-90, FLASH, R0, 90n	X25
110	XXXX	1	SM800-268 Programmed Device	X25
111	S25069-45SMT	1	SIC, 726C16, 20k, 150P	X27
112	S25039-9	1	SIC, AN5257	X28
113	S25053-48SMT	1	SIC, MAX766ESA, NP	X28
114	S17900-11SMT	1	74HC245, NEW PACKAGE	X33
115	S25069-65SMT	1	SIC, MCM7L06ABD	X4
116	S15128-21SMT	2	SIC, LT1019, COMPARATOR	X5 X7
117	S25057-35SMT	2	SIC, AD6838ARU10	X6 X32
118	S15128-16SMT	3	SIC, MCM3074, QUAD, OPAMP, SO14, T	X8 X14 X20
119	S25062-15SMT	1	SXTL, 16M42, HC40, 2PPF, NP	X11

NOTES:

N.A. CAUTION: THIS DEVICE IS SUBJECT TO DAMAGE BY STATIC ELECTRICITY. LINCOLN ELECTRIC TO SEE E2454 BEFORE HANDLING.

N.B. SECURE P.C. BOARD ASSEMBLY IN PLACE WITH (ITEM 3) (2 PLACES, 4.8-5.8 IN. LBS.)

N.C. TOP OF THESE COMPONENTS MUST BE FREE OF POTTING MATERIAL.

N.D. PLACE BARCODED ASSEMBLY NUMBER IDENTIFICATION AND BARCODED SERIAL NUMBER IDENTIFICATION IN AREA SHOWN.

N.E. THERE ARE COMPONENTS ON BOTTOM SIDE OF P.C. BOARD.

N.F. PROGRAM ITEM 109 WITH ITEM 6.

N.G. PROGRAM ITEM 99 WITH ITEM 7.

N.J. PLACE CONNECTOR KEYING PLUG (ITEM 9) OVER HEADER PIN, IN LOCATION SHOWN. PLUG SHOULD BE INSERTED BELOW CONNECTOR TOP SURFACE.

N.K. ALL CONNECTORS MUST BE GREASED WITH (ITEM 5) PRIOR TO ENCAPSULATION.

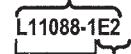
N.L. ENCAPSULATION PER E1911-E TO A MINIMUM DEPTH, SUCH THAT ALL COMPONENT LEADS ARE COVERED.

N.M. SOLDER A #30 INSULATED COPPER WIRE FROM PIN 23 OF X27 TO POSITIVE TERMINAL ON C119 AS SHOWN.

CAPACITORS = MFD/VOLTS  
 INDUCTANCE = HENRIES  
 RESISTANCE = OHMS

SCHEMATIC REF. G3789-1E2

BUY AS



PART NO. IDENTIFICATION CODE

BUY PER E3867  
TEST PER E3856-C

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DESIGN INFORMATION	REFERENCE	EQUIPMENT TYPE:	INVERTER WELDERS
MANUFACTURING TOLERANCE PER ASME	DATE	SCALE:	NONE
DRAWN BY: EWS	ENGINEER	SUBJECT:	CONTROL P.C. BOARD AS'BLY
APPROVED: DLS	DATE:	MATERIAL DESCRIPTION:	UF
		APPROVAL DATE:	8/2/2005
		PROJECT NUMBER:	CRM22115-FM
		PAGE	1 OF 1
		DOCUMENT NUMBER:	L11088-1
		DOCUMENT REVISION:	E

NOTE: Lincoln Electric assumes no responsibility for liabilities resulting from board level troubleshooting. PC Board repairs will invalidate your factory warranty. Individual Printed Circuit Board Components are not available from Lincoln Electric. This information is provided for reference only. Lincoln Electric discourages board level troubleshooting and repair since it may compromise the quality of the design and may result in danger to the Machine Operator or Technician. Improper PC board repairs could result in damage to the machine.



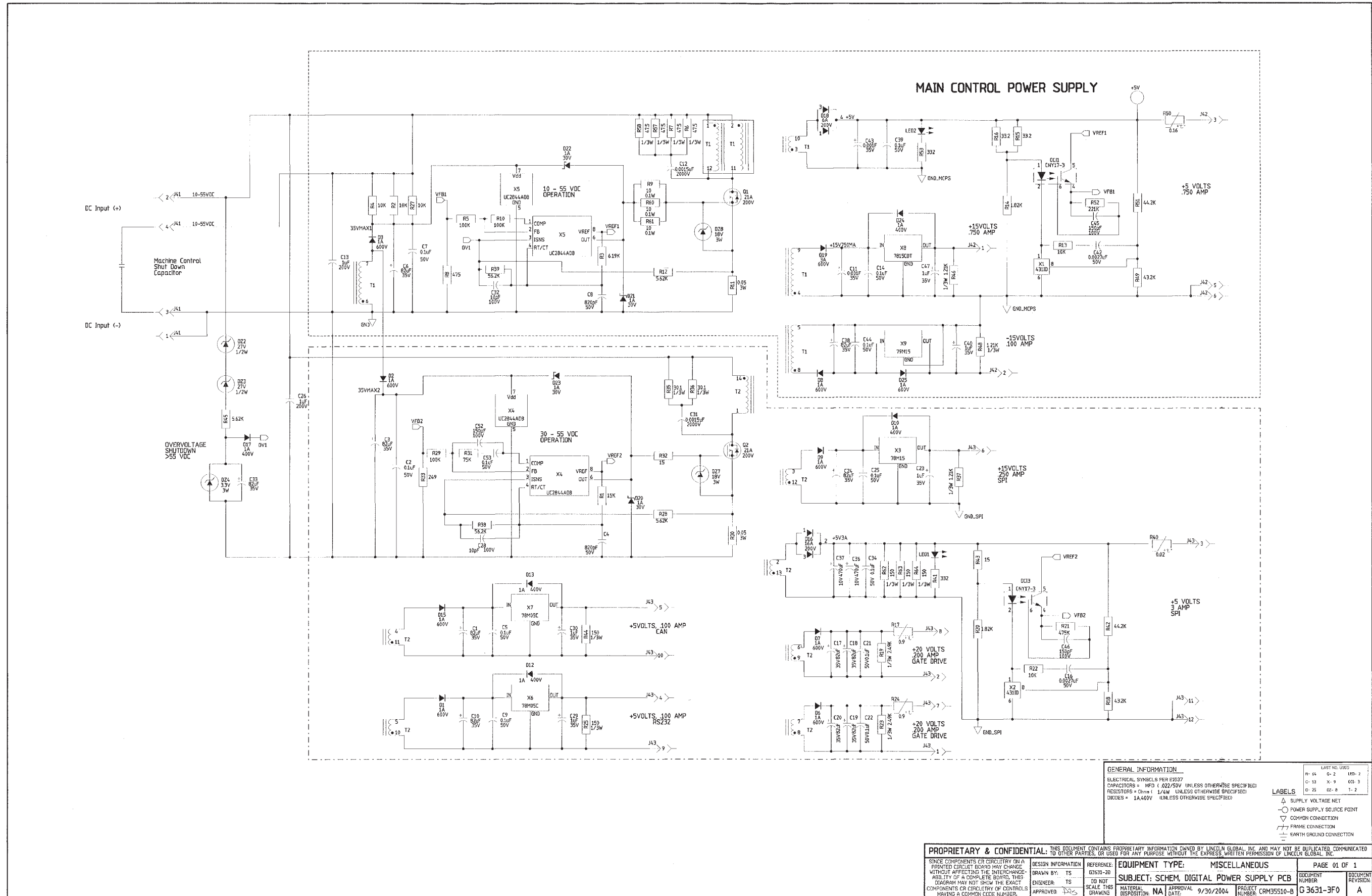
SCHEMATIC POWER SUPPLY P.C. BOARD (G3631-3F0)

Return to Section TOC  
Return to Master TOC

Return to Section TOC  
Return to Master TOC

Return to Section TOC  
Return to Master TOC

Return to Section TOC  
Return to Master TOC



**GENERAL INFORMATION**  
 ELECTRICAL SYMBOLS PER E1037  
 CAPACITORS = MFD (0.22/50V UNLESS OTHERWISE SPECIFIED)  
 RESISTORS = OHMS (1/4W UNLESS OTHERWISE SPECIFIED)  
 DIODES = 1A, 400V (UNLESS OTHERWISE SPECIFIED)

**LABELS**  
 ○ SUPPLY VOLTAGE NET  
 ⊙ POWER SUPPLY SOURCE POINT  
 ▽ COMMON CONNECTION  
 ⊕ FRAME CONNECTION  
 ⊕ EARTH GROUND CONNECTION

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DESIGN INFORMATION	REFERENCE:	EQUIPMENT TYPE:	MISCELLANEOUS	PAGE 01 OF 1
DRAWN BY: TS	G3631-20	SUBJECT: SCHEM, DIGITAL POWER SUPPLY PCB	DOCUMENT NUMBER	DOCUMENT REVISION
ENGINEER: TS	DO NOT SCALE THIS DRAWING	MATERIAL DISPOSITION: NA	APPROVAL DATE: 9/30/2004	PROJECT NUMBER: CRM35510-B
APPROVED: [Signature]				G 3631-3F0

NOTE: This diagram is for reference only. It may not be accurate for all machines covered by this manual.





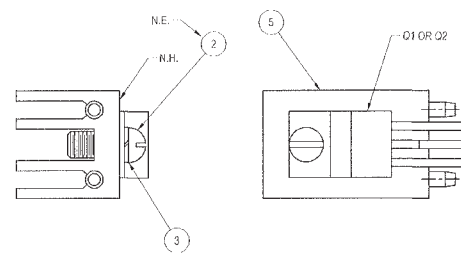
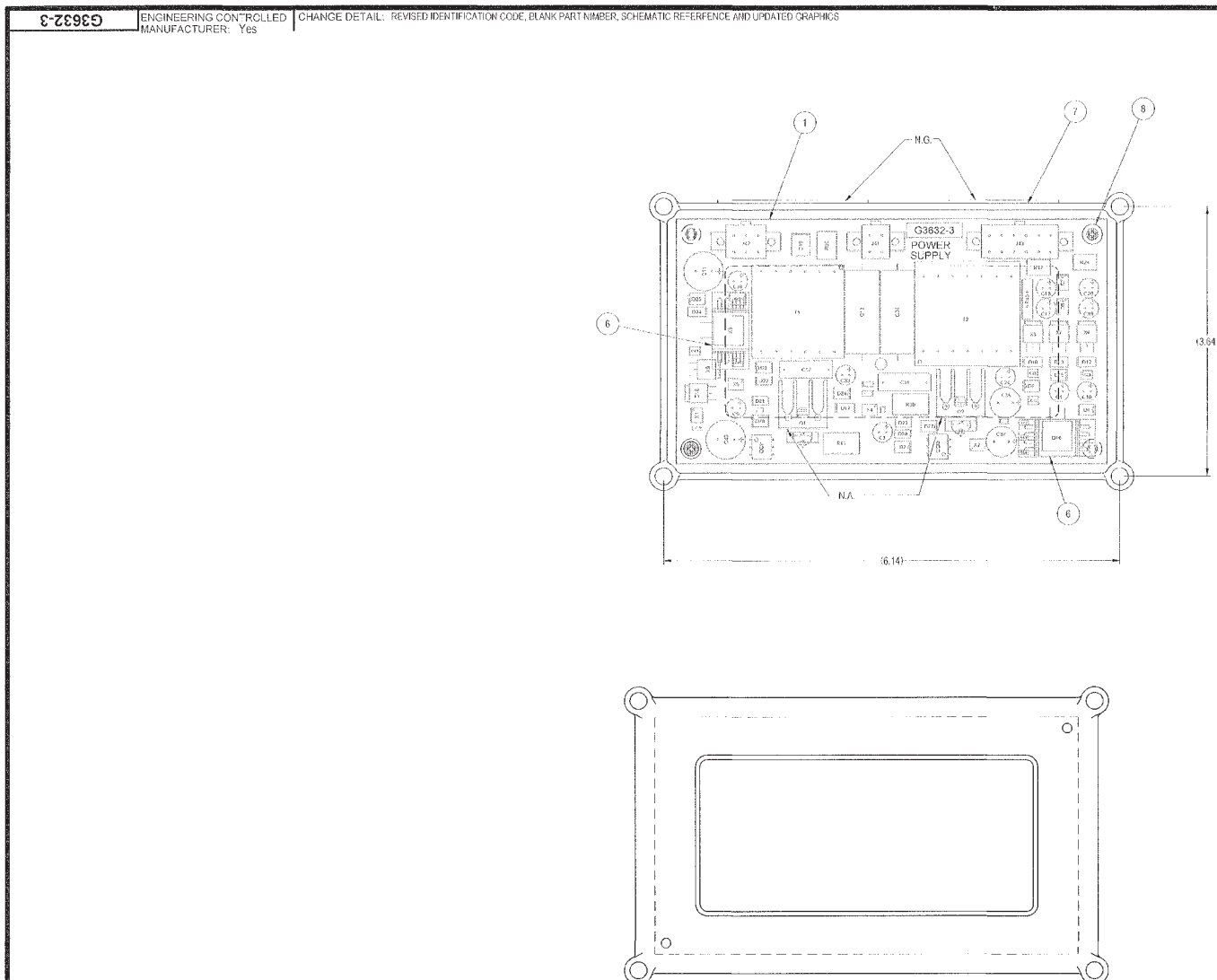
PC BOARD ASSEMBLY - POWER SUPPLY (G3632-3)

Return to Section TOC  
Return to Master TOC

Return to Section TOC  
Return to Master TOC

Return to Section TOC  
Return to Master TOC

Return to Section TOC  
Return to Master TOC



HEATSINK MOUNTING DETAIL

NOTES:

- N.A. SEE HEAT SINK MOUNTING DETAILS.
- N.B. ALL CONNECTORS MUST BE GREASED WITH ITEM 10 PRIOR TO ENCAPSULATION.
- N.C. ATTACH ITEM 1 TO ITEM 7 (2 PLACES) WITH ITEM 6 (TORQUE = 5.3-11.05 IN-LB). ITEM 1 SHOULD BE ALLIGNED SO THAT THE DISTANCE BETWEEN ITEM 1'S CONNECTORS AND ITEM 7 IS AS LARGE AS POSSIBLE.
- N.D. ENCAPSULATION PER E1611-E TO A MINIMUM DEPTH SO ALL OF THE COMPONENTS LEADS ARE COVERED.
- N.E. TIGHTEN TO 6-8 in. lbs. WITHOUT APPLYING ANY PRESSURE TO PLASTIC CASE OF Q1 AND Q2.
- N.G. PLACE BARCODED ASSEMBLY NUMBER IDENTIFICATION AND BARCODED SERIAL NUMBER IDENTIFICATION IN AREA SHOWN.
- N.H. PLACE A HEAVY FILM OF ITEM 4 ON HEAT SINK SURFACE. DO NOT GET ON T-THREADS.

ITEM (USED WITH)	QTY	PART NUMBER	DESCRIPTION
1	1	G3632-F	PC BOARD BLANK
2 (Q1, Q2)	2	CF000003	6-32 X .375 ROUND HEAD MACHINE SCREW
3 (Q1, Q2)	2	E106A-13	# 6 LOCK WASHER
4 (Q1, Q2)	AS REQ	E1668	THERMO JOINT COMPOUND
5 (Q1, Q2)	2	S18104-S	HEAT SINK ALUMINUM EXTRUDED FOR 1 TO-220, 1.0
6 (D16, X2)	2	S25120-1SMT	SMD HEAT SINK FOR D2PAK TO-263
7	1	M19436-3	POTTING TRAY
8	2	S1629-60	SELF TAPPING SCREW
9	1159	E2627	EPOXY ENCAPSULATION RESIN
10	AS REQ	E2661	ELECTRICAL INSULATION COMPOUND

REFER TO ELECTRONIC COMPONENT DATABASE FOR SPECIFICATIONS ON ITEMS LISTED BELOW

REFERENCES	QTY	PART NUMBER	DESCRIPTION
C1, C3, C6, C10, C17, C18, C19, C20, C24, C33, C38	11	S13490-197	CAPACITOR,ALEL,82.35V,20%,LOW-ESR
C2, C5, C7, C9, C14, C21, C22, C25, C34, C39, C44, C53	12	S25020-3SMT	CAPACITOR,SMD,CERAMIC,0.1MF,50V,10%,XTR,S0805
C4, C8	2	S25020-4SMT	CAPACITOR,SMD,CERAMIC,820PF,50V,5%,COG,S0805
C11, C43	2	S13490-198	CAPACITOR,ALEL,1003.35V,20%,LOW-ESR
C12, C31	2	S25000-5	CAPACITOR,PFMF,0015,2000V,BOX
C13, C26	2	T11577-62	CAPACITOR,PEMF,1,C,200V,10%
C16, C42	2	S25020-5SMT	CAPACITOR,SMD,CERAMIC,2700PF,50V,5%,XTR,S0805
C23, C28, C30, C40, C47	5	S25024-2SMT	CAPACITOR,SMD,TANTALUM,1.0MF,35V,10%,S3528
C28, C32	2	S25020-18SMT	CAPACITOR,SMD,CERAMIC,10PF,100V,5%,COG,S0805
C36, C37	2	S13490-202	CAPACITOR,ALEL,4700PF,10V,20%
C45, C46, C52	3	S25020-13SMT	CAPACITOR,SMD,CERAMIC,150PF,100V,5%,COG,S0805
D1, D2, D3, D6, D7, D8, D9, D15, D25	9	S26040-11SMT	DIODE,SMD,1A,600V,S403A,ULTRA-FAST RECOVERY
D10, D12, D13, D17, D24	5	S25040-29SMT	DIODE,SMD,1A,400V,DO-214BA/AC
D16	1	S25040-13SMT	DIODE,SMD,DUAL,16A,200V,D2PAK,CC,ULTRA-FAST RECOVERY
D18	1	S25040-3SMT	DIODE,SMD,DUAL,6A,200V,DPAK,CC,ULTRA-FAST RECOVERY
D19	1	S25040-6SMT	DIODE,SMD,3A,600V,DO-214AB,ULTRA-FAST RECOVERY
D20, D21, D22, D23	4	S25049-29SMT	DIODE,SMD,SC-CHT/KY,1A,20V,SMA
D22, D23	2	S25046-4SMT	ZENER DIODE,SMD,0.5W,27V,5%,S060-123
D24	1	S25044-12SMT	ZENER DIODE,SMD,3W,3.3V,5%,SMB
D27, D28	2	S25044-5SMT	ZENER DIODE,SMD,3W,18V,5%,SMB
J41	1	S24020-4	CONNECTOR,MOLEX,MINI PCB 4-PIN,TIN
J42	1	S24020-6	CONNECTOR,MOLEX,MINI PCB 6-PIN,TIN
J43	1	S24020-12	CONNECTOR,MOLEX,MINI PCB 12-PIN,TIN
LED1, LED2	2	S25080-18SMT	LED,SMD,RED,CLEAR,S1205
OC1, OC3	2	S15000-10	OPTICOUPLER,PI-1010-0,20V,CNY17-3
Q1, Q2	2	T12704-63	TRANSISTOR,NMF,1220,21A,200V,BL230A
R1	1	S25001-1502SMT	RESISTOR,SMD,15K,1/4W,1205,1%,TR
R2, R4, R13, R22, R27	5	S25001-1002SMT	RESISTOR,SMD,10K,1/4W,1205,1%,TR
R3	1	S25001-6191SMT	RESISTOR,SMD,6.19K,1/4W,1205,1%,TR
R5, R10, R29	3	S25001-1003SMT	RESISTOR,SMD,100K,1/4W,1205,1%,TR
R6, R7, R57, R58	4	S25002-4765SMT	RESISTOR,SMD,47.50K,1/3W,MF,1%,S1210
R8	1	S25001-4760SMT	RESISTOR,SMD,4750HMS,1/4W,1205,1%,TR
R9, R60, R61	3	S25000-1006SMT	RESISTOR,SMD,METAL FILM,1/10W,10 COHMS,1%,S0805
R11, R30	2	S25005-18SMT	RESISTOR,SMD,METAL STRIP,3W,0.050HMS,1%
R12, R28, R46	3	S25001-5621SMT	RESISTOR,SMD,5.62K,1/4W,1205,1%,TR
R14, R20	2	S25001-1821SMT	RESISTOR,SMD,1.82K,1/4W,1205,1%,TR
R15, R16	2	S25001-3922SMT	RESISTOR,SMD,33.20HMS,1/4W,1205,1%,TR
R17, R24	2	S25084-2SMT	THERMISTOR,SMD,PTC,0.35,1/10W,1.0,40HMS,2.0A
R18, R49	2	S25001-4322SMT	RESISTOR,SMD,43.2K,1/4W,1205,1%,TR
R19, R23	2	S25002-2491SMT	RESISTOR,SMD,2.49K,1/3W,MF,1%,S1210
R21	1	S25001-4763SMT	RESISTOR,SMD,475K,1/4W,1205,1%,TR
R25, R44, R62, R63, R64	5	S25002-1600SMT	RESISTOR,SMD,1600HMS,1/3W,MF,1%,S1210
R31	1	S25001-7502SMT	RESISTOR,SMD,75.0K,1/4W,1205,1%,TR
R32, R43	2	S25001-1596SMT	RESISTOR,SMD,15.00HMS,1/4W,1205,1%,TR
R33	1	S25001-2490SMT	RESISTOR,SMD,2490HMS,1/4W,1205,1%,TR
R35, R36	2	S25002-30R1SMT	RESISTOR,SMD,30.10HMS,1/3W,MF,1%,S1210
R37, R46, R48	3	S25002-1211SMT	RESISTOR,SMD,1.21K,1/3W,MF,1%,S1210
R38, R39	2	S25001-5622SMT	RESISTOR,SMD,56.2K,1/4W,1205,1%,TR
R40	1	S19360-15	THERMISTOR,PTC,0.010,0.050HMS,4.0A
R41, R53	2	S25001-3320SMT	RESISTOR,SMD,3320HMS,1/4W,1205,1%,TR
R42, R51	2	S25001-4422SMT	RESISTOR,SMD,44.2K,1/4W,1205,1%,TR
R50	1	S25084-1SMT	THERMISTOR,SMD,PTC,0.067,250HMS,1.5A
R52	1	S25001-2213SMT	RESISTOR,SMD,221K,1/4W,1205,1%,TR
T1	1	S20375-13	TRANSFORMER,PCB,PWM,FLYBACK
T2	1	S20375-10	TRANSFORMER,PCB,PWM,FLYBACK
X1, X2	2	S15128-10SMT	IC,SMD,VOLTAGE REG,ADJ,PRECISION,431I,SOIC-8
X3	1	S25089-9SMT	IC,SMD,VOLTAGE REGULATOR,FIXED,3-TERMINAL,0.5A,+15V
X4, X5	2	S25071-2SMT	IC,SMD,PWM CONTROLLER,SOIC(S)
X6, X7	2	S25088-1SMT	IC,SMD,VOLTAGE REGULATOR,FIXED,3-TERMINAL,0.5A,+5V
X8	1	S15128-6SMT	IC,SMD,VOLTAGE REGULATOR,FIXED,3-TERMINAL,1A,+15V
X9	1	S25088-10SMT	IC,SMD,VOLTAGE REGULATOR,FIXED,3-TERMINAL,0.5A,+15V

BUY AS  
G3632-3F0  
PART NO. IDENTIFICATION CODE

SCHEMATIC REFERENCE: G3631-3F0

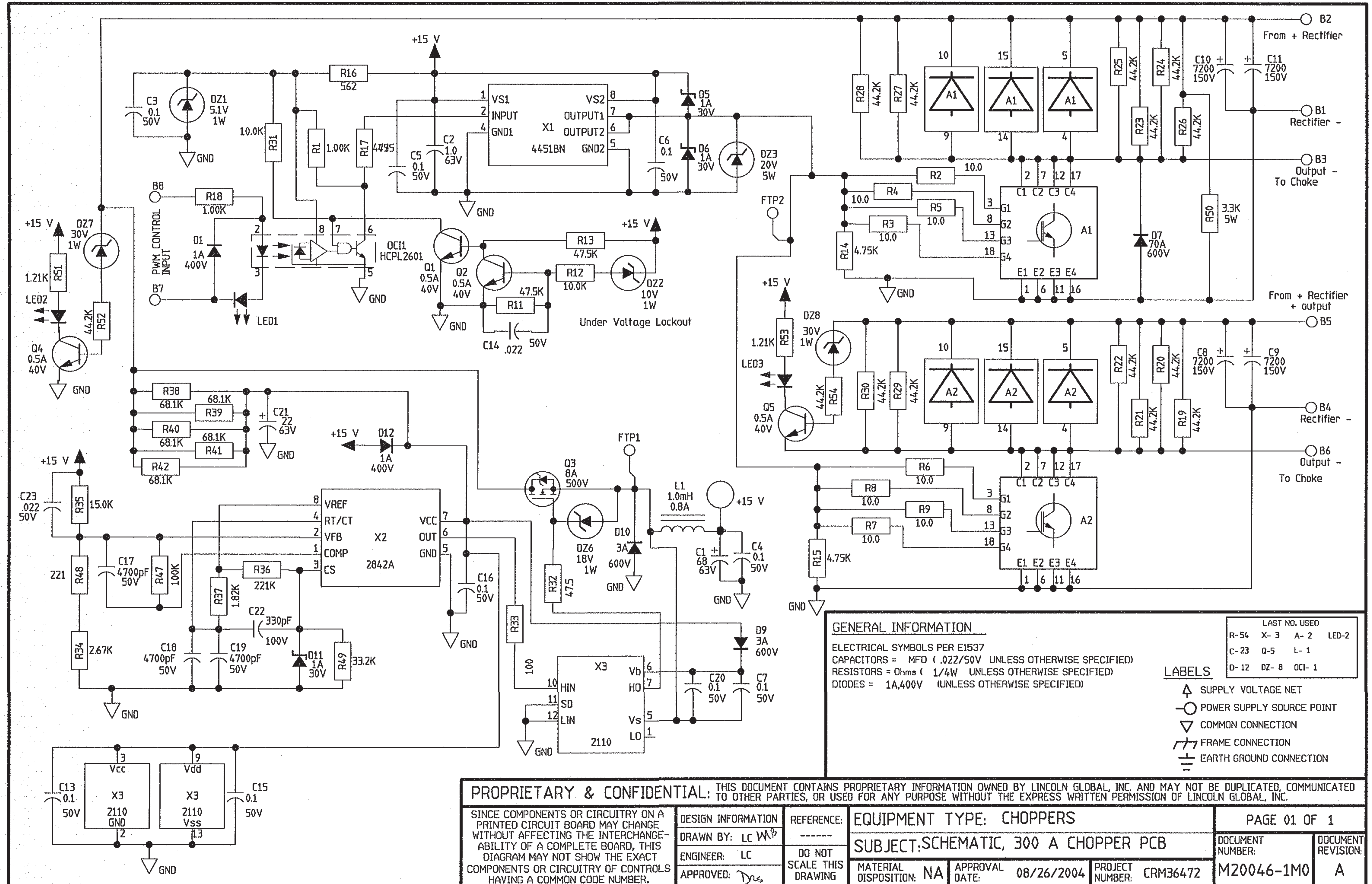
BUY PER E3867  
TEST PER E3856-P

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DESIGN INFORMATION	REFERENCE: G3632-2	SUBJECT: DIGITAL POWER P.C. BOARD AS'BLY	APPROVAL DATE: 9/30/2004	PROJECT NUMBER: CRM35510-B	DOCUMENT NUMBER: G3632-3
ENGINEER: DZs	APPROVAL: NONE	DATE: 9/30/2004	DATE: 9/30/2004	DATE: 9/30/2004	DATE: 9/30/2004

**NOTE:** Lincoln Electric assumes no responsibility for liabilities resulting from board level troubleshooting. PC Board repairs will invalidate your factory warranty. **Individual Printed Circuit Board Components are not available from Lincoln Electric.** This information is provided for reference only. Lincoln Electric discourages board level troubleshooting and repair since it may compromise the quality of the design and may result in danger to the Machine Operator or Technician. Improper PC board repairs could result in damage to the machine.



SCHEMATIC - CHOPPER P.C. BOARD (M20046-1M0)



**GENERAL INFORMATION**

ELECTRICAL SYMBOLS PER E1537  
 CAPACITORS = MFD (.022/50V UNLESS OTHERWISE SPECIFIED)  
 RESISTORS = Ohms ( 1/4W UNLESS OTHERWISE SPECIFIED)  
 DIODES = 1A,400V (UNLESS OTHERWISE SPECIFIED)

**LABELS**

LAST NO. USED	R-54	X-3	A-2	LED-2
	C-23	Q-5	L-1	
	D-12	DZ-8	OC1-1	

- ▲ SUPPLY VOLTAGE NET
- POWER SUPPLY SOURCE POINT
- ▽ COMMON CONNECTION
- ⏏ FRAME CONNECTION
- ⊥ EARTH GROUND CONNECTION

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SINCE COMPONENTS OR CIRCUITRY ON A PRINTED CIRCUIT BOARD MAY CHANGE WITHOUT AFFECTING THE INTERCHANGEABILITY OF A COMPLETE BOARD, THIS DIAGRAM MAY NOT SHOW THE EXACT COMPONENTS OR CIRCUITRY OF CONTROLS HAVING A COMMON CODE NUMBER.	DESIGN INFORMATION	REFERENCE:	EQUIPMENT TYPE: CHOPPERS		PAGE 01 OF 1	
	DRAWN BY: LC W	-----	SUBJECT: SCHEMATIC, 300 A CHOPPER PCB		DOCUMENT NUMBER:	DOCUMENT REVISION:
	ENGINEER: LC	DO NOT SCALE THIS DRAWING	MATERIAL DISPOSITION: NA	APPROVAL DATE: 08/26/2004	PROJECT NUMBER: CRM36472	M20046-1M0 A
APPROVED: DJS						

NOTE: This diagram is for reference only. It may not be accurate for all machines covered by this manual.









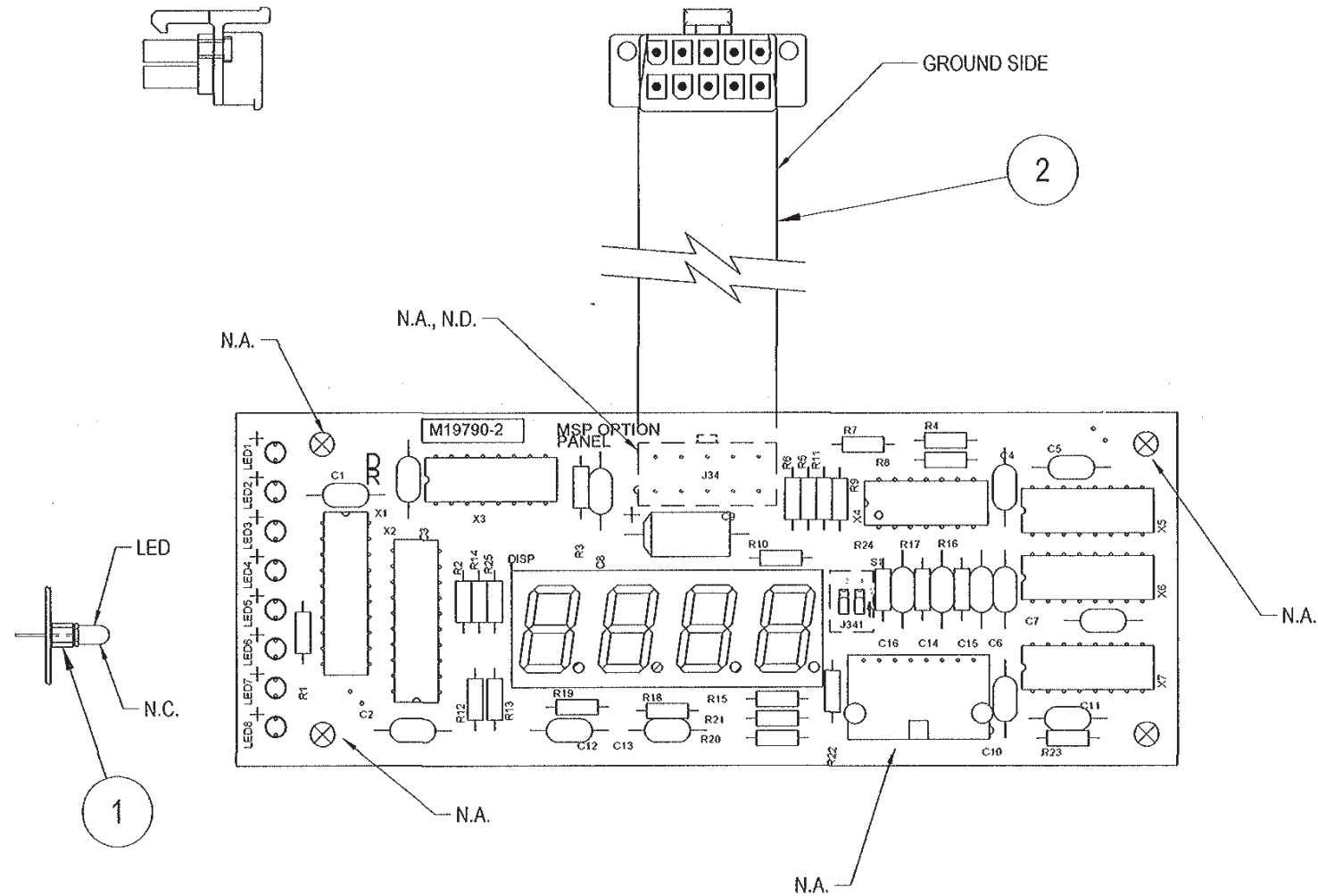
PC BOARD ASSEMBLY - MSP3 (M19790-2)

Z-06261W

ENGINEERING CONTROLLED CHANGE DETAIL: NEW  
MANUFACTURER: Yes

NOTES:

- N.A. DO NOT COAT WITH ENCAPSULATION MATERIAL.
- N.B. CAUTION: THIS DEVICE IS SUBJECT TO DAMAGE BY STATIC ELECTRICITY. SEE E2454 BEFORE HANDLING.
- N.C. USE ITEM 1 TO STAND LED1 THRU LED8 FROM THE P.C. BOARD. THERE MUST NOT BE MORE THAN .020 GAP BETWEEN SPACER AND P.C. BOARD OR BETWEEN SPACER AND LED. ENCAPSULATE P.C.BOARD, SPACER AND LOWER HALF OF LED.
- N.D. CONNECTOR MUST BE GREASED WITH ITEM 3 PRIOR TO ENCAPSULATION.



ITEM	REQ'D	PART No.	DESCRIPTION
1	8	T15176-2	LED SPACER
2	1	L11166-1	FLEX CIRCUIT
3	.01 OZ.	E3539	ELECTRICAL INSULATING COMPOUND
FOR ITEMS BELOW REFER TO ELECTRONIC COMPONENTS DATABASE FOR COMPONENT SPECIFICATIONS			
C1,C2,C3,C4,C5,C6,C7,C8,C10 C11,C12,C13,C14,C15,C16	15	S16668-11	CAPACITOR,CEMO,0.1, 50V,10%
C9	1	S13490-104	CAPACITOR,TAEL,39,20V,10%
N.A. DISP1	1	S17395-9	LED,DISPLAY,7-SEGMENT,CC,4-DIGIT
J34	1	S18248-10	CONNECTOR,MOLEX,MINI,PCB,10-PIN
J341	1	S19365-8	CONNECTOR,PCB,MALE,RT-L,8-PIN
N.C. LED1,LED2,LED3,LED4,LED5 LED6,LED7,LED8	8	T13657-6	LED,T-1,RED,HLMP-K101
R1,R2,R12,R13,R14,R15,R16 R17,R18,R19,R20,R21,R22 R23,R24,R25	16	S19400-1001	RESISTOR,MF,1/4W,1.00K,1%
R3	1	S19400-2670	RESISTOR,MF,1/4W,267,1%
R4,R5,R6,R7,R8,R9	6	S19400-1212	RESISTOR,MF,1/4W,12.1K,1%
R10	1	S19400-2002	RESISTOR,MF,1/4W,20.0K,1%
R11	1	S19400-9091	RESISTOR,MF,1/4W,9.09K,1%
N.B. X1,X2	2	S20496-1	IC,CMOS,DRIVER,DISPLAY,LED,CC,MCU
N.B. X3	1	S17900-28	IC,CMOS,HEX,BUFFER,3-STATE,2-BIT,4-BI
N.B. X4	1	S17900-8	IC,CMOS,INVERTER,SCHMITT,HEX,HC14A(SS)
N.B. X5	1	S17900-26	IC,CMOS,MUX,DAT,8-INPUT,HC151(SS)
N.B. X6,X7	2	S17900-10	IC,CMOS,REGISTER,SHFT,S-PI/SO,8-BIT(S)
S1	1	S19869-2	SWITCH,DIP,SPST,2-CIRCUITS

ENCAPSULATE WITH HUMISEAL 1A27LU PER E1844 OR WITH EQUIVALENT AS APPROVED BY THE LINCOLN ELECTRIC COMPANY. (2 COATS)

UNLESS OTHERWISE SPECIFIED:  
CAPACITANCE = MFD/VOLTS  
INDUCTANCE = HENRIES  
RESISTANCE = OHMS

BUY AS:  
M 1 9 7 9 0 - 2 D 0  
PART NUMBER IDENTIFICATION CODE

BUY PER E3867.

TEST PER E3856-MSP.

SCHEMATIC REFERENCE: L11612-2D0.

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UNLESS OTHERWISE SPECIFIED TOLERANCE: MANUFACTURING TOLERANCE PER E2056 ON 2 PLACE DECIMALS IS ± .02 ON 3 PLACE DECIMALS IS ± .002 ON ALL ANGLES IS ± .5 OF A DEGREE MATERIAL TOLERANCE ("I") TO AGREE WITH PUBLISHED STANDARDS. DO NOT SCALE THIS DRAWING	DESIGN INFORMATION	REFERENCE:	EQUIPMENT TYPE:	PAGE 1 OF 1
	DRAWN BY: cstuble	M19790-1	SUBJECT:	DOCUMENT NUMBER:
	ENGINEER: M. DIDION	SCALE:	MATERIAL DISPOSITION: NA	APPROVAL DATE: 08/02/2002
	APPROVED: DDC	1:1		DOCUMENT REVISION: A

NOTE: Lincoln Electric assumes no responsibility for liabilities resulting from board level troubleshooting. PC Board repairs will invalidate your factory warranty. Individual Printed Circuit Board Components are not available from Lincoln Electric. This information is provided for reference only. Lincoln Electric discourages board level troubleshooting and repair since it may compromise the quality of the design and may result in danger to the Machine Operator or Technician. Improper PC board repairs could result in damage to the machine.

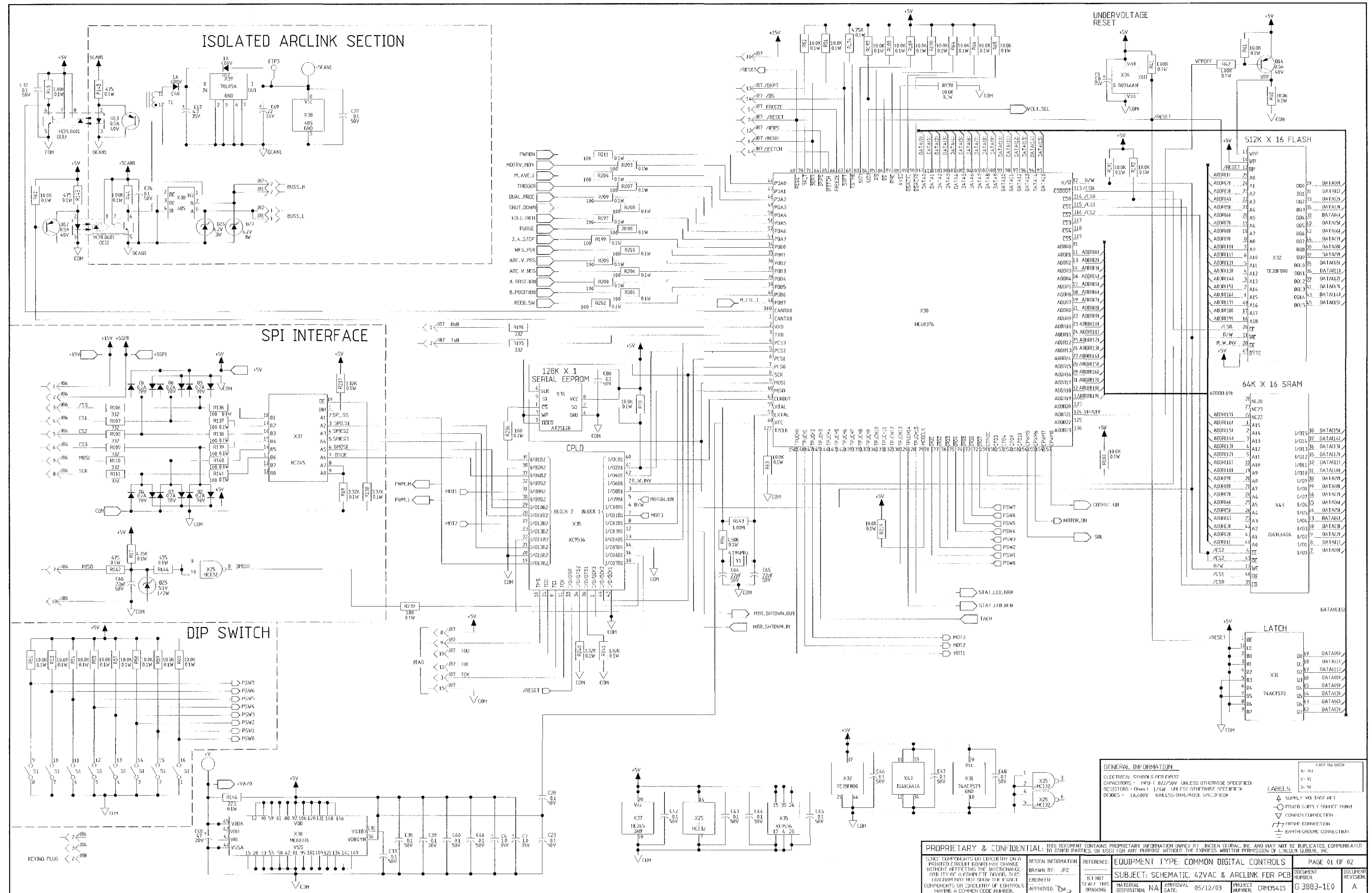


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SOLID EDGE



SCHEMATIC - FEEDER P.C. BOARD (G3883-1E0/1)

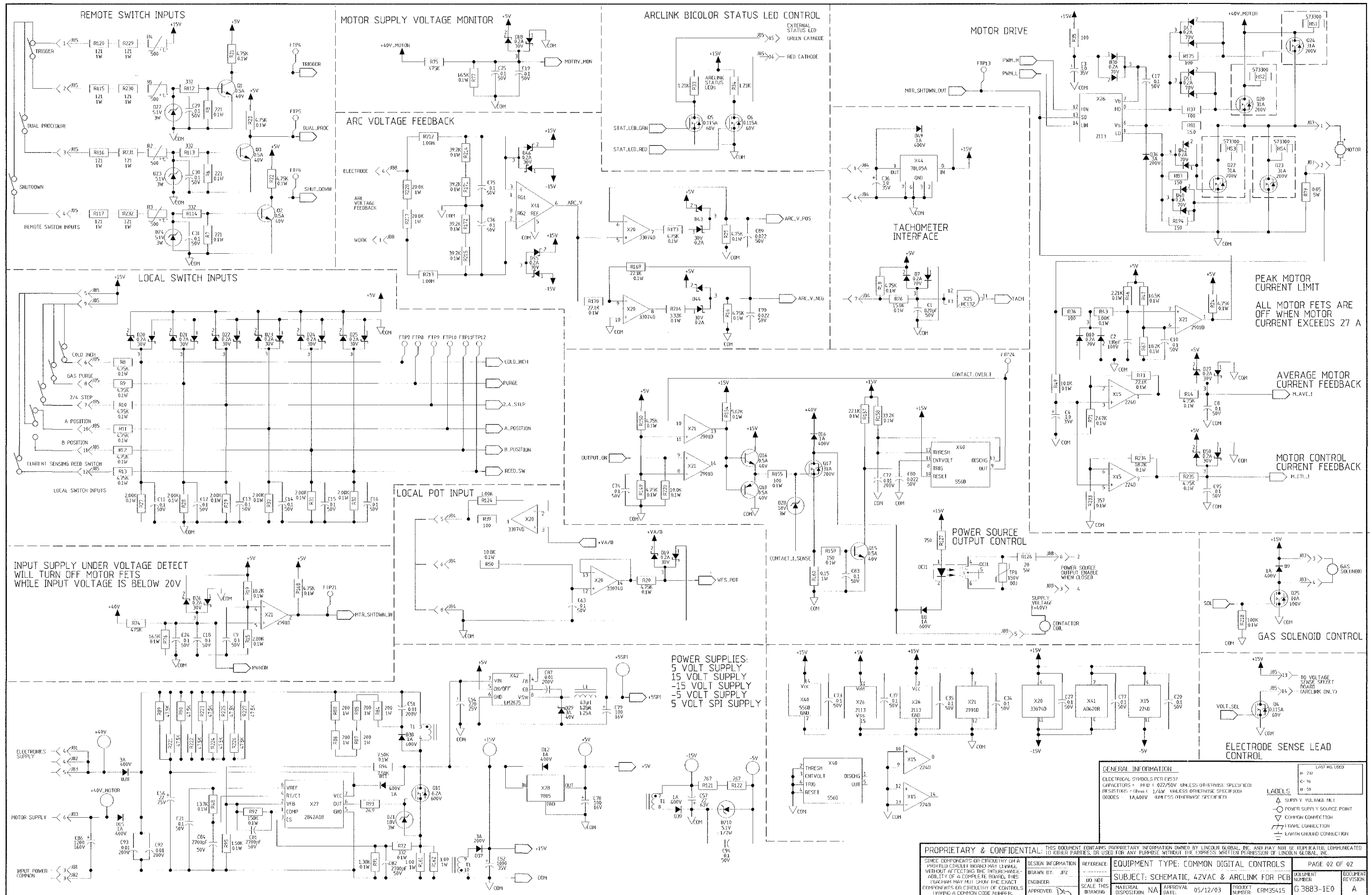


NOTE: This diagram is for reference only. It may not be accurate for all machines covered by this manual.

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SCHEMATIC - FEEDER P.C. BOARD (G3883-1E0/2)



NOTE: This diagram is for reference only. It may not be accurate for all machines covered by this manual.

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DESIGN INFORMATION	REFERENCE	EQUIPMENT TYPE: COMMON DIGITAL CONTROLS	PAGE 02 OF 02
DRAWN BY: JIZ	SUBJECT: SCHEMATIC, 42VAC & ARCLINK FOR PCB	INSTRUMENT NUMBER	EQUIPMENT REVISION
ENGINEER:	DO NOT SCALE THIS DRAWING	MATERIAL DISPOSITION: NA	PROJECT NUMBER: G3883-1E0
APPROVED: [Signature]	DATE: 05/12/03	APPROVAL DATE:	REVISION: A

PC BOARD ASSEMBLY - FEEDER (G3884-1)

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1-78835 ENGINEERING CONTROLLED CHANGE DETAIL: REVISION IDENTIFICATION CODE, SCHEMATIC REFERENCE AND BILL OF MATERIALS, REMOVED NOTE N.L. AND ADDED N.K.

ITEM	QTY	PART No.	DESCRIPTION
1	1	S2467-1	PLUG, KEY-IN PLUG
2	1	M19438-5	POTTING TRAY
3	2	S8025-80	SELF TAPPING SCREW
4	1	E2527	EPOXY ENCAPSULATING RESIN
5	1	S19200-7	SUPPORT PCB, 3M/7H, 0.63
6	1	S25343-1	SOFTWARE CD
7	1	S25344-5	SOFTWARE FLASH
8	1	E2639	ELECTRICAL INSULATING COMPOUND
FOR THE FOLLOWING REFER TO THE ELECTRONIC COMPONENTS DATABASE FOR COMPONENT SPECIFICATIONS			
C1	1	S25920-4SMT	CAPACITOR, SMD, CERAMIC, 820PF, 50V, 5%, COG, S0805
C2	1	S25920-14SMT	CAPACITOR, SMD, CERAMIC, 330PF, 100V, 5%, COG, S0805
C3, C4, C5, C6, C7, C8	6	S25924-2SMT	CAPACITOR, SMD, TANTALUM, 1.0MF, 35V, 10%, S3328
C9, C10, C11, C12, C13, C14	50	S25920-27SMT	CAPACITOR, SMD, CER, 0.1MF, 50V, 20%+80%, 25J, S0805
C15, C16, C17, C18, C19, C20			
C21, C22, C23, C24, C25, C26			
C27, C28, C29, C30, C31, C32			
C33, C34, C35, C37, C38, C39			
C40, C41, C42, C43, C44, C45			
C46, C47, C48, C63, C73, C74			
C75, C76, C77, C83, C88, C94			
C95			
C51, C77, C87, C92, C93	5	S25920-22SMT	CAPACITOR, SMD, CERAMIC, 0.01MF, 200V, 20%, X7R, S1206
C92	1	S13498-178	CAPACITOR, AEL, 1000, 30V, 20%
C94	1	S13490-199	CAPACITOR, AEL, 220, 25V, 20%, LOW ESR
C96	1	S25924-10SMT	CAPACITOR, SMD, TANTALUM, 22MF, 25V, 10%, S7343
C97	1	S13490-181	CAP. AEL, 22.0V, 20%
C98, C99, C96	3	S25920-15SMT	CAPACITOR, SMD, CERAMIC, 22PF, 50V, 5%, COG, S0805
C97	1	S25924-5SMT	CAPACITOR, SMD, TANTALUM, 47MF, 35V, 10%, S7343
C98	1	S25924-7SMT	CAPACITOR, SMD, TANTALUM, 47MF, 20V, 10%, S7343
C99	1	S25924-6SMT	CAPACITOR, SMD, TANTALUM, 22MF, 10V, 10%, S6332
C78, C79	2	S25920-23SMT	CAPACITOR, SMD, TANTALUM, 100MF, 16V, 20%, S7343, LQW
C80, C90, C90	3	S25920-25SMT	CAPACITOR, SMD, CERAMIC, 0.022MF, 50V, 10%, X7R, S0805
C81, C82, C84	3	S25920-5SMT	CAPACITOR, SMD, CERAMIC, 270PF, 50V, 5%, X7R, S0805
C86	1	S13490-195	CAPACITOR, AEL, 1000, 160V, 20%
D1, D2, D3, D4, C5, D6, D7	7	S25940-5SMT	DIODE, SMD, DUAL, 0.20A, 70V, UFR
D8, D9, D10, D11, D12	4	S25940-11SMT	DIODE, SMD, 1A, 600V, S403A, ULTRA-FAST RECOVERY
D9, D11, D12, D15, D16, D17, D18	7	S25940-2SMT	DIODE, SMD, 1A, 400V, D0-214BAAC
D10, D30, D41, D42, D47, D48	6	S25940-6SMT	DIODE, SMD, DUAL, 0.20A, 70V, UFR, CO, SOT-23
D18, D19, D20, D21, D22, D23	15	S25949-4SMT	DIODE, SMD, SCHOTTKY, DUAL, 0.300A, 50V, SOT-23
D24, D25, D26, D27, D43, D44			
D45, D46, D50			
D28	1	S25940-10SMT	DIODE, SMD, 3A, 400V, D0-214AB
D29	1	S25949-3SMT	DIODE, SMD, SCHOTTKY, 3A, 40V, CASE 409-3
D35, D37	2	S25940-12SMT	DIODE, SMD, 3A, 200V, S403-3, ULTRA-FAST RECOVERY
D21, D26	2	S25944-3SMT	ZENER DIODE, SMD, 3W, 18V, 5%, SMD
D27, D23, D24	3	S25944-1SMT	ZENER DIODE, SMD, 3W, 5.1V, 5%, SMD
D25, D29	2	S25945-1SMT	ZENER DIODE, SMD, 0.5W, 5.1V, 5%, SOD123
D26, D27	2	S25944-9SMT	ZENER DIODE, SMD, 3W, 24.3V, 5%, SMD
FTP3, FTP4, FTP5, FTP6, FTP7	13	TESTPT_FUNT	FUNCTIONAL TEST POINT
FTP8, FTP9, FTP10, FTP11			
FTP2, FTP13, FTP21, FTP24			
H51, H52, H53, H54	4	S25128-1SMT	HEAT SINK, SMD, COPPER, FORMED, D2PAK
J81, J82	2	S24920-4	CONNECTOR, MOLEX MINI PCB, 4-PIN, TIN
J83, J88	2	S24920-6	CONNECTOR, MOLEX MINI PCB, 6-PIN, TIN
J84	1	S24920-8	CONNECTOR, MOLEX MINI PCB, 8-PIN, TIN
J85	1	S24920-16	CONNECTOR, MOLEX MINI PCB, 16-PIN, TIN
J86	1	S21134-10	CONNECTOR, MOLEX MINI PCB, 10-PIN
J87	1	S18248-16	CONNECTOR, MOLEX MINI PCB, 16-PIN
L1	1	S25083-3SMT	CHOC, SMD, POWER, 47UH, 10%, 1.25A
OC1	1	S15000-20SMT	OPTOCOUPLER, SMD, SSR, FORM 1A, C 08A, 360V
OC2, OC3	2	S15000-28SMT	OPTOCOUPLER, SMD, TTL-OUT, HI-SPEED, HI-CURR
Q1, Q2, Q3, Q15, Q16	5	S25050-13SMT	TRANSISTOR, SMD, NPN, 0.5A, 40V, SOT-23, MMBT4401LTI
Q4, Q5, Q8	3	S25051-4SMT	TRANSISTOR, SMD, NMF, SOT-23, 0.15A, 60V, 7002LTI(SS)
Q11	1	S25051-3SMT	TRANSISTOR, SMD, NMF, D2PAK, 6.2A, 60V, RFB-0405(SS)
Q12, Q13, Q14, Q18	4	S25050-2SMT	TRANSISTOR, SMD, PNP, SOT23, 0.5A, 40V, MMBT4403LTI
Q17, Q20, Q22, Q23, Q24	5	S25051-9SMT	TRANSISTOR, SMD, NMF, D2PAK, 3*A, 200V, RFS31A20C(SS)
Q25	1	S25051-6SMT	TRANSISTOR, SMD, NMF, DPAK, TO-252, 10A, 100V(SS)
R1, R2, R3, R4	4	S18380-14	THEMISTOR, PTC, 500OHMS, 28mA
R5, R6, R7	3	S25000-3210SMT	RESISTOR, SMD, METAL FILM, 1/10W, 2210OHMS, 1%, S0805
R8, R9, R10, R11, R12, R13, R14	22	S25000-4751SMT	RESISTOR, SMD, METAL FILM, 1/10W, 4.75K, 1%, S0805
R10, R17, R18, R20, R21, R22			
R23, R24, R25, R149, R150, R168			
R173, R174, R235			
R15	1	S25000-2801SMT	RESISTOR, SMD, METAL FILM, 1/10W, 2.80K, 1%, S0805
R19, R67, R234	3	S25000-1822SMT	RESISTOR, SMD, METAL FILM, 1/10W, 18.2K, 1%, S0805
R20	1	S25000-1502SMT	RESISTOR, SMD, METAL FILM, 1/10W, 15.0K, 1%, S0805
R27, R28, R29, R30, R31, R32	8	S25000-2001SMT	RESISTOR, SMD, METAL FILM, 1/10W, 2.00K, 1%, S0805
R33, R34	2	S25001-1211SMT	RESISTOR, SMD, 121K, 1/4W, 1206, 1%, TR
R35, R36, R37, R39, R175	5	S25001-1000SMT	RESISTOR, SMD, 1000OHMS, 1/4W, 1206, 1%, TR
R41, R42, R43, R44, R45	5	S25000-1001SMT	RESISTOR, SMD, METAL FILM, 1/10W, 1.00K, 1%, S0805
R46	1	S25000-2211SMT	RESISTOR, SMD, METAL FILM, 1/10W, 2.21K, 1%, S0805
R47, R76, R77	3	S25000-1662SMT	RESISTOR, SMD, METAL FILM, 1/10W, 16.6K, 1%, S0805
R48	1	S25000-1372SMT	RESISTOR, SMD, METAL FILM, 1/10W, 13.7K, 1%, S0805
R49, R50, R51, R52, R53, R54	30	S25000-1002SMT	RESISTOR, SMD, METAL FILM, 1/10W, 10.0K, 1%, S0805
R55, R56, R57, R58, R59, R60			
R61, R62, R63, R64, R65, R66			
R68, R70, R71, R180, R188			
R189, R193, R191, R192, R193			
R219, R220			
R69, R216, R237, R238, R240	6	S25000-3321SMT	RESISTOR, SMD, METAL FILM, 1/10W, 3.32K, 1%, S0805
R241			
R71	1	S25000-2071SMT	RESISTOR, SMD, METAL FILM, 1/10W, 2.07K, 1%, S0805
R72	1	S25000-3302SMT	RESISTOR, SMD, METAL FILM, 1/10W, 3.30KOHMS, 1%, S0805
R73, R157, R160, R170	4	S25000-2212SMT	RESISTOR, SMD, METAL FILM, 1/10W, 22.1K, 1%, S0805
R74, R75	2	S25001-4753SMT	RESISTOR, SMD, 475K, 1/4W, 1206, 1%, TR
R79	1	S23665-0R05	RESISTOR, STAND-UP, 1/4W, 5W, 0.05, 5%
R81	1	S25001-1540SMT	RESISTOR, SMD, 15.0OHMS, 1/4W, 1206, 1%, TR
R83, R194	2	S25001-1500SMT	RESISTOR, SMD, 1500OHMS, 1/4W, 1206, 1%, TR
R84, R85, R86, R87, R88	5	S25003-2002SMT	RESISTOR, SMD, 1W, 200OHMS, 1%
R89, R90, R221, R222, R223	9	S25001-4752SMT	RESISTOR, SMD, 47.5K, 1/4W, 1206, 1%, TR
R224, R225, R226, R227			
R91	1	S25000-1301SMT	RESISTOR, SMD, METAL FILM, 1/10W, 1.30K, 1%, S0805
R92	1	S25000-1503SMT	RESISTOR, SMD, METAL FILM, 1/10W, 150K, 1%, S0805
R93	1	S25001-2499SMT	RESISTOR, SMD, 24.9OHMS, 1/4W, 1206, 1%, TR
R94	1	S25000-7501SMT	RESISTOR, SMD, METAL FILM, 1/10W, 7.50K, 1%, S0805
R95, R96	2	S25000-1501SMT	RESISTOR, SMD, METAL FILM, 1/10W, 1.50K, 1%, S0805
R108, R107, R108, R109, R110	11	S25001-3320SMT	RESISTOR, SMD, 3320OHMS, 1/4W, 1206, 1%, TR
R111, R112, R113, R114, R195			
R198			
R115, R116, R117, R120, R229	8	S25003-4210SMT	RESISTOR, SMD, 1W, 1210OHMS, 1%
R230, R231, R232			
R121, R122	2	S25001-2670SMT	RESISTOR, SMD, 2670OHMS, 1/4W, 1206, 1%, TR
R124	1	S25001-1601SMT	RESISTOR, SMD, 1K, 1/4W, 1206, 1%, TR
R126	1	T14648-23	RESISTOR, WW, 5W, 20.5%, SQ
R127	1	S25001-7500SMT	RESISTOR, SMD, 7500OHMS, 1/4W, 1206, 1%, TR
R136, R137, R138, R139, R140	24	S25000-1000SMT	RESISTOR, SMD, METAL FILM, 1/10W, 1000OHMS, 1%, S0805
R141, R155, R191, R196, R199			
R200, R201, R202, R203, R204			
R205, R206, R207, R208, R209			
R210, R211, R236, R239			
R142, R143, R144, R145	4	S25000-4750SMT	RESISTOR, SMD, METAL FILM, 1/10W, 4750OHMS, 1%, S0805
R146	1	S25000-22R1SMT	RESISTOR, SMD, METAL FILM, 1/10W, 22.1OHMS, 1%, S0805
R148, R212, R213	3	S25001-1004SMT	RESISTOR, SMD, 1.00M, 1/4W, 1206, 1%, TR
R154	1	S25000-5621SMT	RESISTOR, SMD, METAL FILM, 1/10W, 5.62K, 1%, S0805
R158	1	S25003-3322SMT	RESISTOR, SMD, METAL FILM, 1/10W, 33.2K, 1%, S0805
R159	1	S25000-1500SMT	RESISTOR, SMD, METAL FILM, 1/10W, 1500OHMS, 1%, S0805
R160	1	S25003-0R15SMT	RESISTOR, SMD, 1W, 0.150OHMS, 1%
R161, R162	2	S25004-1R00SMT	RESISTOR, SMD, 1W, 1.00OHMS, 1%
R171, R172, R214, R215	4	S25000-3422SMT	RESISTOR, SMD, METAL FILM, 1/10W, 34.2K, 1%, S0805
R217, R228	2	S25010-3SMT	RESISTOR, SMD, MF, 1W, 20.0K, 1% SURGE
R218	1	S25000-1003SMT	RESISTOR, SMD, METAL FILM, 1/10W, 100K, 1%, S0805
R233	1	S25003-3570SMT	RESISTOR, SMD, METAL FILM, 1/10W, 357OHMS, 1%, S0805
S1	1	S19869-8	SWITCH, DIP, SPST, 8, CIRCUITS
T1	1	S20375-11	TRANSFORMER, PCB, PWM, FLYBACK
TP1	1	T13640-16	MOV, 150VRMS, 60J, 20MM
X15	1	S15128-4SMT	OP-AMP, SMD, QUAD, GEN-PURPOSE, 224D
X20	1	S15128-18SMT	IC, OP-AMP, SMT, QUAD, HIGH-PERF, 39074D
X21	1	S15128-11SMT	IC, SMD, COMPARATOR, QUAD, 2801D
X25	1	S17900-24SMT	IC, SMD, CMOS, GATE, NAND, 2-INPUT, QUAD, SCHM(S)
X26	1	S25068-2SMT	IC, SMT, CMOS, DRIVER, MOSFET, 2115(SS)
X27	1	M13486-4SMT	IC, PWM, CONTROLLER, MODE, 2842A, SOIC-8
X28	1	S18355-3	REGULATOR, HEAT-SINKABLE, S15128-5, S18104-3
X30	1	M15101-16SMT	IC, SMD, CMOS, MCU, 32-BIT, 3.5K, RAM, TPU, 20, 97MHZ, QF
X31	1	S25065-2SMT	IC, SMD, ACT, LATCH, OCTAL, 3-STATE, TSSOP-20
X32	1	S25069-3SMT	IC, SMD, CMOS, EEPROM, FLASH, 16-BIT, 512K
X34	1	S25068-7SMT	IC, SMD, CMOS, UNDERVOLT-SENSING, RESET, MCU, SOT-89
X35	1	S25070-5SMT	IC, PLD, PROGRAMMABLE, XC6200, 44-PIN, VOFF(SS)
X36	1	S25069-5SMT	IC, SMD, CMOS, EEPROM, SERIAL, 3PH, 16Kx8, SOIC-8
X37	1	S17900-11SMT	IC, SMD, CMOS, TRANSDUCER, BUS, 3-STATE, OCTAL, TSSOP-
X38	1	S20353-4SMT	IC, CMOS, SMD, XCVR, EIA-485(SS)
X39, X44	2	S25068-6SMT	IC, SMD, VOLT, REG, FINE, 3-T, (+), 0.1A, 5V, SOIC-8
X40	1	S25067-1SMT	IC, B, POLAR, TIMER, SCD-14
X41	1	S15128-20SMT	IC, SMD, INSTR-AMP, DIFF-INR-PROG GAIN
X42	1	S25068-13SMT	IC, SMD, VOLTAGE, REGULATOR, 3A, +5V, S08
X43	1	M15104-15	IC, CMOS, RAM, STATIC, 16-BIT, 128K, (SS)
Y1	1	S25082-3SMT	CRYSTAL, SMD, QUARTZ, 4, 194MHZ

NOTE: THIS DEVICE IS SUBJECT TO DAMAGE BY STATIC ELECTRICITY. SEE E2454 BEFORE HANDLING.  
 N.A. PLACE ITEM 1 OVER HEADER PIN IN LOCATION SHOWN. PLUG SHOULD BE INSERTED BELOW CONNECTOR TOP SURFACE.  
 N.C. INSERT ITEM 5 THROUGH THE BOARD FROM THE BOTTOM SIDE.  
 N.D. PLACE BARCODED ASSEMBLY IDENTIFICATION AND BARCODED SERIAL NUMBER IDENTIFICATION IN AREA SHOWN.  
 N.E. PROGRAM X32 WITH ITEM 7.  
 N.F. PROGRAM X35 WITH ITEM 6.  
 N.G. PARTS INDICATED MUST BE COMPLETELY COVERED WITH POTTING MATERIAL.  
 N.H. SECURE P.C. BOARD ASSEMBLY IN PLACE WITH ITEM 3 (2 PLACES, 6.3 ± 0.1 IN-LBS).  
 N.K. TP1 IS TO BE POSITIONED AS SHOWN.

UNLESS OTHERWISE SPECIFIED:  
 CAPACITANCE = MFD/VOLTS  
 INDUCTANCE = HENRIES  
 RESISTANCE = OHMS

BUY AS: G3884-1-EC  
 PART NUMBER IDENTIFICATION CODE  
 TEST PER E392-FH  
 BUY PER E387

SCHEMATIC REFERENCE: G3880-1E0

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DESIGN INFORMATION	REFERENCE	EQUIPMENT TYPE	COMMON DIGITAL CONTROLS	PAGE 1 OF 1
DRAWN BY: J. ZUCKER	SCALE: 1:1	SUBJECT: 42V & ARCLINK FEEDER P.C. BOARD ASSEMBLY	DOCUMENT NUMBER: G3884-1	DOCUMENT REVISION: D
APPROVED BY: J. ZUCKER	DATE: 05/15/2003	PROJECT NUMBER: CRM35415		

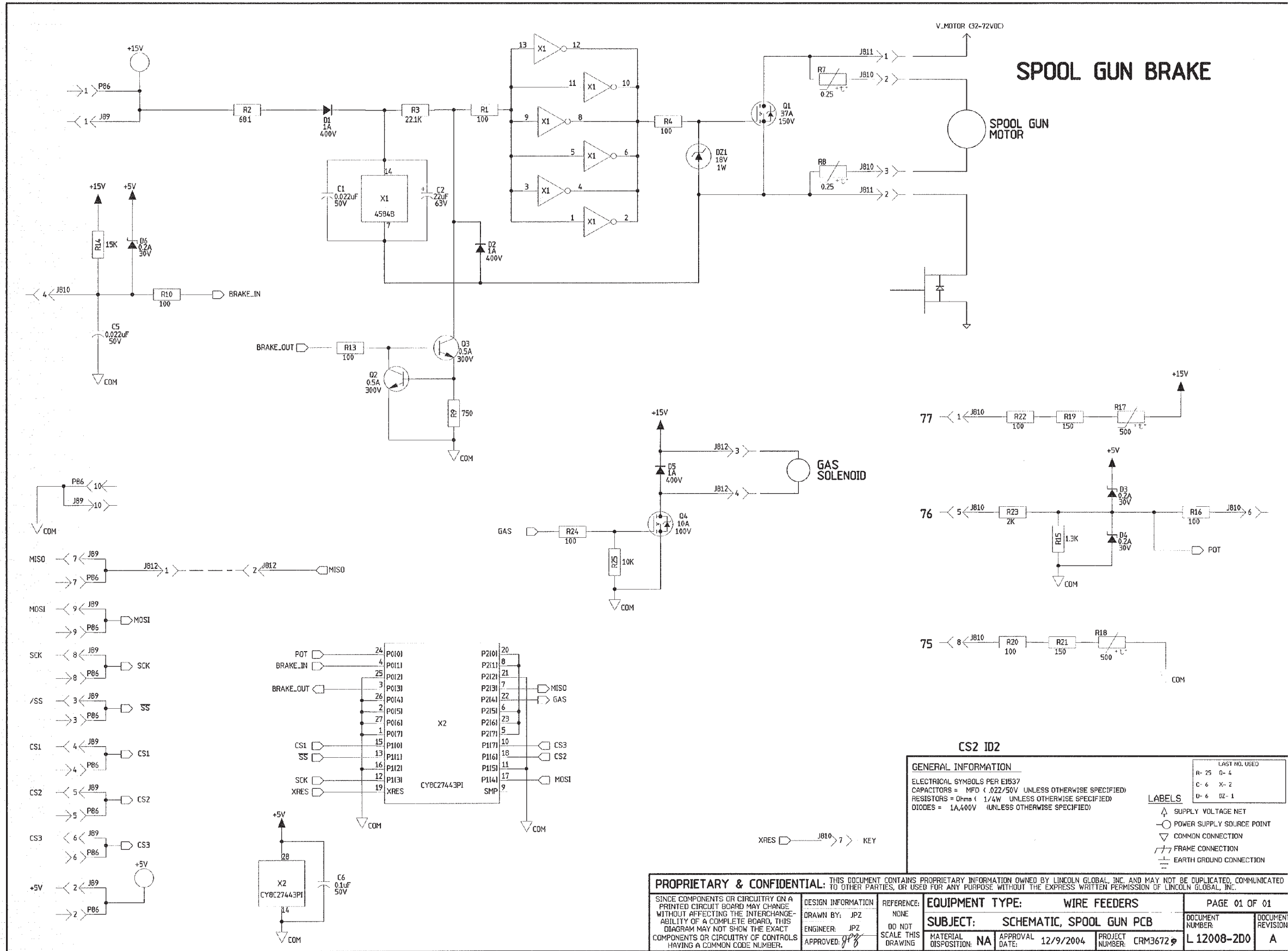
STRIP

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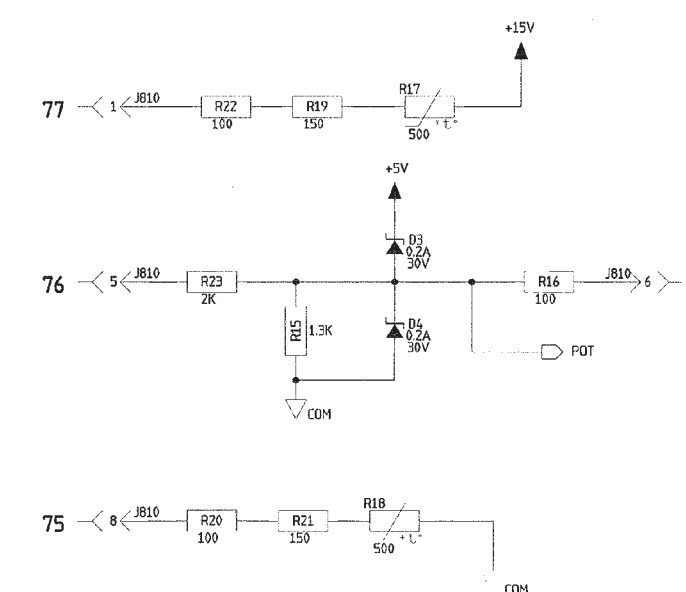




SCHEMATIC - SPOOL GUN P.C. BOARD (L12008-2D0)



SPOOL GUN BRAKE



**CS2 ID2**

GENERAL INFORMATION		LAST NO. USED	
ELECTRICAL SYMBOLS PER E1837		R- 25	0- 4
CAPACITORS = MFD (.022/50V UNLESS OTHERWISE SPECIFIED)		C- 6	X- 2
RESISTORS = Ohms ( 1/4W UNLESS OTHERWISE SPECIFIED)		D- 6	DZ- 1
DIODES = 1A,400V (UNLESS OTHERWISE SPECIFIED)			

**LABELS**

- ▲ SUPPLY VOLTAGE NET
- POWER SUPPLY SOURCE POINT
- ▽ COMMON CONNECTION
- ▽ FRAME CONNECTION
- ⊥ EARTH GROUND CONNECTION

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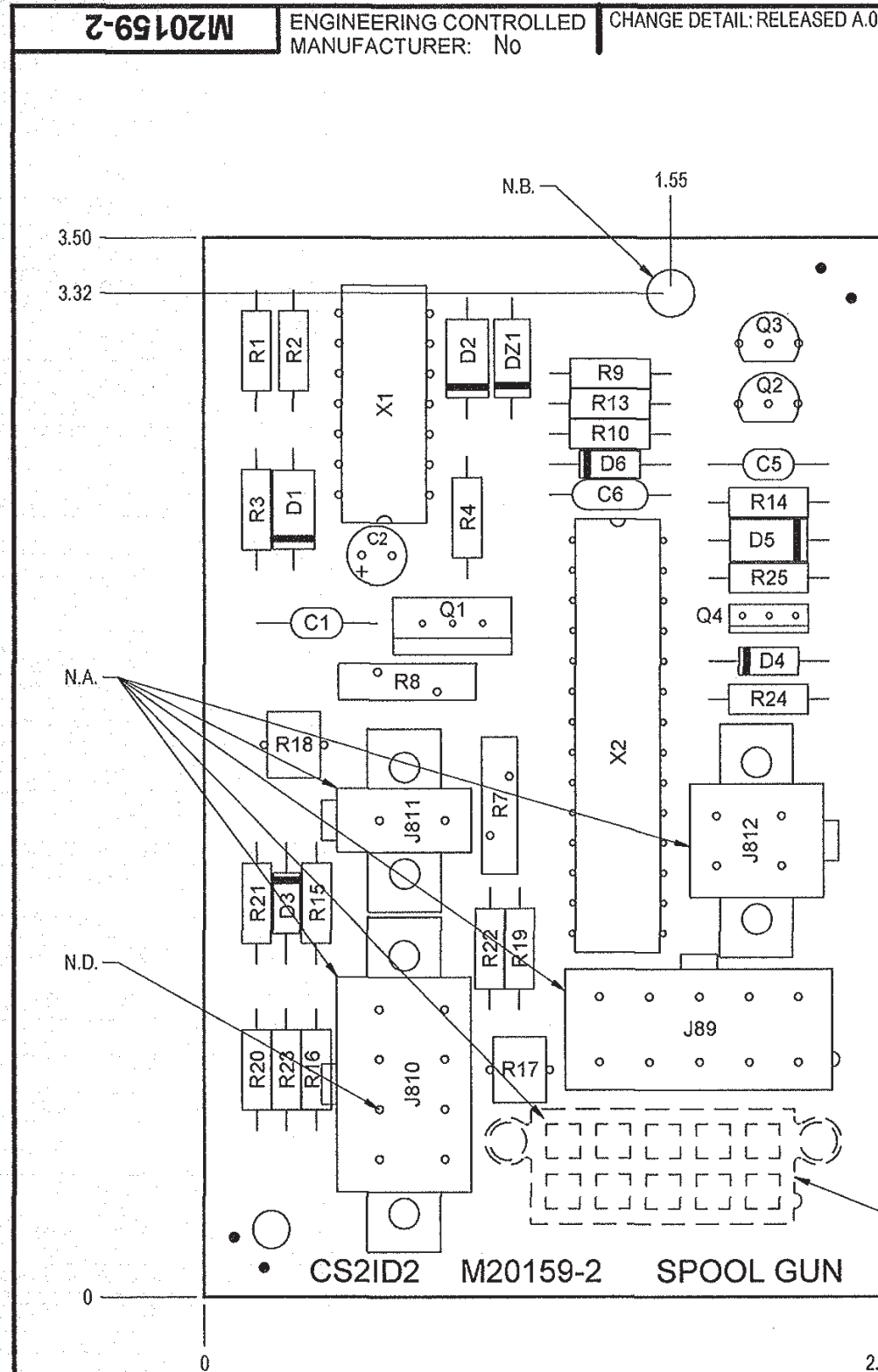
DESIGN INFORMATION	REFERENCE:	EQUIPMENT TYPE:	WIRE FEEDERS	PAGE 01 OF 01
DRAWN BY: JPZ	NONE	SUBJECT:	SCHEMATIC, SPOOL GUN PCB	DOCUMENT NUMBER:
ENGINEER: JPZ	DO NOT SCALE THIS DRAWING	MATERIAL DISPOSITION:	NA	L 12008-2D0
APPROVED: JPZ		APPROVAL DATE:	12/9/2004	DOCUMENT REVISION:
		PROJECT NUMBER:	CRM3672	A

NOTE: This diagram is for reference only. It may not be accurate for all machines covered by this manual.

Return to Section TOC / Return to Master TOC



PC BOARD ASSEMBLY - SPOOL GUN (M20159-2)



- NOTES:
- N.A. DO NOT COAT WITH ENCAPSULATION MATERIAL. KEEP HOLE FREE OF ENCAPSULATION MATERIAL.
  - N.B. MOUNTED ON BOTTOM SIDE OF P.C. BOARD.
  - N.C. PLACE ITEM 2 OVER HEADER PIN AS SHOWN. ITEM 2 SHOULD BE INSERTED BELOW CONNECTOR TOP SURFACE.
  - N.E. PROGRAM X2 PER ITEM 3 AND LABEL X2 WITH PART OF ITEM 3.
  - N.F. **CAUTION:** THIS DEVICE IS SUBJECT TO DAMAGE BY STATIC ELECTRICITY. SEE E2454 BEFORE HANDLING.

MAKE PER E1911  
ENCAPSULATE WITH E1844 (2 DIPS)  
TEST PER E4190-SP

SCHEMATIC REFERENCE: L12008-2D0

MANUFACTURE AS:

M 2 0 1 5 9 - 2 D 0

PART NUMBER IDENTIFICATION CODE

ITEM	QTY	PART No.	DESCRIPTION
1	1	SEE BLANK INFO	P.C. BOARD BLANK
2	1	S24671	KEYING PLUG
3	1	Y00725-1	SOFTWARE

REFERENCES	QTY	PART NUMBER	DESCRIPTION
C1, C5	2	S16668-5	CAPACITOR,CEMO,.022,50V,20%
C2	1	S13490-181	CAP,ALCL,22,63V,20%
C6	1	S16668-11	CAPACITOR,CEMO,0.1, 50V,10%
DZ1	1	T12702-45	ZENER DIODE, 1W,18V,5% 1N4746A
D1-D2, D5	3	T12199-1	DIODE,AXLDS,1A,400V
D3-D4, D6	3	T12705-64	DIODE,SCHOTTKY,AXLDS,0.2A,30V,BAT42
J89	1	S18248-10	CONNECTOR,MOLEX,MINI,PCB,10-PIN
J810	1	S24020-8	CONNECTOR,MOLEX,MINI,PCB,8-PIN,TIN
J811	1	S24020-2G	CONNECTOR,MOLEX,MINI,PCB,2-PIN,GOLD
J812	1	S24020-4	CONNECTOR,MOLEX,MINI,PCB,4-PIN,TIN
P86	1	S21135-10	CONNECTOR,MOLEX,MINI,BLIND,F, 10-PIN

N.F. Q1	1	T12704-98	TRANSISTOR,NMF,T220,37A,150V,FDP2552(SS)
Q2-Q3	2	T12704-35	TRANSISTOR,NPN,TO226,0.5A, 300V,MPS-A42
N.F. Q4	1	T12704-109	TRANSISTOR,NMF,IPAK,TO-251,10A,100V(SS)

R1, R4, R10, R13, R16, R20, R22, R24	8	S19400-1000	RESISTOR,MF,1/4W,100,1%
R2	1	S19400-68R1	RESISTOR,MF,1/4W,68.1,1%
R3	1	S19400-2212	RESISTOR,MF,1/4W,22.1K,1%
R7-R8	2	S18380-4	THERMISTOR,.02-.47 OHMS, 0.9AMP
R9	1	S19400-7500	RESISTOR,MF,1/4W,750,1%
R14	1	S19400-1502	RESISTOR,MF,1/4W,15.0K,1%
R15	1	S19400-1301	RESISTOR,MF,1/4W,1.30K,1%
R17-R18	2	S18380-14	THERMISTOR,PTC,500OHMS,28mA
R19, R21	2	S19400-1500	RESISTOR,MF,1/4W,150,1%
R23	1	S19400-2001	RESISTOR,MF,1/4W,2.00K,1%
R25	1	S19400-1002	RESISTOR,MF,1/4W,10.0K,1%

N.F. X1	1	S15018-4	IC,CMOS,INVERTER,SCHMITT, HEX,4584(SS)
N.E., N.F. X2	1	S25073-9	IC,CMOS,PSOC,8-BIT,CY8C27443,DIP-28(SS)

UNLESS OTHERWISE SPECIFIED:  
CAPACITANCE = MFD/VOLTS  
INDUCTANCE = HENRIES  
RESISTANCE = OHMS

P.C. BOARD BLANK REFERENCE INFORMATION  
BUY BLANK COMPLETE AS M20159-D  
(4 LAYER BOARD PER E3281)  
(MAKES 24 BOARDS PER PANEL. SEE ELECTRONIC FILE FOR ADDITIONAL INFORMATION)

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MANUFACTURING TOLERANCE PER E2056 UNLESS OTHERWISE SPECIFIED TOLERANCE ON 2 PLACE DECIMALS IS ±.02 ON 3 PLACE DECIMALS IS ±.002 ON ALL ANGLES IS ±.5 OF A DEGREE MATERIAL TOLERANCE ("Y") TO AGREE WITH PUBLISHED STANDARDS. DO NOT SCALE THIS DRAWING		DESIGN INFORMATION	REFERENCE:	EQUIPMENT TYPE:		PAGE 1 OF 1	
		DRAWN BY: cstuble	M20159-1	POWER MIG 350MP		DOCUMENT NUMBER:	
		ENGINEER: J. ZUCKER	SCALE:	SUBJECT:		M20159-2	
		APPROVED: <i>J. Zucker</i>	2:1	SPOOL GUN P. C. BOARD ASSEMBLY		DOCUMENT REVISION:	
				MATERIAL DISPOSITION: NA	APPROVAL DATE: 12/14/2004	PROJECT NUMBER: CRM36729	A

NOTE: Lincoln Electric assumes no responsibility for liabilities resulting from board level troubleshooting. PC Board repairs will invalidate your factory warranty. **Individual Printed Circuit Board Components are not available from Lincoln Electric.** This information is provided for reference only. Lincoln Electric discourages board level troubleshooting and repair since it may compromise the quality of the design and may result in danger to the Machine Operator or Technician. Improper PC board repairs could result in damage to the machine.







PC BOARD ASSEMBLY - DISPLAY (L11757-1)

Return to Section TOC  
Return to Master TOC

Return to Section TOC  
Return to Master TOC

Return to Section TOC  
Return to Master TOC

Return to Section TOC  
Return to Master TOC

<b>L11757-1</b>	ENGINEERING CONTROLLED MANUFACTURER: Yes	CHANGE DETAIL: LED5, 6 & 7, REVISED PART NUMBER AND DESCRIPTION. REVISED IDENTIFICATION CODE AND SCHEMATIC REF. NUMBER.
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ITEM / REFERENCE DESIGNATORS	QTY	PART NUMBER	DESCRIPTION
1	1	L11757-E	P.C. BOARD BLANK
2	4	T15176-2	LED, SPACER, 0.140 HIGH
3	.01 OZ.	E3539	ELECTRICAL INSULATING COMPOUND
FOR ITEMS BELOW REFER TO ELECTRONIC COMPONENTS DATABASE FOR COMPONENT SPECIFICATIONS			
C1	1	S25024-7SMT	CAPACITOR,SMD,TANTALUM,47MF,20V,10%,S7343
C2, C3, C4, C5, C11, C12, C19, C20	8	S25020-3SMT	CAPACITOR,SMD,CERAMIC,0.1MF,50V,10%,X7R,S0805
N.A., N.D. DISP1, DISP2	2	S17395-9	LED,DISPLAY,7-SEGMENT,CC,4-DIGIT
J37	1	S18248-10	CONNECTOR,MOLEX,MINI,PCB,10-PIN
N.C. LED1, LED2, LED3, LED4	4	T13657-6	LED,T-1,RED,HLM,K-101
N.A. LED5, LED6, LED7	3	T13657-14	LED,T-1,3/4,AMBER,HIGH-INTENSITY
R6, R16	2	S25000-1501SMT	RESISTOR,SMD,METAL FILM,1/10W,1.50K,1%,S0805
R9, R10, R11, R12, R13, R14	6	S25000-1212SMT	RESISTOR,SMD,METAL FILM,1/10W,12.1K,1%,S0805
R20	1	S25000-2670SMT	RESISTOR,SMD,METAL FILM,1/10W,267OHMS,1%,S0805
R21, R25, R26, R28, R29	5	S25000-1001SMT	RESISTOR,SMD,METAL FILM,1/10W,1.00K,1%,S0805
R22, R23	2	S25000-10R0SMT	RESISTOR,SMD,METAL FILM,1/10W,10.0OHMS,1%,S0805
R24	1	S25000-4751SMT	RESISTOR,SMD,METAL FILM,1/10W,4.75K,1%,S0805
R27	1	S25000-4752SMT	RESISTOR,SMD,METAL FILM,1/10W,47.5K,1%,S0805
N.A. X1	1	S17900-8SMT	IC,SMD,CMOS,INVERTER,SCHMITT,HEX,HC14A(SS)
N.A. X2	1	S17900-26SMT	IC,CMOS,SMD,MUX,DAT,8-INPUT,HC151(SS)
N.A. X3	1	S17900-28SMT	IC,SMD,CMOS,HEX INVERTING BUFFER,3-ST(SS)
N.A. X4	1	S17900-10SMT	IC,SMD,CMOS,REGISTER,SHIFT,SPI/SO,8-BIT(SS)
N.A. X5, X6, X7	3	S20496-1SMT	IC,SMD,CMOS,DRIVER,DISPLAY,LED,CC,MCU

SCHEMATIC REFERENCE: L11756-1E1

UNLESS OTHERWISE SPECIFIED:  
CAPCITANCE = MFD/VOLTS  
RESISTANCE = OHMS  
INDUCTANCE = HENRIES

NOTE:  
N.A. CAUTION: THIS DEVICE SUBJECT TO DAMAGE BY STATIC ELECTRICITY. SEE E2454 BEFORE HANDLING.  
N.B. DO NOT COAT WITH ENCAPSULATION MATERIAL.  
N.C. USE ITEM 2 TO STAND LED1, LED2, LED3 AND LED4 FROM THE P.C. BOARD. THERE MUST NOT BE MORE THAN .020 GAP BETWEEN SPACER AND P.C. BOARD OR BETWEEN SPACER AND LED. ENCAPSULATE P.C. BOARD, SPACER AND LOWER HALF OF LED.  
N.D. DISP1 AND DISP2 MUST ALWAYS BE MATCHED BY VENDOR NAME. DO NOT MIX DIFFERENT VENDORS ON THE SAME BOARD ASSEMBLY. ENCAPSULATE LOWER HALF OF DISPLAYS ONLY, FACE AND UPPER HALF MUST BE FREE OF ENCAPSULATION.  
N.E. CONNECTOR MUST BE GREASED WITH ITEM 3 PRIOR TO ENCAPSULATION.

BUY AS:

**L11757-1E1**

IDENTIFICATION CODE

ENCAPSULATE WITH HUMISEAL 1A27LU  
PER E1844 OR WITH EQUIVALENT AS  
APPROVED BY LINCOLN ELECTRIC COMPANY.  
(2 COATS)

BUY PER E3867  
TEST PER E3856-D

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NOTE: Lincoln Electric assumes no responsibility for liabilities resulting from board level troubleshooting. PC Board repairs will invalidate your factory warranty. Individual Printed Circuit Board Components are not available from Lincoln Electric. This information is provided for reference only. Lincoln Electric discourages board level troubleshooting and repair since it may compromise the quality of the design and may result in danger to the Machine Operator or Technician. Improper PC board repairs could result in damage to the machine.







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