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2007-05

**Processes**



Stick (SMAW) Welding

**Description**

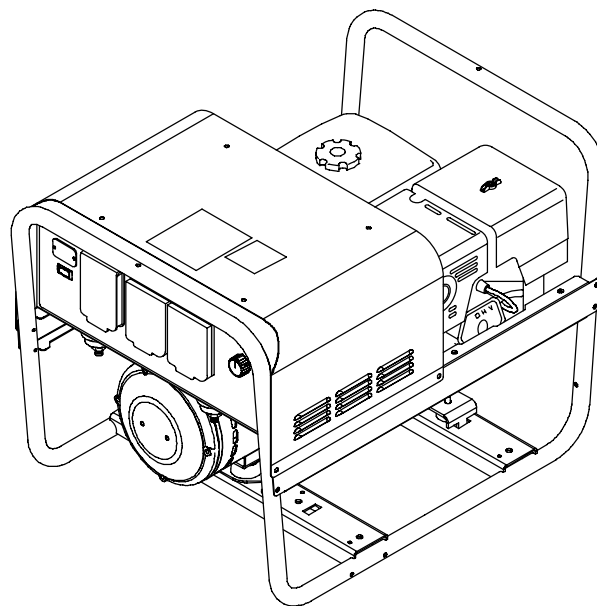


Engine Driven Welding Generator

ENGLISH

ESPAÑOL

# Blue Star<sup>®</sup> 185 Blue Star<sup>®</sup> 185 DX



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## OWNER'S MANUAL

File: Engine Drive



# From Miller to You

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*Thank you and congratulations* on choosing Miller. Now you can get the job done and get it done right. We know you don't have time to do it any other way.

That's why when Niels Miller first started building arc welders in 1929, he made sure his products offered long-lasting value and superior quality. Like you, his customers couldn't afford anything less. Miller products had to be more than the best they could be. They had to be the best you could buy.

Today, the people that build and sell Miller products continue the tradition. They're just as committed to providing equipment and service that meets the high standards of quality and value established in 1929.

This Owner's Manual is designed to help you get the most out of your Miller products. Please take time to read the Safety precautions. They will help you protect yourself against potential hazards on the worksite.

We've made installation and operation quick and easy. With Miller you can count on years of reliable service with proper maintenance. And if for some reason the unit needs repair, there's a Troubleshooting section that will help you figure out what the problem is. The parts list will then help you to decide the exact part you may need to fix the problem. Warranty and service information for your particular model are also provided.



Miller is the first welding equipment manufacturer in the U.S.A. to be registered to the ISO 9001:2000 Quality System Standard.

Miller Electric manufactures a full line of welders and welding related equipment. For information on other quality Miller products, contact your local Miller distributor to receive the latest full line catalog or individual specification sheets. **To locate your nearest distributor or service agency call 1-800-4-A-Miller, or visit us at [www.MillerWelds.com](http://www.MillerWelds.com) on the web.**



Working as hard as you do – every power source from Miller is backed by the most hassle-free warranty in the business.



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<b>WARRANTY</b>	



# SECTION 1 – SAFETY PRECAUTIONS – READ BEFORE USING

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 Protect yourself and others from injury — read and follow these precautions.

## 1-1. Symbol Usage



**DANGER!** – Indicates a hazardous situation which, if not avoided, will result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.



Indicates a hazardous situation which, if not avoided, could result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.

**NOTICE** – Indicates statements not related to personal injury.

 Indicates special instructions.



This group of symbols means Warning! Watch Out! ELECTRIC SHOCK, MOVING PARTS, and HOT PARTS hazards. Consult symbols and related instructions below for necessary actions to avoid the hazards.

## 1-2. Arc Welding Hazards



The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard. The safety information given below is only a summary of the more complete safety information found in the Safety Standards listed in Section 1-7. Read and follow all Safety Standards.



Only qualified persons should install, operate, maintain, and repair this unit.



During operation, keep everybody, especially children, away.



### ELECTRIC SHOCK can kill.

Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on. The input power circuit and machine internal circuits are also live when power is on. In semiautomatic or automatic wire welding, the wire, wire reel, drive roll housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is a hazard.

- Do not touch live electrical parts.
- Wear dry, hole-free insulating gloves and body protection.
- Insulate yourself from work and ground using dry insulating mats or covers big enough to prevent any physical contact with the work or ground.
- Do not use AC output in damp areas, if movement is confined, or if there is a danger of falling.
- Use AC output ONLY if required for the welding process.
- If AC output is required, use remote output control if present on unit.
- Additional safety precautions are required when any of the following electrically hazardous conditions are present: 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; or when there is a high risk of unavoidable or accidental contact with the workpiece or ground. For these conditions, use the following equipment in order presented: 1) a semiautomatic DC constant voltage (wire) welder, 2) a DC manual (stick) welder, or 3) an AC welder with reduced open-circuit voltage. In most situations, use of a DC, constant voltage wire welder is recommended. And, do not work alone!
- Disconnect input power or stop engine before installing or servicing this equipment. Lockout/tagout input power according to OSHA 29 CFR 1910.147 (see Safety Standards).
- Properly install and ground this equipment according to its Owner's Manual and national, state, and local codes.

- Always verify the supply ground — check and be sure that input power cord ground wire is properly connected to ground terminal in disconnect box or that cord plug is connected to a properly grounded receptacle outlet.
- When making input connections, attach proper grounding conductor first – double-check connections.
- Keep cords dry, free of oil and grease, and protected from hot metal and sparks.
- Frequently inspect input power cord for damage or bare wiring — replace cord immediately if damaged — bare wiring can kill.
- Turn off all equipment when not in use.
- Do not use worn, damaged, undersized, or poorly spliced cables.
- Do not drape cables over your body.
- If earth grounding of the workpiece is required, ground it directly with a separate cable.
- Do not touch electrode if you are in contact with the work, ground, or another electrode from a different machine.
- Use only well-maintained equipment. Repair or replace damaged parts at once. Maintain unit according to manual.
- Do not touch electrode holders connected to two welding machines at the same time since double open-circuit voltage will be present.
- Wear a safety harness if working above floor level.
- Keep all panels and covers securely in place.
- Clamp work cable with good metal-to-metal contact to workpiece or worktable as near the weld as practical.
- Insulate work clamp when not connected to workpiece to prevent contact with any metal object.
- Do not connect more than one electrode or work cable to any single weld output terminal.

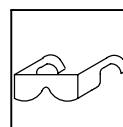
### SIGNIFICANT DC VOLTAGE exists in inverters after stopping engine.

- Stop engine on inverter and discharge input capacitors according to instructions in Maintenance Section before touching any parts.



### HOT PARTS can cause severe burns.

- Do not touch hot parts bare handed.
- Allow cooling period before working on equipment.
- To handle hot parts, use proper tools and/or wear heavy, insulated welding gloves and clothing to prevent burns.



### FLYING METAL or DIRT can injure eyes.

- Welding, chipping, wire brushing, and grinding cause sparks and flying metal. As welds cool, they can throw off slag.
- Wear approved safety glasses with side shields even under your welding helmet.



## FUMES AND GASES can be hazardous.

Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

- Keep your head out of the fumes. Do not breathe the fumes.
- If inside, ventilate the area and/or use local forced ventilation at the arc to remove welding fumes and gases.
- If ventilation is poor, wear an approved air-supplied respirator.
- Read and understand the Material Safety Data Sheets (MSDSs) and the manufacturer's instructions for metals, consumables, coatings, cleaners, and degreasers.
- Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Always have a trained watch-person nearby. Welding fumes and gases can displace air and lower the oxygen level causing injury or death. Be sure the breathing air is safe.
- Do not weld in locations near degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapors to form highly toxic and irritating gases.
- Do not weld on coated metals, such as galvanized, lead, or cadmium plated steel, unless the coating is removed from the weld area, the area is well ventilated, and while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes if welded.



## BUILDUP OF GAS can injure or kill.

- Shut off shielding gas supply when not in use.
- Always ventilate confined spaces or use approved air-supplied respirator.



## ARC RAYS can burn eyes and skin.

Arc rays from the welding process produce intense visible and invisible (ultraviolet and infrared) rays that can burn eyes and skin. Sparks fly off from the weld.

- Wear an approved welding helmet fitted with a proper shade of filter lenses to protect your face and eyes from arc rays and sparks when welding or watching (see ANSI Z49.1 and Z87.1 listed in Safety Standards).
- Wear approved safety glasses with side shields under your helmet.
- Use protective screens or barriers to protect others from flash, glare, and sparks; warn others not to watch the arc.
- Wear protective clothing made from durable, flame-resistant material (leather, heavy cotton, or wool) and foot protection.



## WELDING can cause fire or explosion.

Welding on closed containers, such as tanks, drums, or pipes, can cause them to blow up. Sparks can fly off from the welding arc. The flying sparks, hot workpiece, and hot equipment can cause fires and burns. Accidental contact of electrode to metal objects can cause sparks, explosion, overheating, or fire. Check and be sure the area is safe before doing any welding.

- Remove all flammables within 35 ft (10.7 m) of the welding arc. If this is not possible, tightly cover them with approved covers.
- Do not weld where flying sparks can strike flammable material.
- Protect yourself and others from flying sparks and hot metal.
- Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas.
- Watch for fire, and keep a fire extinguisher nearby.
- Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.

- Do not weld on closed containers such as tanks, drums, or pipes, unless they are properly prepared according to AWS F4.1 (see Safety Standards).
- Do not weld where the atmosphere may contain flammable dust, gas, or liquid vapors (such as gasoline).
- Connect work cable to the work as close to the welding area as practical to prevent welding current from traveling long, possibly unknown paths and causing electric shock, sparks, and fire hazards.
- Do not use welder to thaw frozen pipes.
- Remove stick electrode from holder or cut off welding wire at contact tip when not in use.
- Wear oil-free protective garments such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap.
- Remove any combustibles, such as a butane lighter or matches, from your person before doing any welding.
- After completion of work, inspect area to ensure it is free of sparks, glowing embers, and flames.
- Use only correct fuses or circuit breakers. Do not oversize or bypass them.
- Follow requirements in OSHA 1910.252 (a) (2) (iv) and NFPA 51B for hot work and have a fire watcher and extinguisher nearby.



## NOISE can damage hearing.

Noise from some processes or equipment can damage hearing.

- Wear approved ear protection if noise level is high.



## MAGNETIC FIELDS can affect Implanted Medical Devices.

- Wearers of Pacemakers and other Implanted Medical Devices should keep away.
- Implanted Medical Device wearers should consult their doctor and the device manufacturer before going near arc welding, spot welding, gouging, plasma arc cutting, or induction heating operations.



## CYLINDERS can explode if damaged.

Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Since gas cylinders are normally part of the welding process, be sure to treat them carefully.

- Protect compressed gas cylinders from excessive heat, mechanical shocks, physical damage, slag, open flames, sparks, and arcs.
- Install cylinders in an upright position by securing to a stationary support or cylinder rack to prevent falling or tipping.
- Keep cylinders away from any welding or other electrical circuits.
- Never drape a welding torch over a gas cylinder.
- Never allow a welding electrode to touch any cylinder.
- Never weld on a pressurized cylinder — explosion will result.
- Use only correct shielding gas cylinders, regulators, hoses, and fittings designed for the specific application; maintain them and associated parts in good condition.
- Turn face away from valve outlet when opening cylinder valve.
- Keep protective cap in place over valve except when cylinder is in use or connected for use.
- Use the right equipment, correct procedures, and sufficient number of persons to lift and move cylinders.
- Read and follow instructions on compressed gas cylinders, associated equipment, and Compressed Gas Association (CGA) publication P-1 listed in Safety Standards.

## 1-3. Engine Hazards



### BATTERY EXPLOSION can BLIND.

- Always wear a face shield, rubber gloves, and protective clothing when working on a battery.
- Stop engine before disconnecting or connecting battery cables or servicing battery.
- Do not allow tools to cause sparks when working on a battery.
- Do not use welder to charge batteries or jump start vehicles.
- Observe correct polarity (+ and -) on batteries.
- Disconnect negative (-) cable first and connect it last.



### FUEL can cause fire or explosion.

- Stop engine and let it cool off before checking or adding fuel.
- Do not add fuel while smoking or if unit is near any sparks or open flames.
- Do not overfill tank — allow room for fuel to expand.
- Do not spill fuel. If fuel is spilled, clean up before starting engine.
- Dispose of rags in a fireproof container.
- Always keep nozzle in contact with tank when fueling.



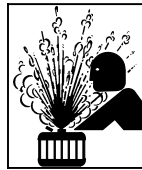
### MOVING PARTS can cause injury.

- Keep away from fans, belts, and rotors.
- Keep all doors, panels, covers, and guards closed and securely in place.
- Stop engine before installing or connecting unit.
- Have only qualified people remove doors, panels, covers, or guards for maintenance and troubleshooting as necessary.
- To prevent accidental starting during servicing, disconnect negative (-) battery cable from battery.
- Keep hands, hair, loose clothing, and tools away from moving parts.
- Reinstall doors, panels, covers, or guards when servicing is finished and before starting engine.
- Before working on generator, remove spark plugs or injectors to keep engine from kicking back or starting.
- Block flywheel so that it will not turn while working on generator components.



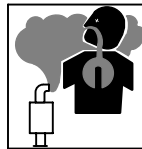
### HOT PARTS can cause severe burns.

- Do not touch hot parts bare handed.
- Allow cooling period before working on equipment.
- To handle hot parts, use proper tools and/or wear heavy, insulated welding gloves and clothing to prevent burns.



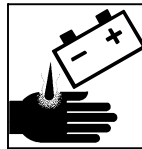
### STEAM AND HOT COOLANT can burn.

- If possible, check coolant level when engine is cold to avoid scalding.
- Always check coolant level at overflow tank, if present on unit, instead of radiator (unless told otherwise in maintenance section or engine manual).
- If the engine is warm, checking is needed, and there is no overflow tank, follow the next two statements.
- Wear safety glasses and gloves and put a rag over radiator cap.
- Turn cap slightly and let pressure escape slowly before completely removing cap.



### Using a generator indoors CAN KILL YOU IN MINUTES.

- Generator exhaust contains carbon monoxide. This is a poison you cannot see or smell.
- NEVER use inside a home or garage, EVEN IF doors and windows are open.
- Only use OUTSIDE and far away from windows, doors, and vents.



### BATTERY ACID can BURN SKIN and EYES.

- Do not tip battery.
- Replace damaged battery.
- Flush eyes and skin immediately with water.



### ENGINE HEAT can cause fire.

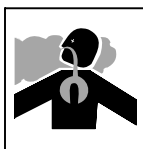
- Do not locate unit on, over, or near combustible surfaces or flammables.
- Keep exhaust and exhaust pipes way from flammables.



### EXHAUST SPARKS can cause fire.

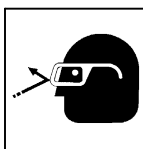
- Do not let engine exhaust sparks cause fire.
- Use approved engine exhaust spark arrestor in required areas — see applicable codes.

## 1-4. Compressed Air Hazards



### BREATHING COMPRESSED AIR can cause serious injury or death.

- Do not use compressed air for breathing.
- Use only for cutting, gouging, and tools.



### COMPRESSED AIR can cause injury.

- Wear approved safety goggles.
- Do not direct air stream toward self or others.



### TRAPPED AIR PRESSURE AND WHIPPING HOSES can cause injury.

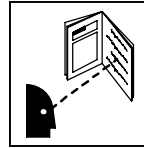
- Release air pressure from tools and system before servicing, adding or changing attachments, or opening compressor oil drain or oil fill cap.

**HOT METAL from air arc cutting and gouging can cause fire or explosion.**

- Do not cut or gouge near flammables.
- Watch for fire; keep extinguisher nearby.

**HOT PARTS can cause burns and injury.**

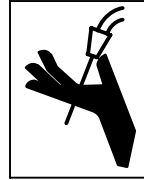
- Do not touch hot compressor or air system parts.
- Let system cool down before touching or servicing.

**READ INSTRUCTIONS.**

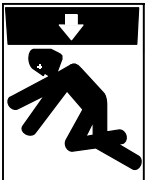
- Read Owner's Manual before using or servicing unit.
- Stop engine and release air pressure before servicing.
- Use only genuine replacement parts from the manufacturer.

**1-5. Additional Symbols For Installation, Operation, And Maintenance****FIRE OR EXPLOSION hazard.**

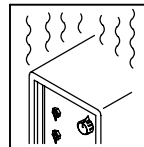
- Do not install or place unit on, over, or near combustible surfaces.
- Do not install unit near flammables.
- Do not overload building wiring – be sure power supply system is properly sized, rated, and protected to handle this unit.

**WELDING WIRE can cause injury.**

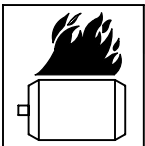
- Do not press gun trigger until instructed to do so.
- Do not point gun toward any part of the body, other people, or any metal when threading welding wire.

**FALLING UNIT can cause injury.**

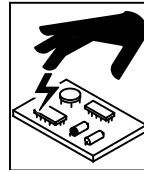
- Use lifting eye to lift unit and properly installed accessories only, NOT gas cylinders. Do not exceed maximum lift eye weight rating (see Specifications).
- Lift and support unit only with proper equipment and correct procedures.
- If using lift forks to move unit, be sure forks are long enough to extend beyond opposite side of unit.

**OVERUSE can cause OVERHEATING.**

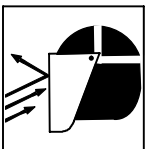
- Allow cooling period; follow rated duty cycle.
- Reduce current or reduce duty cycle before starting to weld again.
- Do not block or filter airflow to unit.

**OVERHEATING can damage motors.**

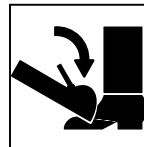
- Turn off or unplug equipment before starting or stopping engine.
- Do not let low voltage and frequency caused by low engine speed damage electric motors.
- Do not connect 50 or 60 Hertz motors to the 100 Hertz receptacle where applicable.

**STATIC (ESD) can damage PC boards.**

- Put on grounded wrist strap BEFORE handling boards or parts.
- Use proper static-proof bags and boxes to store, move, or ship PC boards.

**FLYING SPARKS can cause injury.**

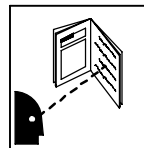
- Wear a face shield to protect eyes and face.
- Shape tungsten electrode only on grinder with proper guards in a safe location wearing proper face, hand, and body protection.
- Sparks can cause fires — keep flammables away.

**TILTING OF TRAILER can cause injury.**

- Use tongue jack or blocks to support weight.
- Properly install welding generator onto trailer according to instructions supplied with trailer.

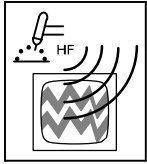
**MOVING PARTS can cause injury.**

- Keep away from moving parts.
- Keep away from pinch points such as drive rolls.

**READ INSTRUCTIONS.**

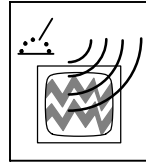
- Read Owner's Manual before using or servicing unit.
- Use only genuine replacement parts from the manufacturer.
- Perform engine and air compressor maintenance and service according to this manual and the engine/air compressor (if applicable) manuals.





### H.F. RADIATION can cause interference.

- High-frequency (H.F.) can interfere with radio navigation, safety services, computers, and communications equipment.
- Have only qualified persons familiar with electronic equipment perform this installation.
- The user is responsible for having a qualified electrician promptly correct any interference problem resulting from the installation.
- If notified by the FCC about interference, stop using the equipment at once.
- Have the installation regularly checked and maintained.
- Keep high-frequency source doors and panels tightly shut, keep spark gaps at correct setting, and use grounding and shielding to minimize the possibility of interference.



### ARC WELDING can cause interference.

- Electromagnetic energy can interfere with sensitive electronic equipment such as micro-processors, computers, and computer-driven equipment such as robots.
- Be sure all equipment in the welding area is electromagnetically compatible.
- To reduce possible interference, keep weld cables as short as possible, close together, and down low, such as on the floor.
- Locate welding operation 100 meters from any sensitive electronic equipment.
- Be sure this welding machine is installed and grounded according to this manual.
- If interference still occurs, the user must take extra measures such as moving the welding machine, using shielded cables, using line filters, or shielding the work area.

## 1-6. California Proposition 65 Warnings

- ⚠ Welding or cutting equipment produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code Section 25249.5 et seq.)**
- ⚠ Battery posts, terminals and related accessories contain lead and lead compounds, chemicals known to the State of California to cause cancer and birth defects or other reproductive harm. Wash hands after handling.**

### For Gasoline Engines:

- ⚠ Engine exhaust contains chemicals known to the State of California to cause cancer, birth defects, or other reproductive harm.**

### For Diesel Engines:

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

## 1-7. Principal Safety Standards

*Safety in Welding, Cutting, and Allied Processes*, ANSI Standard Z49.1, from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

*Recommended Safe Practices for the Preparation for Welding and Cutting of Containers and Piping*, American Welding Society Standard AWS F4.1, from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

*National Electrical Code*, NFPA Standard 70, from National Fire Protection Association, P.O. Box 9101, Quincy, MA 02269-9101 (phone: 617-770-3000, website: www.nfpa.org and www.sparky.org).

*Safe Handling of Compressed Gases in Cylinders*, CGA Pamphlet P-1, from Compressed Gas Association, 4221 Walney Road, 5th Floor, Chantilly, VA 20151 (phone: 703-788-2700, website: www.cganet.com).

*Code for Safety in Welding and Cutting*, CSA Standard W117.2, from Canadian Standards Association, Standards Sales, 5060 Mississauga,

Ontario, Canada L4W 5NS (phone: 800-463-6727 or in Toronto 416-747-4044, website: www.csa-international.org).

*Safe Practice For Occupational And Educational Eye And Face Protection*, ANSI Standard Z87.1, from American National Standards Institute, 25 West 43rd Street, New York, NY 10036-8002 (phone: 212-642-4900, website: www.ansi.org).

*Standard for Fire Prevention During Welding, Cutting, and Other Hot Work*, NFPA Standard 51B, from National Fire Protection Association, P.O. Box 9101, Quincy, MA 02269-9101 (phone: 617-770-3000, website: www.nfpa.org).

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910, Subpart Q, and Part 1926, Subpart J, from U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250-7954 (phone: 1-866-512-1800) (there are 10 Regional Offices—phone for Region 5, Chicago, is 312-353-2220, website: www.osha.gov).

## 1-8. EMF Information

Considerations About Welding And The Effects Of Low Frequency Electric And Magnetic Fields

Welding current, as it flows through welding cables, will cause electromagnetic fields. There has been and still is some concern about such fields. However, after examining more than 500 studies spanning 17 years of research, a special blue ribbon committee of the National Research Council concluded that: "The body of evidence, in the committee's judgment, has not demonstrated that exposure to power-frequency electric and magnetic fields is a human-health hazard." However, studies are still going forth and evidence continues to be examined. Until the final conclusions of the research are reached, you may wish to minimize your exposure to electromagnetic fields when welding or cutting.

To reduce magnetic fields in the workplace, use the following procedures:

1. Keep cables close together by twisting or taping them, or using a cable cover.
2. Arrange cables to one side and away from the operator.
3. Do not coil or drape cables around your body.
4. Keep welding power source and cables as far away from operator as practical.
5. Connect work clamp to workpiece as close to the weld as possible.

### About Implanted Medical Devices:

Implanted Medical Device wearers should consult their doctor and the device manufacturer before performing or going near arc welding, spot welding, gouging, plasma arc cutting, or induction heating operations. If cleared by your doctor, then following the above procedures is recommended.

# SECTION 2 – CONSIGNES DE SÉCURITÉ – LIRE AVANT UTILISATION

rom\_2007-04fre

**!** Se protéger, ainsi que toute autre personne travaillant sur les lieux, contre les étincelles et le métal chaud.

## 2-1. Signification des symboles



**DANGER!** – Indique une situation dangereuse qui si on l'évite pas peut donner la mort ou des blessures graves. Les dangers possibles sont montrés par les symboles joints ou sont expliqués dans le texte.



Indique une situation dangereuse qui si on l'évite pas peut donner la mort ou des blessures graves. Les dangers possibles sont montrés par les symboles joints ou sont expliqués dans le texte.

**NOTE** – Indique des déclarations pas en relation avec des blessures personnelles.

 Indique des instructions spécifiques.



Ce groupe de symboles veut dire Avertissement! Attention! DANGER DE CHOC ELECTRIQUE, PIECES EN MOUVEMENT, et PIECES CHAUDES. Consulter les symboles et les instructions ci-dessous y afférant pour les actions nécessaires afin d'éviter le danger.

## 2-2. Dangers relatifs au soudage à l'arc



Les symboles présentés ci-après sont utilisés tout au long du présent manuel pour attirer votre attention et identifier les risques de danger. Lorsque vous voyez un symbole, soyez vigilant et suivez les directives mentionnées afin d'éviter tout danger. Les consignes de sécurité présentées ci-après ne font que résumer l'information contenue dans les normes de sécurité énumérées à la section 2-7. Veuillez lire et respecter toutes ces normes de sécurité.



L'installation, l'utilisation, l'entretien et les réparations ne doivent être confiés qu'à des personnes qualifiées.



Au cours de l'utilisation, tenir toute personne à l'écart et plus particulièrement les enfants.



### UN CHOC ÉLECTRIQUE peut tuer.

Un simple contact avec des pièces électriques peut provoquer une électrocution ou des blessures graves. L'électrode et le circuit de soudage sont sous tension

dès que l'appareil est sur ON. Le circuit d'entrée et les circuits internes de l'appareil sont également sous tension à ce moment-là. En soudage semi-automatique ou automatique, le fil, le dévidoir, le logement des galets d'entraînement et les pièces métalliques en contact avec le fil de soudage sont sous tension. Des matériels mal installés ou mal mis à la terre présentent un danger.

- Ne jamais toucher les pièces électriques sous tension.
- Porter des gants et des vêtements de protection secs ne comportant pas de trous.
- S'isoler de la pièce et de la terre au moyen de tapis ou d'autres moyens isolants suffisamment grands pour empêcher le contact physique éventuel avec la pièce ou la terre.
- Ne pas se servir de source électrique à courant électrique dans les zones humides, dans les endroits confinés ou là où on risque de tomber.
- Se servir d'une source électrique à courant électrique UNIQUEMENT si le procédé de soudage le demande.
- Si l'utilisation d'une source électrique à courant électrique s'avère nécessaire, se servir de la fonction de télécommande si l'appareil en est équipé.
- Des précautions de sécurité supplémentaires sont requises dans des environnements à risque comme: les endroits humides ou lorsque l'on porte des vêtements mouillés; sur des structures métalliques au sol, grillages et échafaudages; dans des positions assises, à genoux et allongées; ou quand il y a un risque important de contact accidentel avec la pièce ou le sol. Dans ces cas utiliser les appareils suivants dans l'ordre de préférence: 1) un poste à

souder DC semi-automatique de type CV (MIG/MAG), 2) un poste à souder manuel (électrode enrobée) DC, 3) un poste à souder manuel AC avec tension à vide réduite. Dans la plupart des cas, un poste courant continu de type CV est recommandé. Et, ne pas travailler seul!

- Couper l'alimentation ou arrêter le moteur avant de procéder à l'installation, à la réparation ou à l'entretien de l'appareil. Déverrouiller l'alimentation selon la norme OSHA 29 CFR 1910.147 (voir normes de sécurité).
- Installer et mettre à la terre correctement cet appareil conformément à son manuel d'utilisation et aux codes nationaux, provinciaux et municipaux.
- Toujours vérifier la terre du cordon d'alimentation – Vérifier et s'assurer que le fil de terre du cordon d'alimentation est bien raccordé à la borne de terre du sectionneur ou que la fiche du cordon est raccordée à une prise correctement mise à la terre.
- En effectuant les raccordements d'entrée fixer d'abord le conducteur de mise à la terre approprié et contre-vérifier les connexions.
- Les câbles doivent être exempts d'humidité, d'huile et de graisse; protégez-les contre les étincelles et les pièces métalliques chaudes.
- Vérifier fréquemment le cordon d'alimentation pour voir s'il n'est pas endommagé ou dénudé – remplacer le cordon immédiatement s'il est endommagé – un câble dénudé peut provoquer une électrocution.
- Mettre l'appareil hors tension quand on ne l'utilise pas.
- Ne pas utiliser des câbles usés, endommagés, de grosseur insuffisante ou mal épissés.
- Ne pas enrouler les câbles autour du corps.
- Si la pièce soudée doit être mise à la terre, le faire directement avec un câble distinct – ne pas utiliser le connecteur de pièce ou le câble de retour.
- Ne pas toucher l'électrode quand on est en contact avec la pièce, la terre ou une électrode provenant d'une autre machine.
- Ne pas toucher des porte électrodes connectés à deux machines en même temps à cause de la présence d'une tension à vide doublée.
- N'utiliser qu'un matériel en bon état. Réparer ou remplacer sur-le-champ les pièces endommagées. Entretenir l'appareil conformément à ce manuel.
- Porter un harnais de sécurité quand on travaille en hauteur.
- Maintenir solidement en place tous les panneaux et capots.
- Fixer le câble de retour de façon à obtenir un bon contact métal-métal avec la pièce à souder ou la table de travail, le plus près possible de la soudure.
- Isoler la pince de masse quand pas mis à la pièce pour éviter le contact avec tout objet métallique.

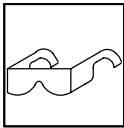
## Une tension DC importante subsiste à l'intérieur des onduleurs après avoir coupé l'alimentation.

- Couper l'alimentation du poste et décharger les condensateurs d'entrée comme indiqué dans la Section Maintenance avant de toucher des composants.



### DES PIÈCES CHAUDES peuvent provoquer des brûlures graves.

- Ne pas toucher à mains nues les parties chaudes.
- Prévoir une période de refroidissement avant de travailler à l'équipement.
- Ne pas toucher aux pièces chaudes, utiliser les outils recommandés et porter des gants de soudage et des vêtements épais pour éviter les brûlures.



### DES PIÈCES DE METAL ou DES SA-LETES peuvent provoquer des blessures dans les yeux.

- Le soudage, l'écaillage, le passage de la pièce à la brosse en fil de fer, et le meulage génèrent des étincelles et des particules métalliques volantes. Pendant la période de refroidissement des soudures, elles risquent de projeter du laitier.
- Porter des lunettes de sécurité avec écrans latéraux ou un écran facial.



### LES FUMÉES ET LES GAZ peuvent être dangereux.

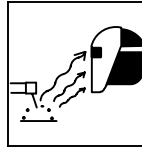
Le soudage génère des fumées et des gaz. Leur inhalation peut être dangereux pour votre santé.

- Eloigner votre tête des fumées. Ne pas respirer les fumées.
- À l'intérieur, ventiler la zone et/ou utiliser une ventilation forcée au niveau de l'arc pour l'évacuation des fumées et des gaz de soudage.
- Si la ventilation est médiocre, porter un respirateur anti-vapeurs approuvé.
- Lire et comprendre les spécifications de sécurité des matériaux (MSDS) et les instructions du fabricant concernant les métaux, les consommables, les revêtements, les nettoyants et les dégraissants.
- Travailler dans un espace fermé seulement s'il est bien ventilé ou en portant un respirateur à alimentation d'air. Demander toujours à un surveillant dûment formé de se tenir à proximité. Des fumées et des gaz de soudage peuvent déplacer l'air et abaisser le niveau d'oxygène provoquant des blessures ou des accidents mortels. S'assurer que l'air de respiration ne présente aucun danger.
- Ne pas souder dans des endroits situés à proximité d'opérations de dégraissage, de nettoyage ou de pulvérisation. La chaleur et les rayons de l'arc peuvent réagir en présence de vapeurs et former des gaz hautement toxiques et irritants.
- Ne pas souder des métaux munis d'un revêtement, tels que l'acier galvanisé, plaqué en plomb ou au cadmium à moins que le revêtement n'ait été enlevé dans la zone de soudure, que l'endroit soit bien ventilé, et en portant un respirateur à alimentation d'air. Les revêtements et tous les métaux renfermant ces éléments peuvent dégager des fumées toxiques en cas de soudage.



### LES ACCUMULATIONS DE GAZ risquent de provoquer des blessures ou même la mort.

- Fermer l'alimentation du gaz protecteur en cas de non utilisation.
- Veiller toujours à bien aérer les espaces confinés ou se servir d'un respirateur d'adduction d'air homologué.



### LES RAYONS DE L'ARC peuvent provoquer des brûlures dans les yeux et sur la peau.

Le rayonnement de l'arc du procédé de soudage génère des rayons visibles et invisibles intenses (ultraviolets et infrarouges) susceptibles de provoquer des brûlures dans les yeux et sur la peau. Des étincelles sont projetées pendant le soudage.

- Porter un casque de soudage approuvé muni de verres filtrants appropriés pour protéger visage et yeux pendant le soudage (voir ANSI Z49.1 et Z87.1 énuméré dans les normes de sécurité).
- Porter des lunettes de sécurité avec écrans latéraux même sous votre casque.
- Avoir recours à des écrans protecteurs ou à des rideaux pour protéger les autres contre les rayonnements les éblouissements et les étincelles ; prévenir toute personne sur les lieux de ne pas regarder l'arc.
- Porter des vêtements confectionnés avec des matières résistantes et ignifuges (cuir, coton lourd ou laine) et des bottes de protection.



### LE SOUDAGE peut provoquer un incendie ou une explosion.

Le soudage effectué sur des conteneurs fermés tel que des réservoirs, tambours ou des conduites peut provoquer leur éclatement. Des étincelles peuvent être projetées de l'arc de soudure. La projection d'étincelles, des pièces chaudes et des équipements chauds peut provoquer des incendies et des brûlures. Le contact accidentel de l'électrode avec des objets métalliques peut provoquer des étincelles, une explosion, un surchauffement ou un incendie. Avant de commencer le soudage, vérifier et s'assurer que l'endroit ne présente pas de danger.

- Déplacer toutes les substances inflammables à une distance de 10,7 m de l'arc de soudage. En cas d'impossibilité les recouvrir soigneusement avec des protections homologués.
- Ne pas souder dans un endroit où des étincelles peuvent tomber sur des substances inflammables.
- Se protéger et d'autres personnes de la projection d'étincelles et de métal chaud.
- Des étincelles et des matériaux chauds du soudage peuvent facilement passer dans d'autres zones en traversant de petites fissures et des ouvertures.
- Surveiller tout déclenchement d'incendie et tenir un extincteur à proximité.
- Le soudage effectué sur un plafond, plancher, paroi ou séparation peut déclencher un incendie de l'autre côté.
- Ne pas effectuer le soudage sur des conteneurs fermés tels que des réservoirs, tambours, ou conduites, à moins qu'ils n'aient été préparés correctement conformément à AWS F4.1 (voir les normes de sécurité).
- Ne soudez pas si l'air ambiant est chargé de particules, gaz, ou vapeurs inflammables (vapeur d'essence, par exemple).
- Brancher le câble de masse sur la pièce la plus près possible de la zone de soudage pour éviter le transport du courant sur une longue distance par des chemins inconnus éventuels en provoquant des risques d'électrocution, d'étincelles et d'incendie.
- Ne pas utiliser le poste de soudage pour dégeler des conduites gelées.
- En cas de non utilisation, enlever la baguette d'électrode du porte-électrode ou couper le fil à la pointe de contact.
- Porter des vêtements de protection dépourvus d'huile tels que des gants en cuir, une chemise en matériau lourd, des pantalons sans revers, des chaussures hautes et un couvre chef.
- Avant de souder, retirer toute substance combustible de vos poches telles qu'un allumeur au butane ou des allumettes.
- Une fois le travail achevé, assurez-vous qu'il ne reste aucune trace d'étincelles incandescentes ni de flammes.
- Utiliser exclusivement des fusibles ou coupe-circuits appropriés. Ne pas augmenter leur puissance; ne pas les ponter.

- Suivre les recommandations dans OSHA 1910.252(a)(2)(iv) et NFPA 51B pour les travaux à chaud et avoir de la surveillance et un extincteur à proximité.



### LE BRUIT peut affecter l'ouïe.

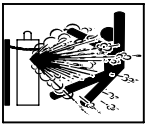
Le bruit des processus et des équipements peut affecter l'ouïe.

- Porter des protections approuvées pour les oreilles si le niveau sonore est trop élevé.



### LES CHAMPS MAGNETIQUES peuvent affecter des implants médicaux.

- Porteur de simulateur cardiaque ou autre implants médicaux, rester à distance.
- Les porteurs d'implants doivent d'abord consulter leur médecin avant de s'approcher des opérations de soudage à l'arc, de soudage par points, de gougeage, du coupage plasma ou de chauffage par induction.

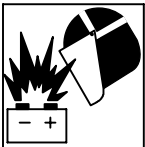


### Si des BOUTEILLES sont endommagées, elles pourront exploser.

Des bouteilles de gaz protecteur contiennent du gaz sous haute pression. Si une bouteille est endommagée, elle peut exploser. Du fait que les bouteilles de gaz forment normalement partie du procédé de soudage, les manipuler avec précaution.

- Protéger les bouteilles de gaz comprimé d'une chaleur excessive, des chocs mécaniques, des dommages physiques, du laitier, des flammes ouvertes, des étincelles et des arcs.
- Placer les bouteilles debout en les fixant dans un support stationnaire ou dans un porte-bouteilles pour les empêcher de tomber ou de se renverser.
- Tenir les bouteilles éloignées des circuits de soudage ou autres circuits électriques.
- Ne jamais placer une torche de soudage sur une bouteille à gaz.
- Une électrode de soudage ne doit jamais entrer en contact avec une bouteille.
- Ne jamais souder une bouteille pressurisée – risque d'explosion.
- Utiliser seulement des bouteilles de gaz protecteur, régulateurs, tuyaux et raccords convenables pour cette application spécifique; les maintenir ainsi que les éléments associés en bon état.
- Ne pas tenir la tête en face de la sortie en ouvrant la soupape de la bouteille.
- Maintenir le chapeau de protection sur la soupape, sauf en cas d'utilisation ou de branchement de la bouteille.
- Utiliser les équipements corrects, les bonnes procédures et suffisamment de personnes pour soulever et déplacer les bouteilles.
- Lire et suivre les instructions sur les bouteilles de gaz comprimé, l'équipement connexe et le dépliant P-1 de la CGA (Compressed Gas Association) mentionné dans les principales normes de sécurité.

## 2-3. Dangers existant en relation avec le moteur



### L'EXPLOSION DE LA BATTERIE peut RENDRE AVEUGLE.

- Toujours porter une protection faciale, des gants en caoutchouc et vêtements de protection lors d'une intervention sur la batterie.
- Arrêter le moteur avant de débrancher ou de brancher les câbles de batterie.
- Éviter de provoquer des étincelles avec les outils en travaillant sur la batterie.
- Ne pas utiliser le poste de soudage pour charger les batteries ou des véhicules de démarrage rapide.
- Observer la polarité correcte (+ et -) sur les batteries.
- Débrancher le câble négatif (-) en premier lieu. Le rebrancher en dernier lieu.



### LE CARBURANT MOTEUR peut provoquer un incendie ou une explosion.

- Arrêter le moteur avant de vérifier le niveau de carburant ou de faire le plein.
- Ne pas faire le plein en fumant ou proche d'une source d'étincelles ou d'une flamme nue.
- Ne pas faire le plein de carburant à ras bord; prévoir de l'espace pour son expansion.
- Faire attention de ne pas renverser de carburant. Nettoyer tout carburant renversé avant de faire démarrer le moteur.
- Jeter les chiffons dans un récipient ignifuge.
- Toujours garder le pistolet en contact avec le réservoir lors du remplissage.



### DES ORGANES MOBILES peuvent provoquer des blessures.

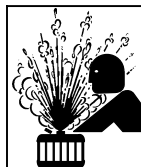
- Ne pas approcher les mains des ventilateurs, courroies et autres pièces en mouvement.
- Maintenir fermés et fixement en place les portes, panneaux, recouvrements et dispositifs de protection.
- Arrêter le moteur avant d'installer ou brancher l'appareil.

- Seules des personnes qualifiées sont autorisées à enlever les portes, panneaux, recouvrements ou dispositifs de protection pour effectuer, s'il y a lieu, des travaux d'entretien et de dépannage.
- Pour empêcher tout démarrage accidentel pendant les travaux d'entretien, débrancher le câble négatif (-) de batterie de la borne.
- Ne pas approcher les mains, cheveux, vêtements lâches et outils des organes mobiles.
- Remettre en place les panneaux ou les dispositifs de protection et fermer les portes à la fin des travaux d'entretien et avant de faire démarrer le moteur.
- Avant d'intervenir, déposer les bougies ou injecteurs pour éviter la mise en route accidentelle du moteur.
- Bloquer le volant moteur pour éviter sa rotation lors d'une intervention sur le générateur.



### DES PIÈCES CHAUDES peuvent provoquer des brûlures graves.

- Ne pas toucher à mains nues les parties chaudes.
- Prévoir une période de refroidissement avant de travailler à l'équipement.
- Ne pas toucher aux pièces chaudes, utiliser les outils recommandés et porter des gants de soudage et des vêtements épais pour éviter les brûlures.



### LA VAPEUR ET LE LIQUIDE DE REFROIDISSEMENT CHAUD peuvent provoquer des brûlures.

- Il est préférable de vérifier le liquide de refroidissement une fois le moteur refroidi pour éviter de se brûler.
- Toujours vérifier le niveau de liquide de refroidissement dans le vase d'expansion (si présent), et non dans le radiateur (sauf si précisé autrement dans la section maintenance du manuel du moteur).
- Si le moteur est chaud et que le liquide doit être vérifié, opérer comme suivant.
- Mettre des lunettes de sécurité et des gants, placer un torchon sur le bouchon du radiateur.

- Dévisser le bouchon légèrement et laisser la vapeur s'échapper avant d'enlever le bouchon.



**L'utilisation d'un groupe autonome à l'intérieur PEUT VOUS TUER EN QUELQUES MINUTES.**

- Les fumées d'un groupe autonome contient du monoxyde de carbone. C'est un poison invisible et inodore.
- JAMAIS utiliser dans une maison ou garage, même avec les portes et fenêtres ouvertes.
- Uniquement utiliser à l'EXTERIEUR, loin des portes, fenêtres et bouches aération.



**L'ACIDE DE LA BATTERIE peut provoquer des brûlures dans les YEUX et sur la PEAU.**

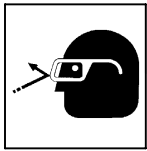
- Ne pas renverser la batterie.
- Remplacer une batterie endommagée.
- Rincer immédiatement les yeux et la peau à l'eau.

**2-4. Dangers liés à l'air comprimé**



**RESPIRER L'AIR COMPRIMÉ peut provoquer des blessures graves ou causer la mort.**

- Ne pas utiliser l'air comprimé pour respirer.
- Utiliser l'air comprimé seulement pour le coupage, gougeage et les outils pneumatiques.



**L'AIR COMPRIMÉ peut provoquer des blessures.**

- Porter des lunettes de sécurité approuvées.
- Ne pas diriger le jet d'air vers d'autres ou soi-même.



**L'AIR COMPRI ME EMMAGASINE ET DES TUYAUX SOUS PRESSION peuvent provoquer des blessures.**

- Relâcher la pression d'air de l'outillage ou du système avant d'effectuer la maintenance, avant de changer ou de rajouter des éléments ou avant d'ouvrir la purge ou le bouchon de remplissage d'huile.



**LA CHALEUR DU MOTEUR peut provoquer un incendie.**

- Ne pas placer l'appareil sur, au-dessus ou à proximité de surfaces inflammables.
- Tenir à distance les produits inflammables de l'échappement.



**LES ÉTINCELLES À L'ÉCHAPPEMENT peuvent provoquer un incendie.**

- Empêcher les étincelles d'échappement du moteur de provoquer un incendie.
- Utiliser uniquement un pare-étincelles approuvé – voir codes en vigueur.



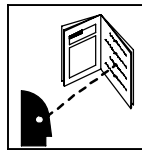
**Le METAL CHAUD lors du coupage et gougeage plasma peut provoquer un incendie ou une explosion.**

- Ne pas couper ou gouger à proximité de produits inflammables.
- Surveillez et garder un extincteur à proximité.



**DES PIÈCES CHAUDES peuvent provoquer des brûlures et blessures.**

- Ne pas toucher le compresseur ou d'autres éléments du circuit air comprimé chauds.
- Laisser l'ensemble se refroidir avant de toucher ou d'effectuer la maintenance.



**LIRE LES INSTRUCTIONS.**

- Lisez le manuel d'instructions avant l'utilisation ou la maintenance de l'appareil.
- Arrêter le moteur et relâcher la pression avant d'effectuer la maintenance.
- N'utiliser que les pièces de rechange recommandées par le constructeur.

**2-5. Dangers supplémentaires en relation avec l'installation, le fonctionnement et la maintenance**



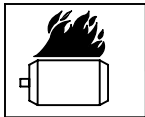
**Risque D'INCENDIE OU D'EXPLOSION.**

- Ne pas placer l'appareil sur, au-dessus ou à proximité de surfaces inflammables.
- Ne pas installer l'appareil à proximité de produits inflammables.
- Ne pas surcharger l'installation électrique – s'assurer que l'alimentation est correctement dimensionnée et protégée avant de mettre l'appareil en service.



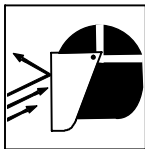
**LA CHUTE DE L'APPAREIL peut blesser.**

- Utiliser l'anneau de levage pour lever l'appareil et les accessoires correctement installés seuls, PAS les bouteilles de gaz. Ne pas dépasser le poids nominal maximal de l'œilleton (voir les spécifications).
- Ne lever et ne soutenir l'appareil qu'avec de l'équipement approprié et en suivant les procédures adéquates.
- En utilisant des fourches de levage pour déplacer l'unité, s'assurer que les fourches sont suffisamment longues pour dépasser du côté opposé de l'appareil.



### LE SURCHAUFFEMENT peut endommager le moteur électrique.

- Arrêter ou déconnecter l'équipement avant de démarrer ou d'arrêter le moteur.
- Ne pas laisser tourner le moteur trop lentement sous risque d'endommager le moteur électrique à cause d'une tension et d'une fréquence trop faibles.
- Ne pas brancher de moteur de 50 ou de 60 Hz à la prise de 100 Hz, s'il y a lieu.



### LES ÉTINCELLES VOLANTES risquent de provoquer des blessures.

- Porter un écran facial pour protéger le visage et les yeux.
- Affûter l'électrode au tungstène uniquement à la meuleuse dotée de protecteurs. Cette manœuvre est à exécuter dans un endroit sûr lorsque l'on porte l'équipement homologué de protection du visage, des mains et du corps.
- Les étincelles risquent de causer un incendie – éloigner toute substance inflammable.



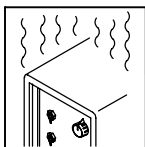
### DES ORGANES MOBILES peuvent provoquer des blessures.

- Ne pas s'approcher des organes mobiles.
- Ne pas s'approcher des points de coincement tels que des rouleaux de commande.



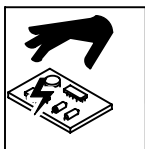
### LES FILS DE SOUDAGE peuvent provoquer des blessures.

- Ne pas appuyer sur la gâchette avant d'en avoir reçu l'instruction.
- Ne pas diriger le pistolet vers soi, d'autres personnes ou toute pièce mécanique en engageant le fil de soudage.



### L'EMPLOI EXCESSIF peut SURCHAUFFER L'ÉQUIPEMENT.

- Laisser l'équipement refroidir ; respecter le facteur de marche nominal.
- Réduire le courant ou le facteur de marche avant de poursuivre le soudage.
- Ne pas obstruer les passages d'air du poste.



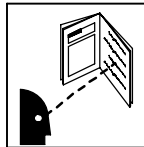
### LES CHARGES ÉLECTROSTATIQUES peuvent endommager les circuits imprimés.

- Établir la connexion avec la barrette de terre avant de manipuler des cartes ou des pièces.
- Utiliser des pochettes et des boîtes antistatiques pour stocker, déplacer ou expédier des cartes de circuits imprimés.



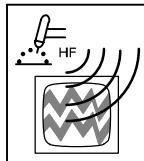
### UNE REMORQUE QUI BASCULE peut entraîner des blessures.

- Utiliser les supports de la remorque ou des blocs pour soutenir le poids.
- Installer convenablement le poste sur la remorque comme indiqué dans le manuel s'y rapportant.



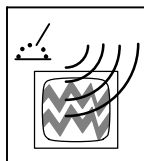
### LIRE LES INSTRUCTIONS.

- Lisez le manuel d'instructions avant l'utilisation ou la maintenance de l'appareil.
- N'utiliser que les pièces de rechange recommandées par le constructeur.
- Effectuer la maintenance et le service du moteur et du compresseur d'air suivant les instructions dans ce manuel ou le manuel du moteur/compresseur (si applicable).



### LE RAYONNEMENT HAUTE FRÉQUENCE (H.F.) risque de provoquer des interférences.

- Le rayonnement haute fréquence (H.F.) peut provoquer des interférences avec les équipements de radio-navigation et de communication, les services de sécurité et les ordinateurs.
- Demander seulement à des personnes qualifiées familiarisées avec des équipements électroniques de faire fonctionner l'installation.
- L'utilisateur est tenu de faire corriger rapidement par un électricien qualifié les interférences résultant de l'installation.
- Si le FCC signale des interférences, arrêter immédiatement l'appareil.
- Effectuer régulièrement le contrôle et l'entretien de l'installation.
- Maintenir soigneusement fermés les portes et les panneaux des sources de haute fréquence, maintenir les éclateurs à une distance correcte et utiliser une terre et un blindage pour réduire les interférences éventuelles.



### LE SOUDAGE À L'ARC risque de provoquer des interférences.

- L'énergie électromagnétique risque de provoquer des interférences pour l'équipement électronique sensible tel que les ordinateurs et l'équipement commandé par ordinateur tel que les robots.
- Veiller à ce que tout l'équipement de la zone de soudage soit compatible électromagnétiquement.
- Pour réduire la possibilité d'interférence, maintenir les câbles de soudage aussi courts que possible, les grouper, et les poser aussi bas que possible (ex. par terre).
- Veiller à souder à une distance de 100 mètres de tout équipement électronique sensible.
- Veiller à ce que ce poste de soudage soit posé et mis à la terre conformément à ce mode d'emploi.
- En cas d'interférences après avoir pris les mesures précédentes, il incombe à l'utilisateur de prendre des mesures supplémentaires telles que le déplacement du poste, l'utilisation de câbles blindés, l'utilisation de filtres de ligne ou la pose de protecteurs dans la zone de travail.

## 2-6. Proposition californienne 65 Avertissements

**!** Les équipements de soudage et de coupage produisent des fumées et des gaz qui contiennent des produits chimiques dont l'État de Californie reconnaît qu'ils provoquent des malformations congénitales et, dans certains cas, des cancers. (Code de santé et de sécurité de Californie, chapitre 25249.5 et suivants)

**!** Les batteries, les bornes et autres accessoires contiennent du plomb et des composés à base de plomb, produits chimiques dont l'État de Californie reconnaît qu'ils provoquent des cancers et des malformations congénitales ou autres problèmes de procréation. Se laver les mains après manipulation.

Pour les moteurs à essence :

**!** Les gaz d'échappement des moteurs contiennent des produits chimiques dont l'État de Californie reconnaît qu'ils provoquent des cancers et des malformations congénitales ou autres problèmes de procréation.

Pour les moteurs diesel :

**!** Les gaz d'échappement des moteurs diesel et certains de leurs composants sont reconnus par l'État de Californie comme provoquant des cancers et des malformations congénitales ou autres problèmes de procréation.

## 2-7. Principales normes de sécurité

*Safety in Welding, Cutting, and Allied Processes*, ANSI Standard Z49.1, de Global Engineering Documents (téléphone : 1-877-413-5184, site Internet : [www.global.ih.com](http://www.global.ih.com)).

*Recommended Safe Practices for the Preparation for Welding and Cutting of Containers and Piping*, American Welding Society Standard AWS F4.1 de Global Engineering Documents (téléphone : 1-877-413-5184, site Internet : [www.global.ih.com](http://www.global.ih.com)).

*National Electrical Code*, NFPA Standard 70, de National Fire Protection Association, P.O. Box 9101, Quincy, MA 02269-9101 (téléphone : 617-770-3000, site Internet : [www.nfpa.org](http://www.nfpa.org)).

*Safe Handling of Compressed Gases in Cylinders*, CGA Pamphlet P-1, de Compressed Gas Association, 4221 Walney Road, 5th Floor, Chantilly, VA 20151 (téléphone : 703-788-2700, site Internet : [www.cganet.com](http://www.cganet.com)).

*Code for Safety in Welding and Cutting*, CSA Standard W117.2, de Canadian Standards Association, 5060 Mississauga, Ontario, Canada

L4W 5NS (téléphone : 800-463-6727 ou à Toronto 416-747-4044, site Internet : [www.csa-international.org](http://www.csa-international.org)).

*Safe Practice For Occupational And Educational Eye And Face Protection*, ANSI Standard Z87.1, de American National Standards Institute, 11 West 43rd Street, New York, NY 10036-8002 (téléphone : 212-642-4900, site Internet : [www.ansi.org](http://www.ansi.org)).

*Standard for Fire Prevention During Welding, Cutting, and Other Hot Work*, NFPA Standard 51B, de National Fire Protection Association, P.O. Box 9101, Quincy, MA 02269-9101 (téléphone : 617-770-3000, site Internet : [www.nfpa.org](http://www.nfpa.org)).

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910, Subpart Q, and Part 1926, Subpart J, de U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250-7954 (téléphone : 1-866-512-1800) (il y a 10 bureaux régionaux--le téléphone de la région 5, Chicago, est 312-353-2220, site Internet : [www.osha.gov](http://www.osha.gov)).

## 2-8. Information EMF

Considérations sur le soudage et les effets de basse fréquence et des champs magnétiques et électriques.

Le courant de soudage, pendant son passage dans les câbles de soudage, causera des champs électromagnétiques. Il y a eu et il y a encore un certain souci à propos de tels champs. Cependant, après avoir examiné plus de 500 études qui ont été faites pendant une période de recherche de 17 ans, un comité spécial ruban bleu du National Research Council a conclu : « L'accumulation de preuves, suivant le jugement du comité, n'a pas démontré que l'exposition aux champs magnétiques et champs électriques à haute fréquence représente un risque à la santé humaine ». Toutefois, des études sont toujours en cours et les preuves continuent à être examinées. En attendant que les conclusions finales de la recherche soient établies, il vous serait souhaitable de réduire votre exposition aux champs électromagnétiques pendant le soudage ou le coupage.

Pour réduire les champs magnétiques sur le poste de travail, appliquer les procédures suivantes :






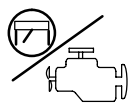






1. Garder les câbles ensemble, les torsader, les scotcher, ou les recouvrir d'une housse.
2. Disposer les câbles d'un côté et à distance de l'opérateur.
3. Ne pas courber pas et ne pas entourer pas les câbles autour de votre corps.
4. Garder le poste de soudage et les câbles le plus loin possible de vous.
5. Connecter la pince sur la pièce aussi près que possible de la soudure.

**Des implants médicaux :**

Les porteurs d'implants doivent d'abord consulter leur médecin avant de s'approcher des opérations de soudage à l'arc, de soudage par points, de gougeage, du coupage plasma ou de chauffage par induction. Si le médecin approuve, il est recommandé de suivre les procédures précédentes.

## SECTION 3 – DEFINITIONS

### 3-1. Symbol Definitions

	Engine Choke		Read Operator's Manual	<b>A</b>	Amperes	<b>V</b>	Volts
	Engine Oil		Fuel		Battery (Engine)		Engine
<b>+</b>	Positive	<b>—</b>	Negative		Alternating Current (AC)		Output
<b>h</b>	Hours	<b>s</b>	Seconds		Time		Protective Earth (Ground)
	Circuit Protector		Temperature				

## SECTION 4 – SPECIFICATIONS

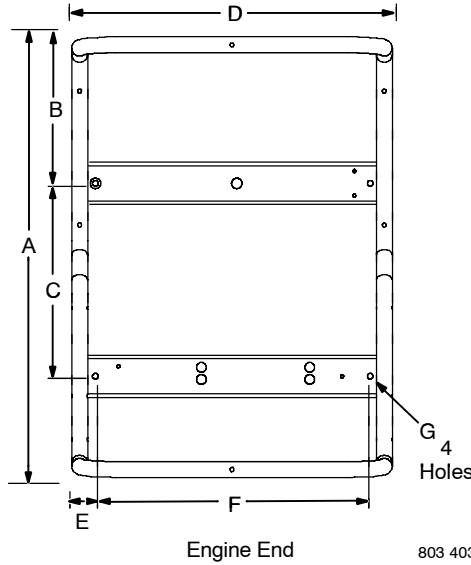
### 4-1. Weld, Power, And Engine Specifications

Welding Mode	Weld Output Range	Rated Welding Output	Maximum Open Circuit Voltage	Generator Power Rating	Fuel Capacity	Engine
CC/DC	55 – 185 A	185 A, 25 V, 20% Duty Cycle 130 A, 25 V, 60% Duty Cycle 100 A, 25 V 100% Duty Cycle	80	Single-Phase, 6 kVA/kW (Peak) 5.5 kVA/kW (Continuous) 40/23 A, 120/240 V AC, 60 Hz	Standard Model: 1.7 gal (6.9 L) Tank  DX Model: 5 gal (19 L) Tank	Standard Model: Honda GX390 Air-Cooled, One-Cylinder, Four-Cycle, 13 HP (390 CC), Gasoline Engine (Recoil-Start)  DX Model: Kohler CS12.75 Air-Cooled, One-Cylinder, Four-Cycle, 12.75 HP (360 CC), Gasoline Engine (Electric-Start)

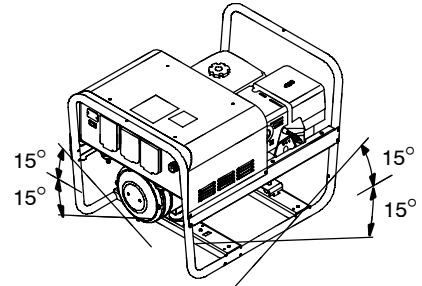


### 4-2. Dimensions, Weights, And Operating Angles

Dimensions	
Height	22-3/4 in (578 mm)
Width	22-3/4 in (577 mm)
Depth	31-5/8 in (803 mm)
A	31-5/8 in (803 mm)
B	10-9/16 in (268 mm)
C	13-25/64 in (340 mm)
D	22-3/4 in (577 mm)
E	1-9/16 in (40 mm)
F	19-5/8 in (498 mm)
G	13/32 in (10 mm) Dia.
Weight	
DX Model: 315 lb (143 kg)	
Standard Model: 267 lb (121 kg)	
Optional Lifting Eye Weight Rating	
430 lb (195 kg)	

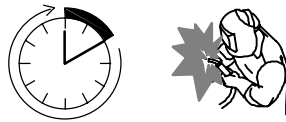


- ⚠ Do not move or operate unit where it could tip.
- ⚠ Do not exceed tilt angles or engine could be damaged or unit could tip.



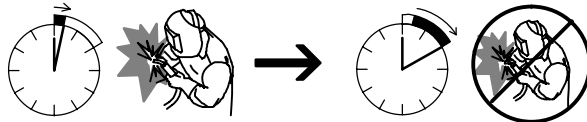
803 597-B

### 4-3. Duty Cycle



Continuous Welding

100% Duty Cycle at 100 Amperes CC/DC



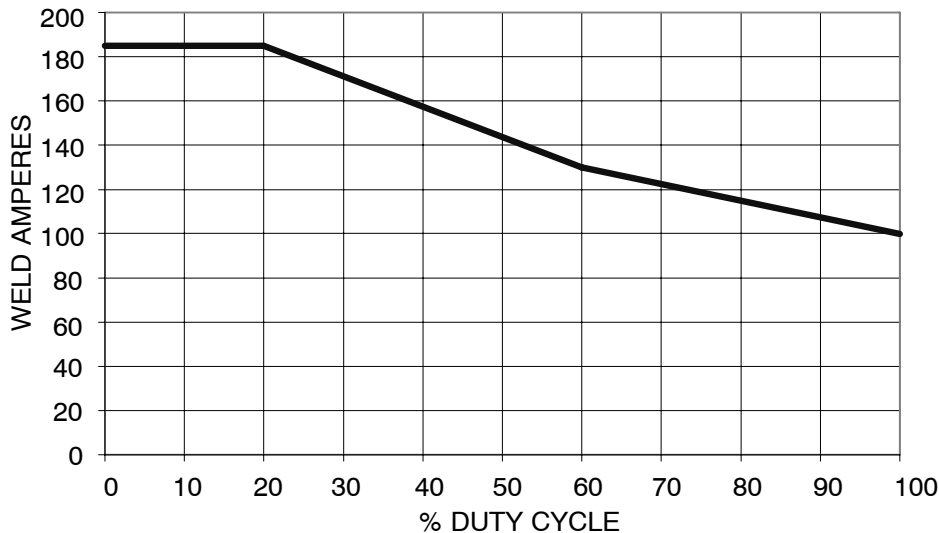
2 Minutes Welding

8 Minutes Resting

20% Duty Cycle at 185 Amperes CC/DC

Duty cycle is the percentage of 10 minutes that unit can weld at rated load without overheating.

**NOTICE** - Exceeding duty cycle can damage unit and void warranty.

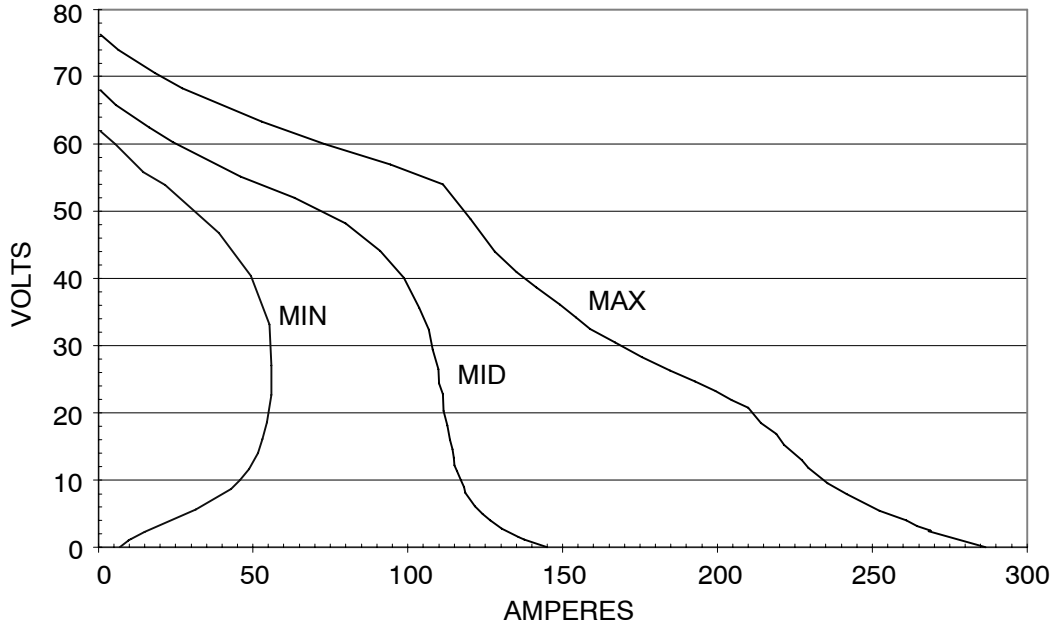


220 626-A

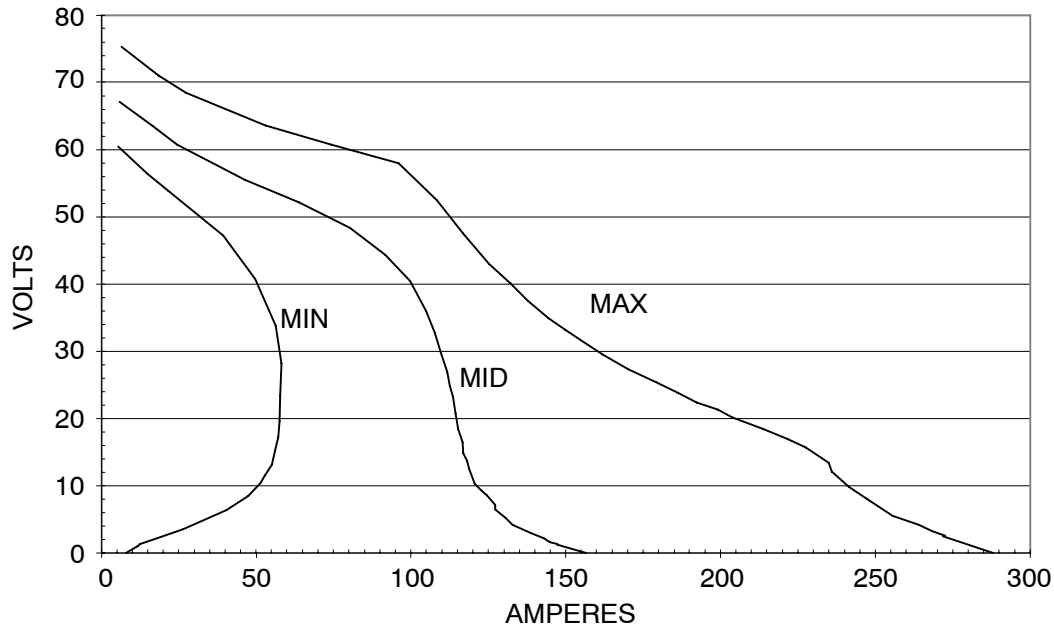
## 4-4. Volt-Ampere Curves

The volt-ampere curve shows the minimum and maximum voltage and amperage output capabilities of the welding generator. Curves of all other settings fall between the curves shown.

**A. Standard Model (Honda Engine)**



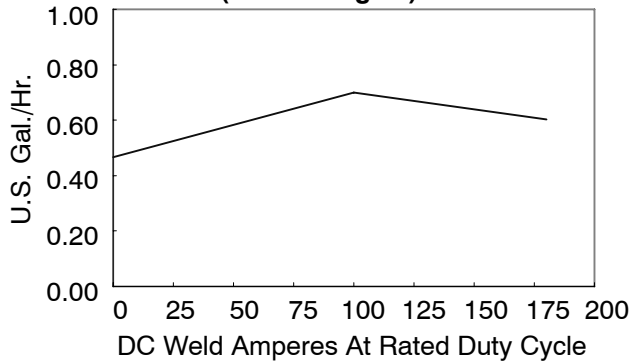
**B. DX Model (Kohler Engine)**



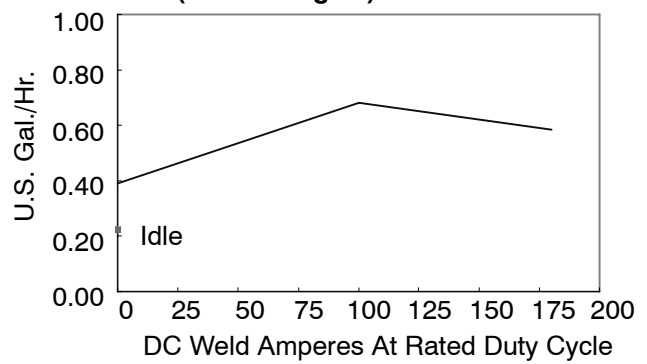
220 603-A / 220 605-A

### 4-5. Fuel Consumption Curves

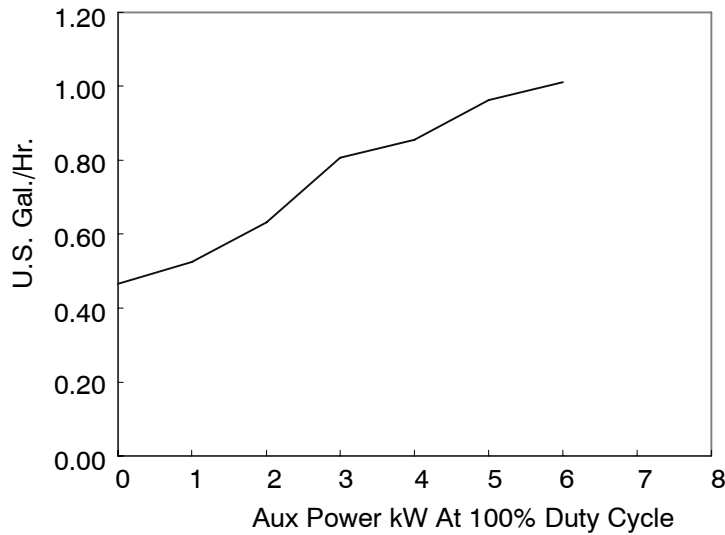
**A. Weld Output Standard Model (Honda Engine)**



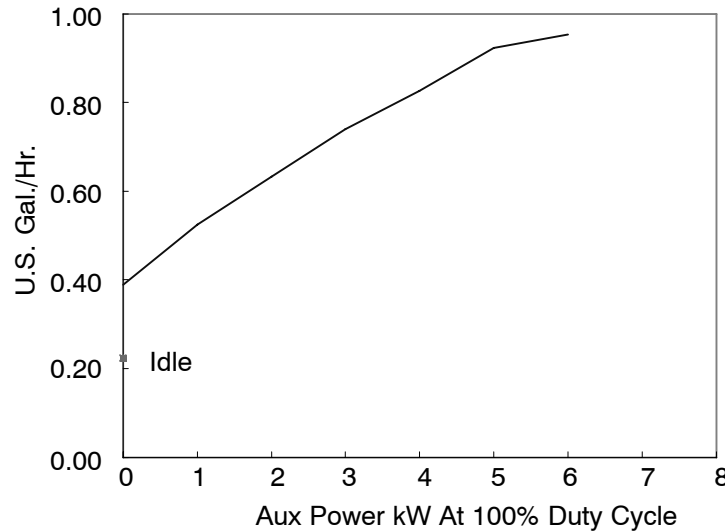
**B. Weld Output DX Model (Kohler Engine)**



**C. Auxiliary Power Standard Model (Honda Engine)**



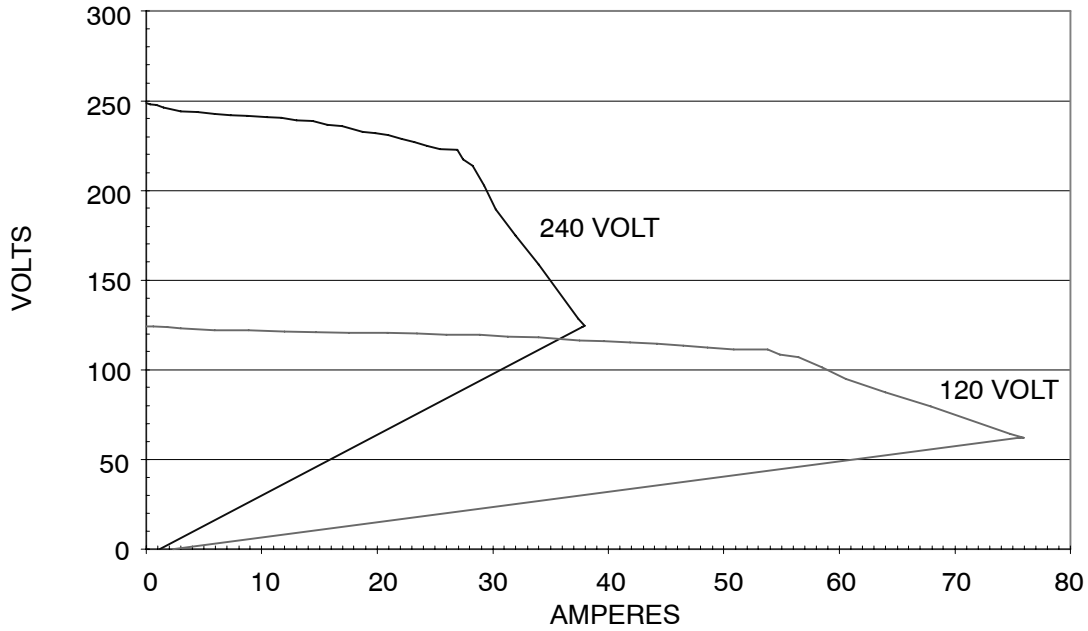
**D. Auxiliary Power DX Model (Kohler Engine)**



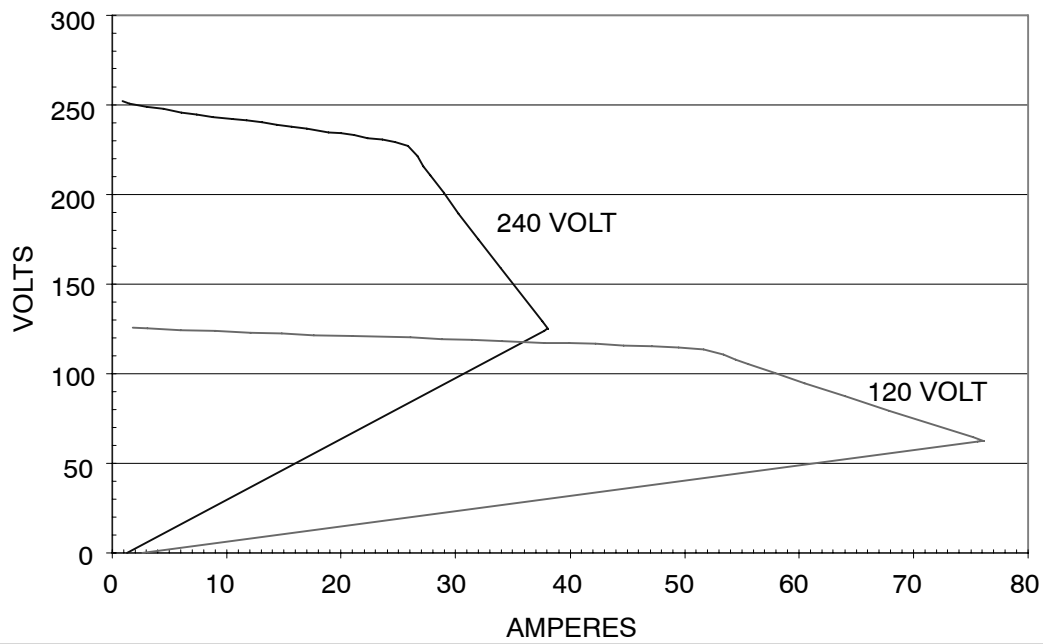
### 4-6. Generator Power Curves

The ac generator power curves show the generator power available in amperes at the receptacles.

**A. Power Output Standard Model (Honda Engine)**



**B. Power Output DX Model (Kohler Engine)**



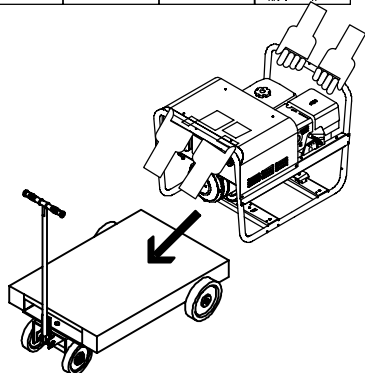
220 589-A / 220 594-A

# SECTION 5 – INSTALLATION

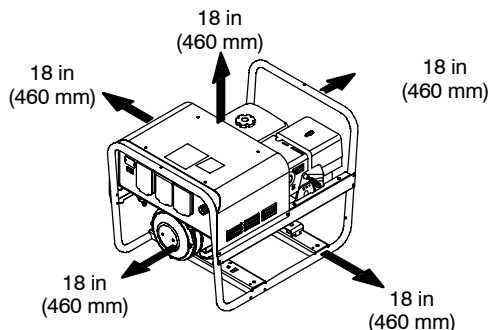
## 5-1. Installing Welding Generator



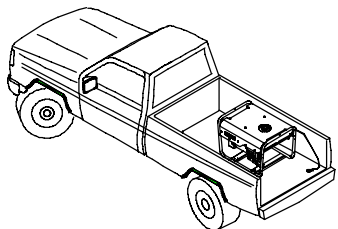
**Movement**



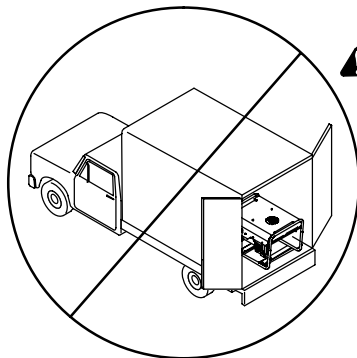
**Airflow Clearance**



**Location**



OR

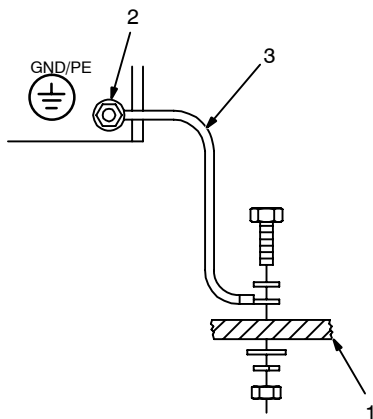


**⚠ Do not install unit where air flow is restricted or engine may overheat.**

**⚠ Always securely fasten welding generator onto transport vehicle or trailer and comply with all DOT and other applicable codes**

**⚠ Always ground generator frame to vehicle frame to prevent electric shock and static electricity hazards.**

- 1 Metal Vehicle Frame
- 2 Equipment Grounding Terminal
- 3 Grounding Cable




**⚠ Bed liners, shipping skids, and some running gear insulate the welding generator from the vehicle frame. Always connect a ground wire from the generator equipment grounding terminal to bare metal on the vehicle frame as shown.**

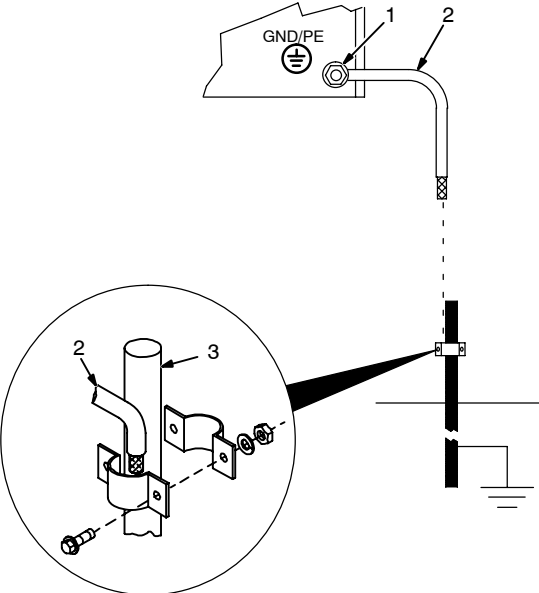
Use #10 AWG or larger insulated copper wire to make metal-to-metal grounding connection.

**⚠ If unit does not have GFCI receptacles, use GFCI-protected extension cord.**

Ref 151 556 / Ref. 800 652 / 803 597-B / S-0854

### 5-2. Grounding Generator When Supplying Building Systems





**⚠ Ground generator to system earth ground if supplying power to a premises (home, shop, farm) wiring system.**

- 1 Equipment Grounding Terminal
- 2 Grounding Cable


Use #10 AWG or larger insulated copper wire.

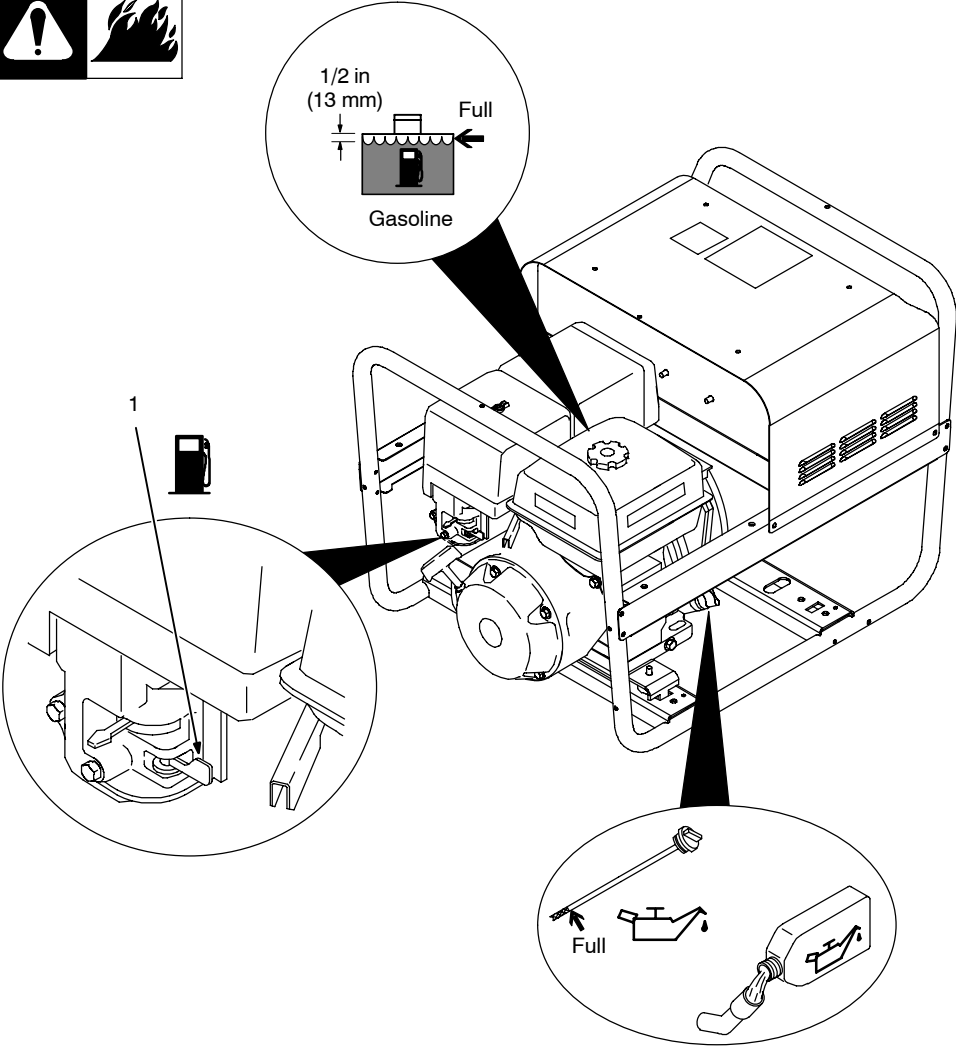
- 3 Ground Device

*Use ground device as stated in electrical codes.*

800 576-B

### 5-3. Engine Prestart Checks – Standard Model





Check all fluids daily. Engine must be cold and on a level surface. Unit is shipped with 10W30 engine oil.

- 1 Fuel Valve

Open valve.

*Fuel valve is shown in the open position. Always close fuel valve after stopping unit. Moving unit with fuel valve open may cause carburetor flooding and make starting difficult.*

**Fuel**

Add fresh fuel before starting engine the first time (see engine manual for specifications). Fill fuel tank up to 1/2 in. (13 mm) from top to allow room for expansion. Check fuel level on a cold engine before use each day.

**Oil**

After fueling, check oil with unit on level surface. If oil is not up to full mark on dipstick, add oil (see engine manual).

Unit stops if oil level is too low. Unit cannot be restarted until sufficient oil is added.

Ref. 803 597-B / Ref. 802 099

## 5-4. Engine Prestart Checks – DX Model

1/2 in (13 mm) Full  
Gasoline

1

*☞ Fuel valve is shown in the open position. Always close fuel valve after stopping unit. Moving unit with fuel valve open may cause carburetor flooding and make starting difficult.*

*☞ To improve cold weather starting:*

*Keep battery in good condition. Store battery in warm area off concrete surface.*

*Use correct grade oil for cold weather.*

Check all fluids daily. Engine must be cold and on a level surface. Unit is shipped with 10W30 engine oil.

**1 Fuel Valve**  
Open valve.

*☞ Close fuel valve before moving unit or carburetor may flood and make starting difficult.*

**Fuel**  
Add fresh fuel before starting engine the first time (see engine manual for specifications). Fill fuel tank up to 1/2 in. (13 mm) from top to allow room for expansion. Check fuel level on a cold engine before use each day.

**Oil**  
After fueling, check oil with unit on level surface. If oil is not up to full mark on dipstick, add oil (see engine manual).  
Unit stops if oil level is too low. Unit cannot be restarted until sufficient oil is added.

803 595-B

## 5-5. Connecting The Battery (DX Models Only)

**☹ Turn Engine Switch to Off (DX models only).**

**☹ Connect negative (-) cable last.**

**Tools Needed:**

1/2 in

803 596-B / 803 466

### 5-6. Connecting To Weld Output Terminals

Correct Installation                      Incorrect Installation

- 1 Positive (+) Weld Output Terminal
- 2 Negative (-) Weld Output Terminal

For Direct Current Electrode Positive (DCEP), connect work cable to Negative (-) terminal and electrode holder to Positive (+) terminal.

For Direct Current Electrode negative (DCEN), reverse cable connections.

**⚠ Failure to properly connect weld cables may cause excessive heat and start a fire, or damage your machine.**

- 3 Weld Output Terminal
- 4 Supplied Weld Output Terminal Nut
- 5 Weld Cable Terminal
- 6 Copper Bar

Remove supplied nut from weld output terminal. Slide weld cable terminal onto weld output terminal and secure with nut so that weld cable terminal is tight against copper bar. **Do not place anything between weld cable terminal and copper bar. Make sure that the surfaces of the weld cable terminal and copper bar are clean.**

Tools Needed:  
 3/4 in

803 596-B / 803 778-A

### 5-7. Selecting Weld Cable Sizes\*

 Weld Output Terminals ⚠ Stop engine before connecting to weld output terminals. ⚠ Do not use worn, damaged, undersized, or poorly spliced cables.	Weld Cable Size** and Total Cable (Copper) Length in Weld Circuit Not Exceeding***								
	Welding Amperes	100 ft (30 m) or Less		150 ft (45 m)	200 ft (60 m)	250 ft (70 m)	300 ft (90 m)	350 ft (105 m)	400 ft (120 m)
		10 – 60% Duty Cycle	60 – 100% Duty Cycle	10 – 100% Duty Cycle					
100	4 (20)	4 (20)	4 (20)	3 (30)	2 (35)	1 (50)	1/0 (60)	1/0 (60)	
150	3 (30)	3 (30)	2 (35)	1 (50)	1/0 (60)	2/0 (70)	3/0 (95)	3/0 (95)	
200	3 (30)	2 (35)	1 (50)	1/0 (60)	2/0 (70)	3/0 (95)	4/0 (120)	4/0 (120)	
250	2 (35)	1 (50)	1/0 (60)	2/0 (70)	3/0 (95)	4/0 (120)	2 ea. 2/0 (2x70)	2 ea. 2/0 (2x70)	
300	1 (50)	1/0 (60)	2/0 (70)	3/0 (95)	4/0 (120)	2 ea. 2/0 (2x70)	2 ea. 3/0 (2x95)	2 ea. 3/0 (2x95)	

\* This chart is a general guideline and may not suit all applications. If cables overheat, use next size larger cable.

\*\*Weld cable size (AWG) is based on either a 4 volts or less drop or a current density of at least 300 circular mils per ampere. ( ) = mm<sup>2</sup> for metric use

S-0007-F

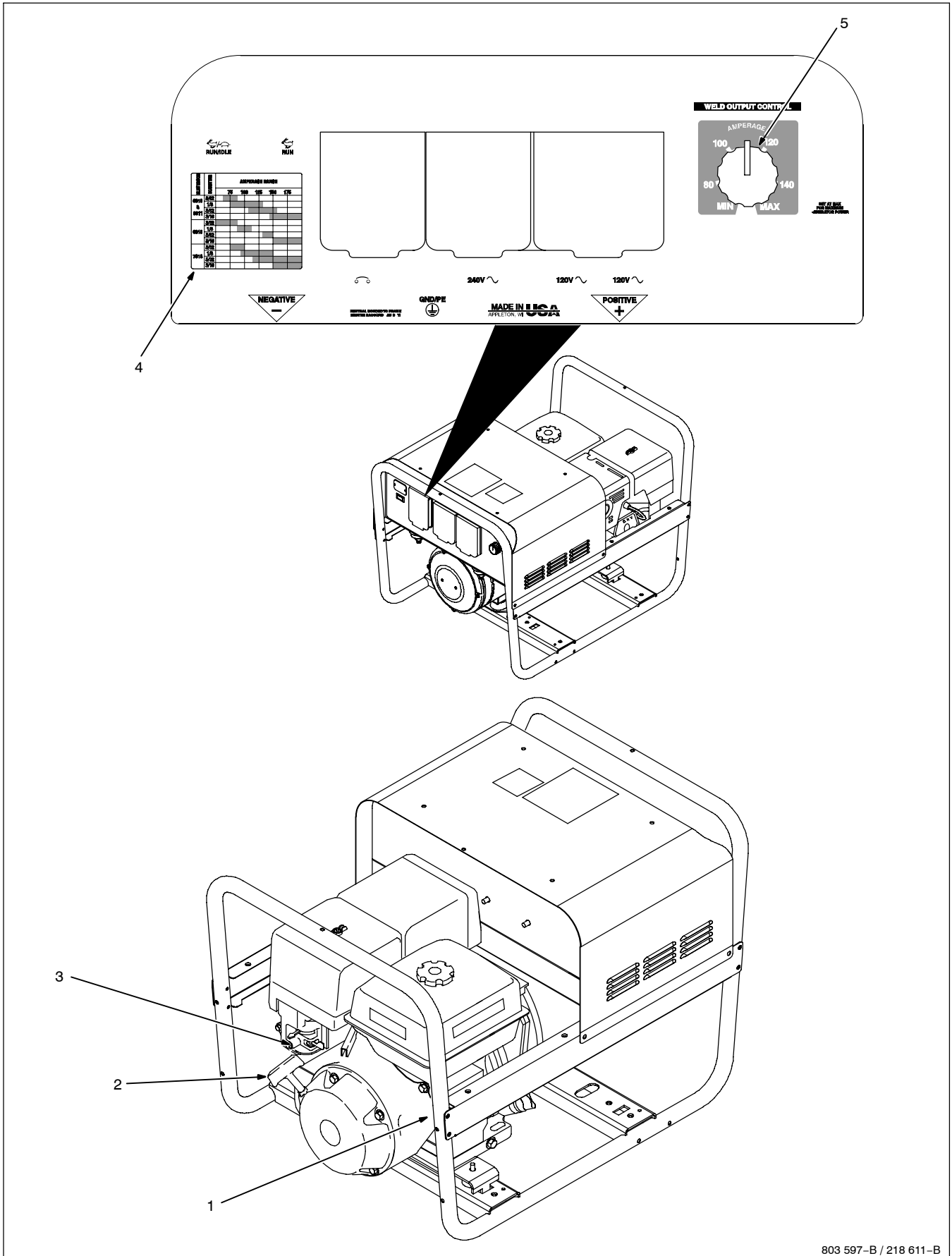
\*\*\*For distances longer than those shown in this guide, call a factory applications representative at 920-735-4505.





# SECTION 6 – OPERATING THE WELDING GENERATOR

## 6-1. Controls (Standard Models) (See Section 6-2)



### 6-2. Description Of Controls (Standard Models) (See Section 6-1)



#### 1 Engine Switch

Use switch to control ignition circuit. Turn switch to On position when starting engine. Turn switch to Off position to stop engine. Engine cannot be started with switch in the Off position.

Engine stops if oil level is too low. Engine cannot be restarted until sufficient oil is added.

#### 2 Starter Handle

#### 3 Choke Control

Use control to change engine air/fuel mix. Move control to far right if starting a cold engine. Move control to far left if starting a warm engine.

#### To Start:

- Open fuel valve (see Section 5-3).
- Turn Engine switch to On.

- Set choke.
- Pull starter handle. Open choke as engine warms.

**⚠ If the engine does not start, let engine come to a complete stop before attempting restart.**

#### To Stop:

- Turn Engine switch to Off.

*Always close fuel valve after stopping unit. Moving unit with fuel valve open may cause carburetor flooding and make starting difficult.*

#### 4 Welding Range Table

Use table to determine correct weld amperage based on electrode size, type, and material thickness.

#### 5 Weld Output Control

*Set control at maximum for full generator power output at AC receptacles*

Use control to select weld amperage. Control may be adjusted while welding.

**To Set Weld Output Control:** Use table to determine correct size electrode for weld amperage. Select electrode type and set control to corresponding amperage range on nameplate. Adjust control to obtain desired weld performance.

#### EXAMPLE:

Electrode Diameter: 1/8

Electrode Type: E-6013

Current Control Setting: 90 – 120 A

# Notes

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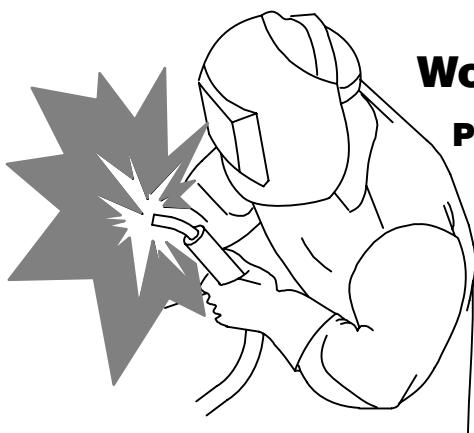
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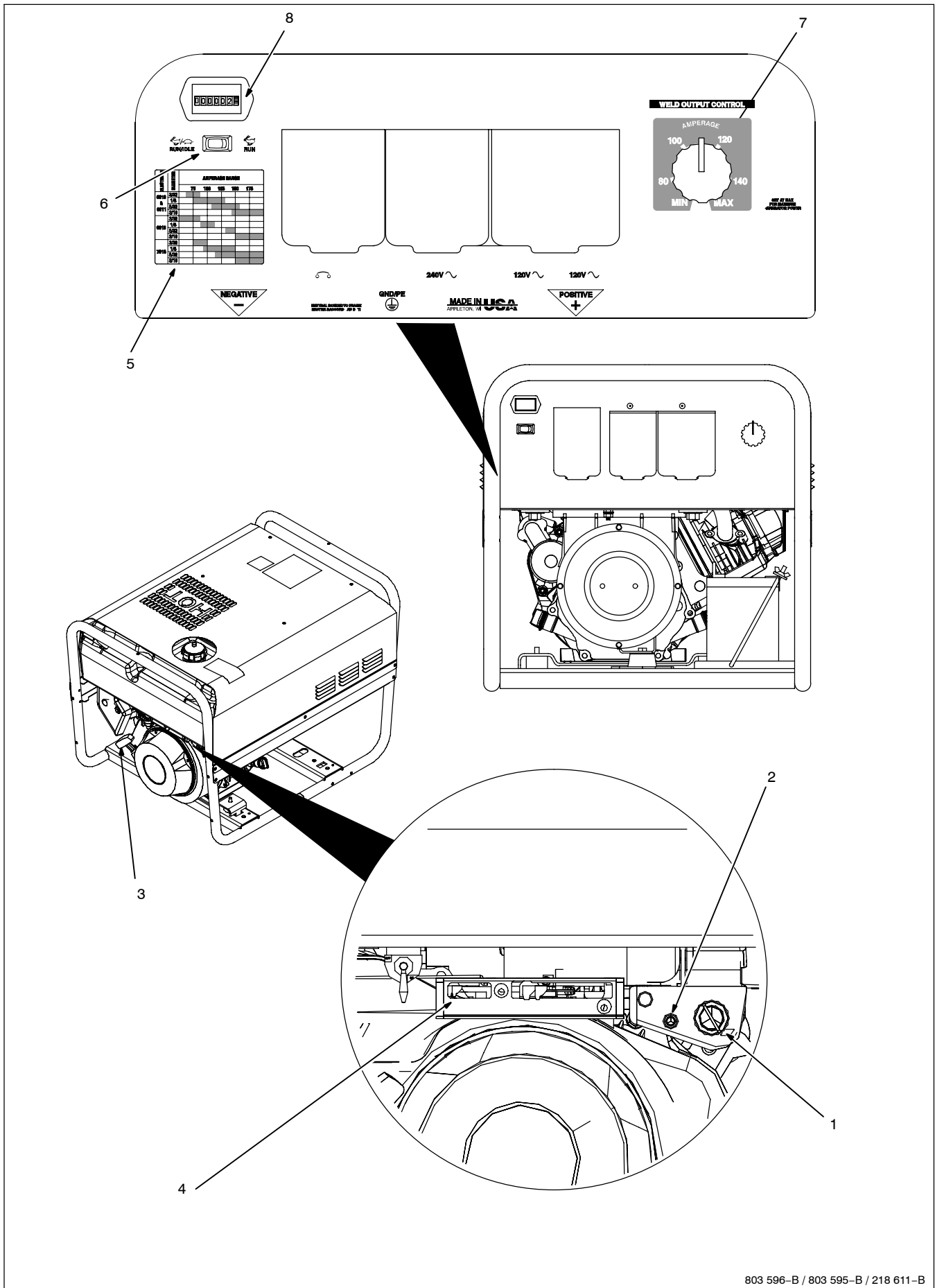


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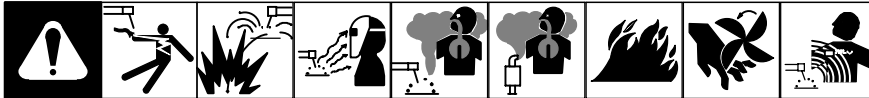
**Work like a Pro!**  
Pros weld and cut safely. Read the safety rules at the beginning of this manual.

### 6-3. Controls (DX Models) (See Section 6-4)



803 596-B / 803 595-B / 218 611-B

## 6-4. Description Of Controls (DX Models) (See Section 6-3)



### 1 Engine Switch

Use switch to control ignition circuit. Turn switch to Start position for electric start. Turn switch to On position to start engine using starter handle (recoil). Turn switch to Off position to stop engine.

### 2 Low Oil Level Light

Light goes on and engine stops if engine oil level is too low.

Engine cannot be restarted until sufficient oil is added.

**⚠ Stop engine and add oil if light goes on (see Section 5-4).**

### 3 Starter Handle

Use starter handle to start unit if electric start does not work.

### 4 Choke Control

Use control to change engine air/fuel mix. Move control to far right if starting a cold engine. Move control to far left if starting a warm engine.

The engine starts at weld/power speed and runs at weld/power speed under weld or generator power load. The engine returns to idle speed 12 seconds after start-up or after weld or generator power load is removed.

### To Start:

- Open fuel valve (see Section 5-4).
- Set choke.
- Electric-Start: Turn Engine switch to Start position.  
Recoil: Turn Engine switch to On position. Pull starter handle until engine starts.
- Open choke as engine warms.

**⚠ If the engine does not start, let engine come to a complete stop before attempting restart.**

### To Stop:

- Turn Engine switch to Off.

*✎ Always close fuel valve after stopping unit. Moving unit with fuel valve open may cause carburetor flooding and make starting difficult.*

### 5 Welding Range Table

Use table to determine correct weld amperage based on electrode size, type, and material thickness.

### 6 Run / Idle Switch

Use switch to select whether the engine stays at run speed continuously or whether the auto idle feature is enabled so engine speed returns to idle speed after start-up or after weld or generator load is removed.

### 7 Weld Output Control

*✎* Set control at maximum for full generator power output at AC receptacles.

Use control to select weld amperage. Control may be adjusted while welding.

**To Set Weld Output Control:** Use table to determine correct size electrode for weld amperage. Select electrode type and set control to corresponding amperage range on nameplate. Adjust control to obtain desired weld performance.

### EXAMPLE:

Electrode Diameter: 1/8

Electrode Type: E-6013

Current Control Setting: 90 – 120 A

### 8 Hourmeter

Use hourmeter to help schedule routine maintenance.

## Notes

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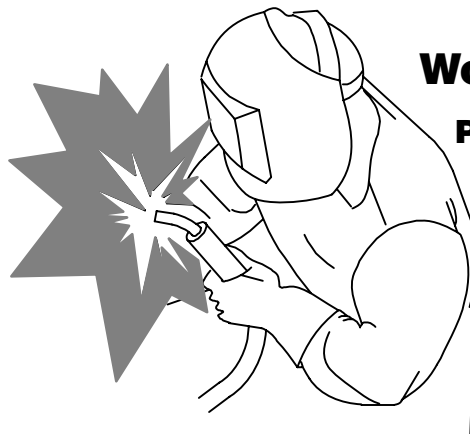
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**Work like a Pro!**  
**Pros weld and cut safely. Read the safety rules at the beginning of this manual.**


# SECTION 7 – OPERATING AUXILIARY EQUIPMENT

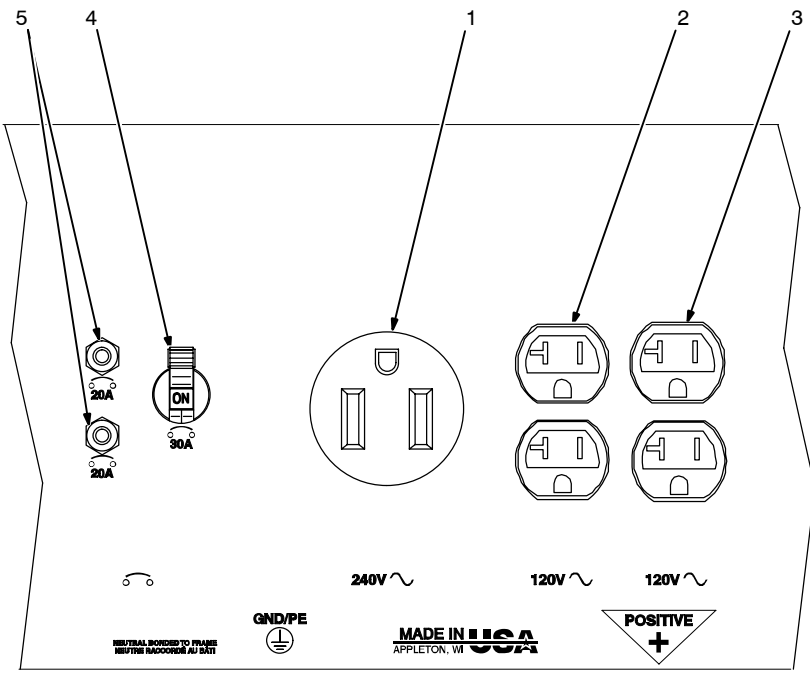
## 7-1. Generator Power Panel Receptacles











218 611-B

**⚠ If unit does not have GFCI receptacles, use GFCI-protected extension cord.**

*Generator power decreases as weld current increases. Set Weld Output control to maximum for full generator power output at AC receptacles.*

1 240 V AC Receptacle RC1  
RC1 supplies 60 Hz single-phase power at weld/power speed. Maximum output is 6 kVA/kW (peak) or 5.5 kVA/kW (continuous).

2 120 V 20 A AC Duplex Receptacle RC2

3 120 V 20 A AC Duplex Receptacle RC3  
RC2 and RC3 supply 60 Hz single-phase power at weld/power speed. Maximum output from RC2 or RC3 is 2.4 kVA/kW.  
**NOTICE** – Do not parallel the two 120V duplex receptacles.

4 Supplementary Protector CB1  
CB1 protects the receptacles from overload. If CB1 opens, the receptacles do not work. Move switch to the On position to reset.

5 Supplementary Protectors CB2, CB3  
CB2 protects RC2 and CB3 protects RC3 from overload. If the supplementary pro-

tor opens, the receptacle does not work. Press button to reset.

*If supplementary protector continues to open, contact Factory Authorized Service Agent.*

Combined output of all receptacles limited to 5.5 kVA/kW continuous rating of the generator (See Section 12 – Generator Power Guidelines).

**EXAMPLE:** If 10 A is drawn from each 120 volt duplex receptacle, only 13 A is available from the 240 V receptacle.

$2 \times (120 \text{ V} \times 10 \text{ A}) + (240 \text{ V} \times 13 \text{ A}) = 5.5 \text{ kVA/KW.}$

# SECTION 8 – MAINTENANCE

Follow the storage procedure in the engine owner's manual if the unit will not be used for an extended period.

## 8-1. Routine Maintenance

								Recycle engine fluids.	<b>Stop engine before maintaining.</b> See Engine Manual and Maintenance Label for important start-up, service, and storage information. Service engine more often if used in severe conditions.
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	✓ = Check * To be done by Factory Authorized Service Agent	= Change	= Clean	= Replace	Reference
Every 8 Hours	 ✓ Fuel Level	 ✓ Oil Level		 ● Oil, Fuel Spills	Section 5-3, 5-4
Every 25 Hours	 ● Air Cleaner Precleaner				Section 8-2
Every 50 Hours	 ● Weld Terminals				
Every 100 Hours	 ◇ Oil	 ✓◇ Air Cleaner Element		 ● Cooling System	Engine Manual, Section 8-2
	 ● Battery Terminals (DX Models)	 ✓● Spark Arrestor Screen (Optional on DX Models)		 ✓ Spark Plug Gap	
Every 200 Hours	 ☆ Unreadable Labels				
Every 300 Hours	 ✓ Valve Clearance*				Engine Manual
Every 500 Hours	 ✓☆ Weld Cables	 ✓● Slip Rings*	 ✓☆ Brushes*		Engine Manual

## 8-2. Servicing Air Cleaner



**⚠ Stop engine.**

**NOTICE** – Do not run engine without air cleaner or with dirty element.

- 1 Precleaner
- 2 Paper Element

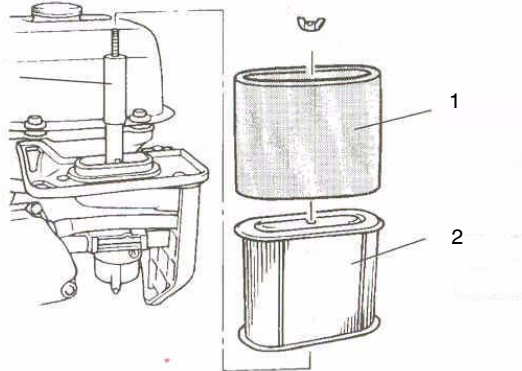
*Do not wash paper element or clean with compressed air.*

Remove cover.

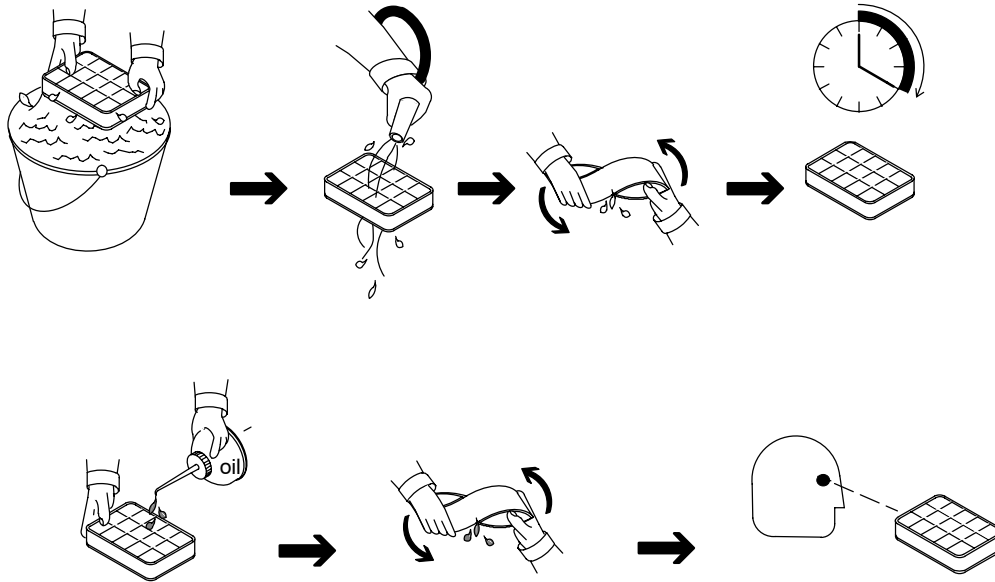
Wash precleaner with soap and water solution. Allow precleaner to air dry completely.

Dip precleaner in clean engine oil. Squeeze out excess oil. The engine will smoke if precleaner contains too much oil.

Replace paper element if dirty, oily, or damaged.



Standard Model Shown



aircleaner6 9/00 – 803 404



### 8-3. Adjusting Engine Speed (Honda-Powered Units)



	1400 ± 150 rpm
	3750 ± 30 rpm (62 Hz)

After tuning engine, check engine speeds. See table for proper no load speeds. If necessary, adjust speeds as follows:

Start engine and run until warm.

#### Weld/Power Speed Adjustment

- 1 Throttle Control Lever
- 2 Adjustment Screw

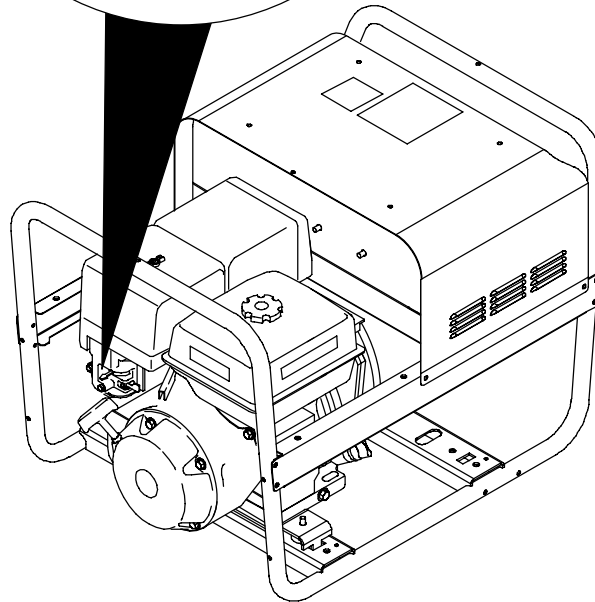
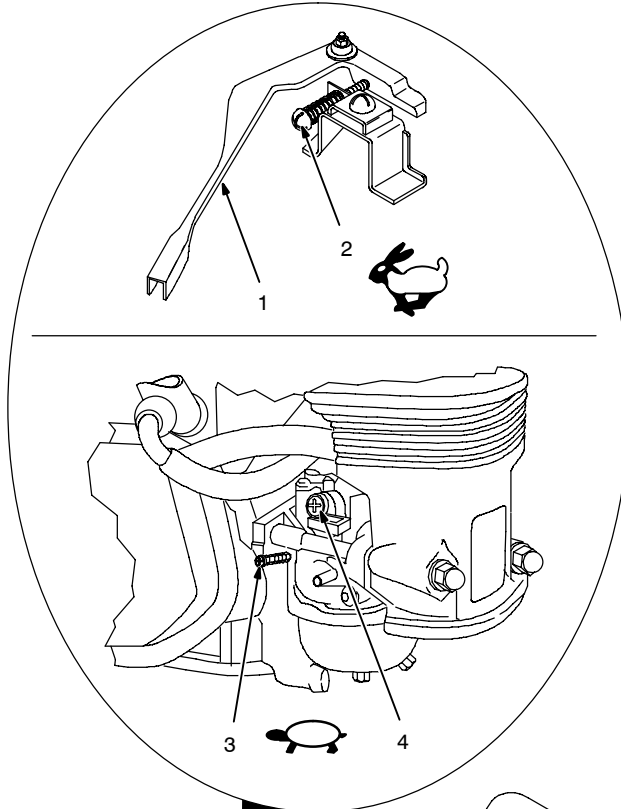
Move lever to Run (far left) position. Turn screw and move lever until engine runs at weld/power speed.

#### Idle Speed Adjustment

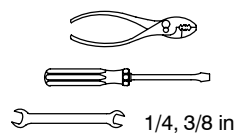
- 3 Pilot Screw
- 4 Throttle Stop Screw

Move lever to idle (far right) position. Turn pilot screw until engine runs at highest idle speed. Turn stop screw until engine runs at rated idle speed (normally about 2-1/4 turns out.)

**⚠ Stop engine. Close fuel valve.**



Tools Needed:



## 8-4. Adjusting Engine Speed (Kohler-Powered Units)



	2500 ± 100 rpm (42 Hz)
	3750 ± 30 rpm (62Hz)

After tuning engine, check engine speed. See table for proper no load speed. If necessary, adjust speed as follows:

Start engine and run until warm.

Set Weld Output Control to Max.

### Weld/Power Speed Adjustment

1 Adjustment Screw

To increase speed, turn screw out (counterclockwise). To decrease speed, turn screw in (clockwise).

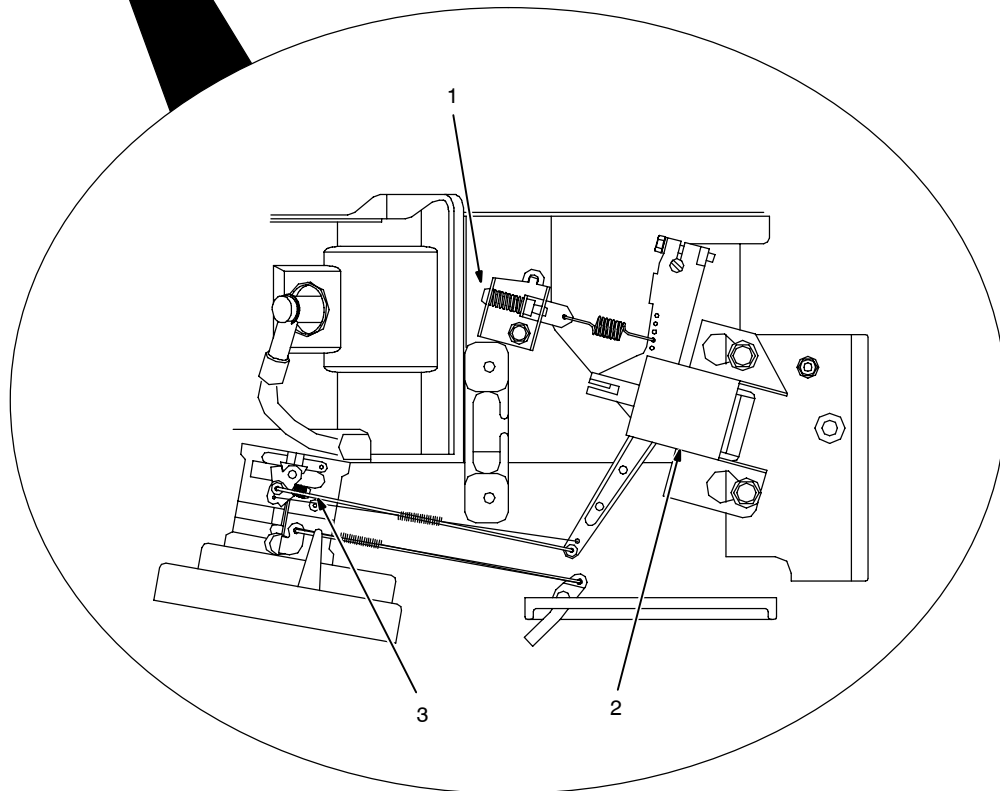
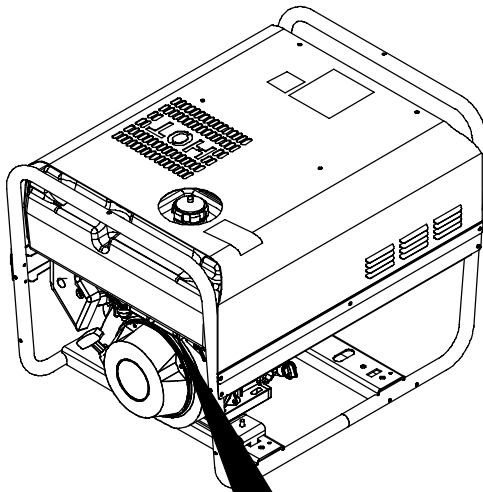
### Idle Speed Adjustment

2 Throttle Solenoid TS1

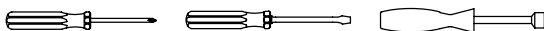
3 Adjustment Screw

Loosen two screws on side of throttle solenoid TS1. Adjust TS1 until idle speed is approximately 2500 rpm. Use adjustment screw to fine tune idle speed. Be sure TS1 plunger bottoms at idle. Tighten two screws on TS1.

**Stop engine. Close fuel valve.**

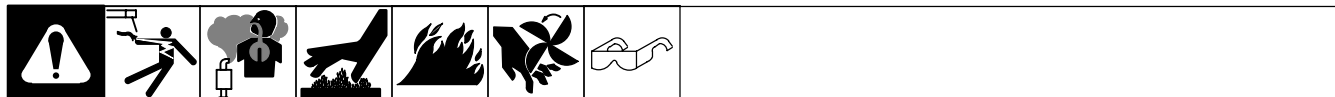


Tools Needed:



# SECTION 9 – TROUBLESHOOTING

## 9-1. Troubleshooting



### A. Welding

Trouble	Remedy
No weld output or generator power output at ac receptacles.	Be sure all equipment is disconnected from receptacles when starting unit.
	Have Factory Authorized Service Agent check brushes, slip rings, rotor, stator, integrated rectifier SR2, and Weld Output control R1.
No weld output; generator power output okay at ac receptacles.	Check Weld Output control setting.
	Check weld connections.
	Have Factory Authorized Service Agent check Weld Output control R1, stator, integrated rectifier SR2, stabilizer DC-Z, main rectifier SR1, and reactor AC-Z
Low weld output.	Check Weld Output control setting.
	Check engine speed, and adjust if necessary (see Section 8-3 or 8-4).
	Service engine air cleaner.
	Check weld cable size and length.
	Have Factory Authorized Service Agent check Weld Output control R1, stator, integrated rectifier SR2, stabilizer DC-Z, main rectifier SR1, and reactor AC-Z
High weld output.	Check Weld Output control setting.
	Check engine speed, and adjust if necessary (see Section 8-3 or 8-4).
Erratic weld output.	Check Weld Output control setting.
	Tighten and clean connections to electrode and workpiece.
	Use dry, properly-stored electrodes for Stick welding.
	Remove excessive coils from weld cables.
	Clean and tighten connections both inside and outside welding generator.
	Check engine speed, and adjust if necessary (see Section 8-3 or 8-4).
	Check throttle/governor linkage for smooth, non-binding operation.

### B. Generator Power

Trouble	Remedy
No output at generator power ac receptacles; no weld output.	Be sure all equipment is disconnected from receptacles when starting unit.
	Have Factory Authorized Service Agent check brushes, slip rings, rotor, stator, integrated rectifier SR2, and Weld Output control R1.
No output at generator power ac receptacles; weld output okay.	Reset and check supplementary protectors (see Section 7-1).
	Check receptacle wiring and connections.
	Have Factory Authorized Service Agent check stator windings and connections at terminal block 1T.
High output at generator power ac receptacles.	Check engine speed, and adjust if necessary (see Section 8-3 or 8-4).

Trouble	Remedy
Low output at generator power ac receptacles.	Check Weld Output control setting.
	Check engine speed, and adjust if necessary (see Section 8-3 or 8-4). Open circuit voltage is reduced as engine speed drops.
Erratic output at generator power ac receptacles.	Check fuel level.
	Have Factory Authorized Service Agent check connections at terminal block 1T.
	Check receptacle supplementary protector(s), wiring, and connections.
	Check throttle linkage for smooth, non-binding operation.
	Service air cleaner according to engine manual.
Check engine speed, and adjust if necessary (see Section 8-3 or 8-4).	

### C. Engine


Trouble	Remedy
Engine will not crank (DX models only).	Reset ignition circuit breaker (see engine manual).
	Check and replace ignition fuse (see engine manual).
	Check battery voltage.
	Check battery connections and tighten if necessary.
	Have Factory Authorized Service Agent check engine ignition circuit.
Engine will not start.	Check fuel level (see Section 5-3 or 5-4).
	Move choke control to correct position (see Section 5-3 or 5-4).
	Open fuel valve (see Section 5-3 or 5-4). Close fuel valve before moving unit or carburetor may flood and make starting difficult.
	Check battery voltage (DX models only).
	Check battery connections and tighten if necessary (DX models only).
	Check oil level (see Section 5-3 or 5-4). Engine stops if oil level is too low. Refill crankcase with proper viscosity oil for operating temperature.
Have Factory Authorized Service Agent check low oil level shutdown switch.	
Engine stopped during normal operation.	Check fuel level (see Section 5-3 or 5-4).
	Open fuel valve (see Section 5-3 or 5-4). Close fuel valve before moving unit or carburetor may flood and make starting difficult.
	Check oil level (see Section 5-3 or 5-4). Engine stops if oil level is too low.
Battery discharges between uses (DX models only).	Clean battery, terminals, and posts with baking soda and water solution; rinse with clear water.
	Periodically recharge battery (approximately every 3 months).
	Replace battery.
	Check engine battery charging circuit and connections according to engine manual.
Unstable or sluggish engine speeds.	Check engine speed, and adjust if necessary (see Section 8-3 or 8-4).
	Check throttle/governor linkage for smooth, non-binding operation.
	Tune-up engine according to engine manual.

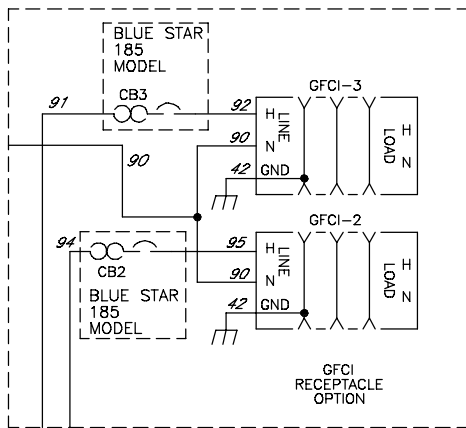
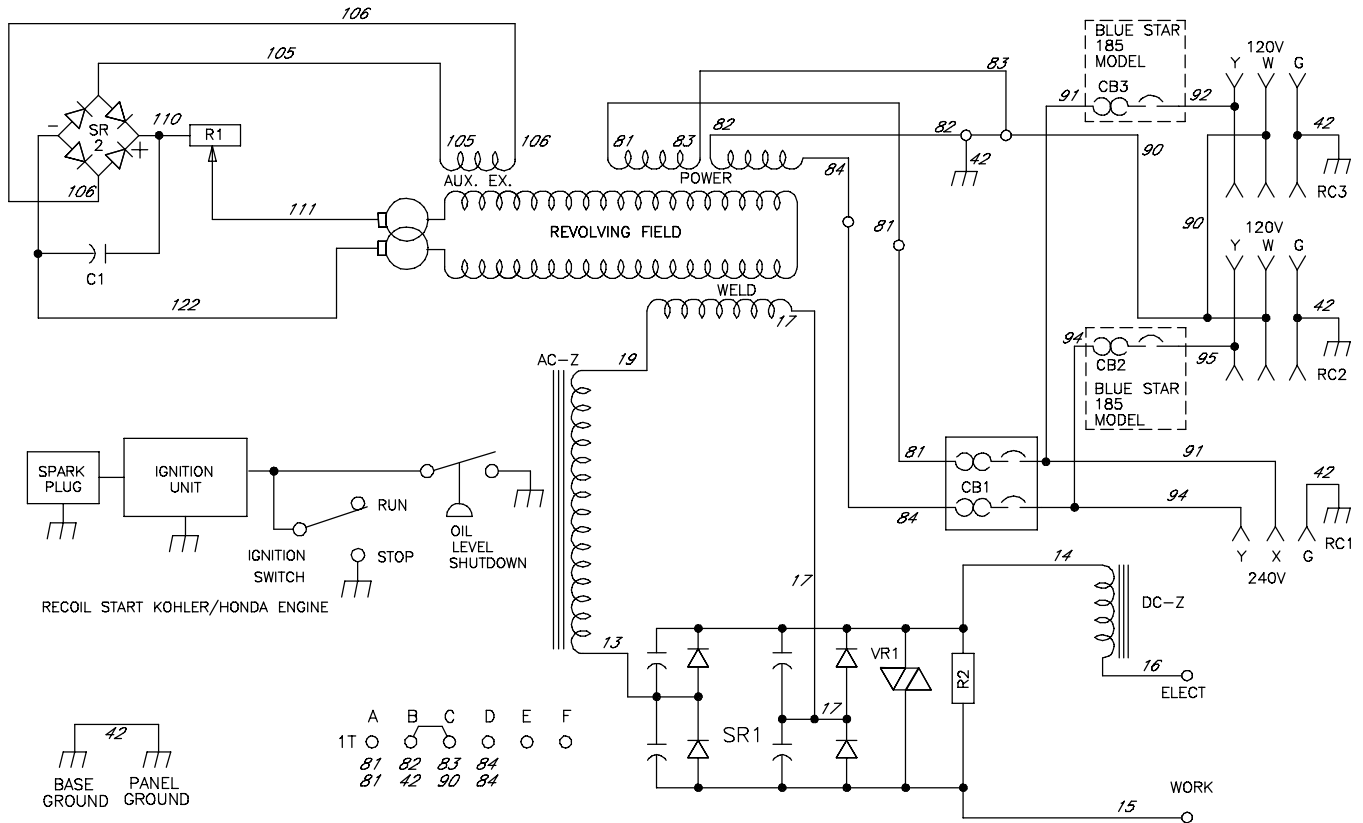
## SECTION 10 – PARTS LIST

### 10-1. Recommended Spare Parts

Dia. Mkgs.	Part No.	Description	Quantity
<b>Recommended Spare Parts</b>			
.....	220305	.. Tune-up & Filter Kit, Honda (includes) .....	
.....	190108	.... Spark Plug .....	1
.....	220303	.... Air Filter .....	1
.....	220304	.... Air Filter, Pre Cleaner .....	1
.....	221584	.. Tune-up & Filter Kit, Kohler CS 10 & 12 Electric (includes) .....	
.....	203960	.... Spark Plug .....	1
.....	221582	.... Filter, Air Kohler CS 10 & 12 Electric .....	1
.....	221583	.... Filter, Air Pre Cleaner Kohler CS 10 & 12 Electric .....	1

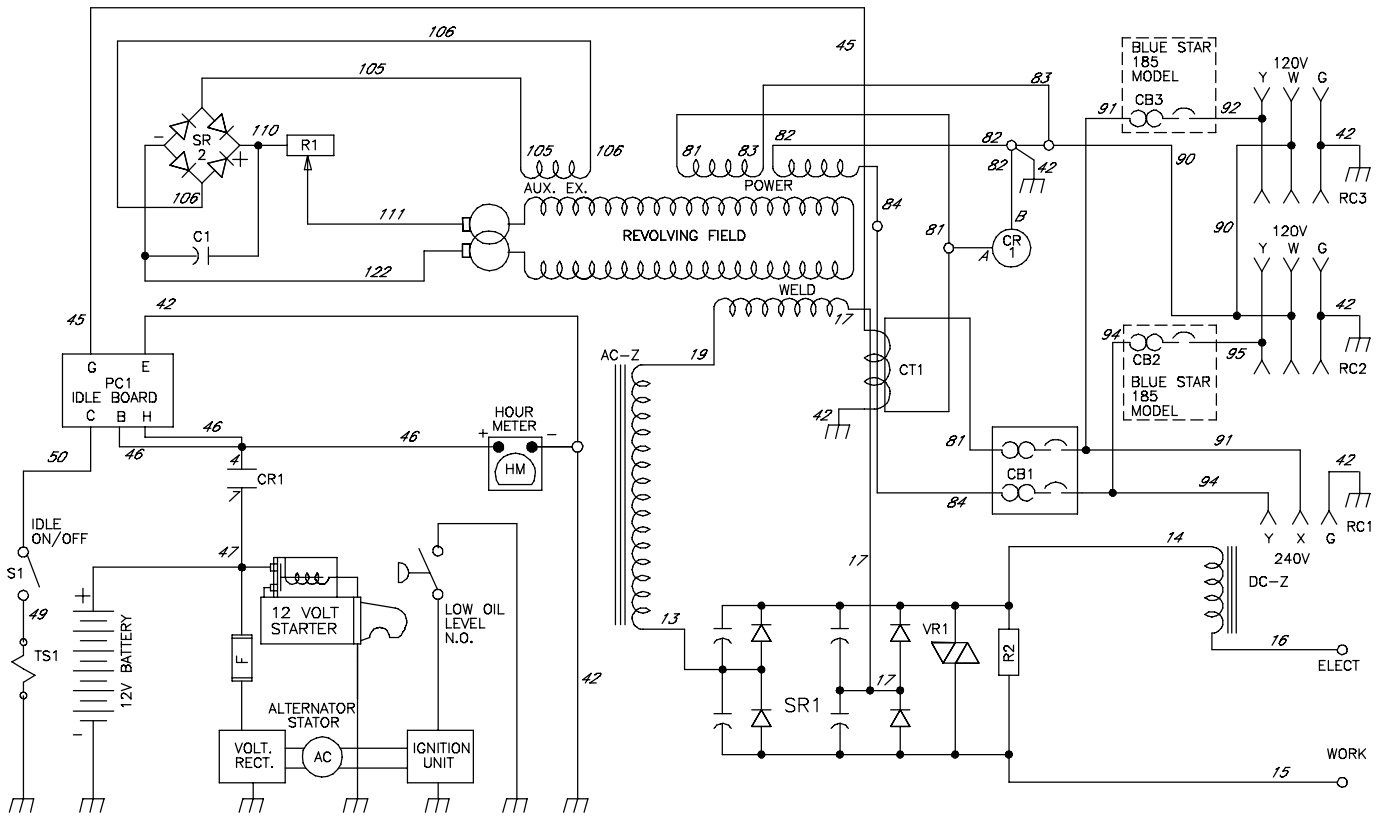
# SECTION 11 – ELECTRICAL DIAGRAMS

 <b>ELECTRIC SHOCK HAZARD</b>	<b>WARNING</b>
	<ul style="list-style-type: none"> <li>• Do not touch live electrical parts.</li> <li>• Disconnect input power or stop engine before servicing.</li> <li>• Do not operate with covers removed.</li> <li>• Have only qualified persons install, use, or service this unit.</li> </ul>

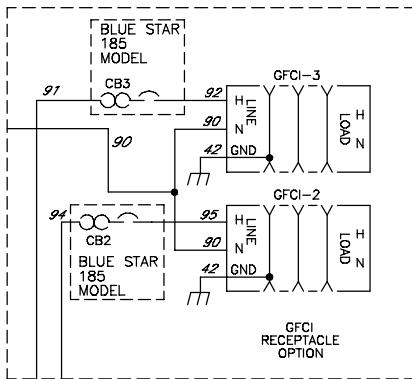
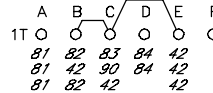
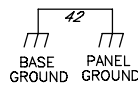


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**Figure 11-1. Circuit Diagram For Standard Models**



ELECTRIC START KOHLER ENGINE



**⚠ WARNING**

- Do not touch live electrical parts.
- Disconnect input power or stop engine before servicing.
- Do not operate with covers removed.
- Have only qualified persons install, use, or service this unit.



**ELECTRIC SHOCK HAZARD**

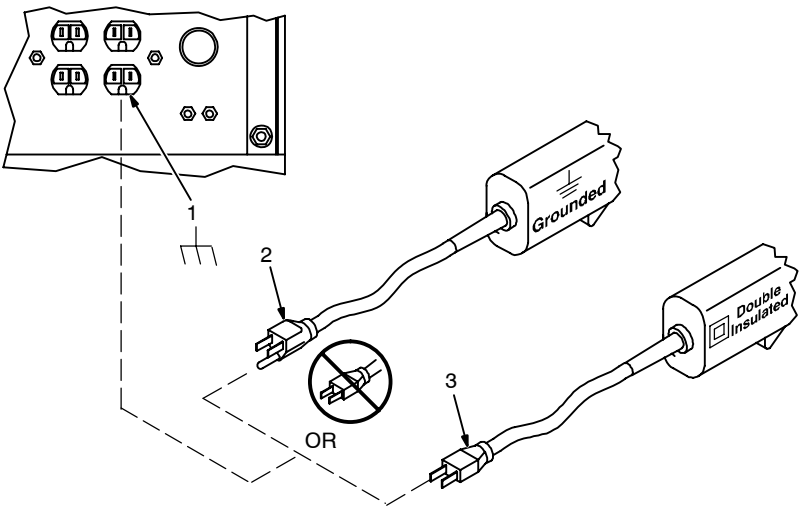
Figure 11-2. Circuit Diagram for DX Models

# SECTION 12 – GENERATOR POWER GUIDELINES

*The views in this section are intended to be representative of all engine-driven welding generators. Your unit may differ from those shown.*

## 12-1. Selecting Equipment





- 1 Generator Power Receptacles – Neutral Bonded To Frame
- 2 3-Prong Plug From Case Grounded Equipment
- 3 2-Prong Plug From Double Insulated Equipment

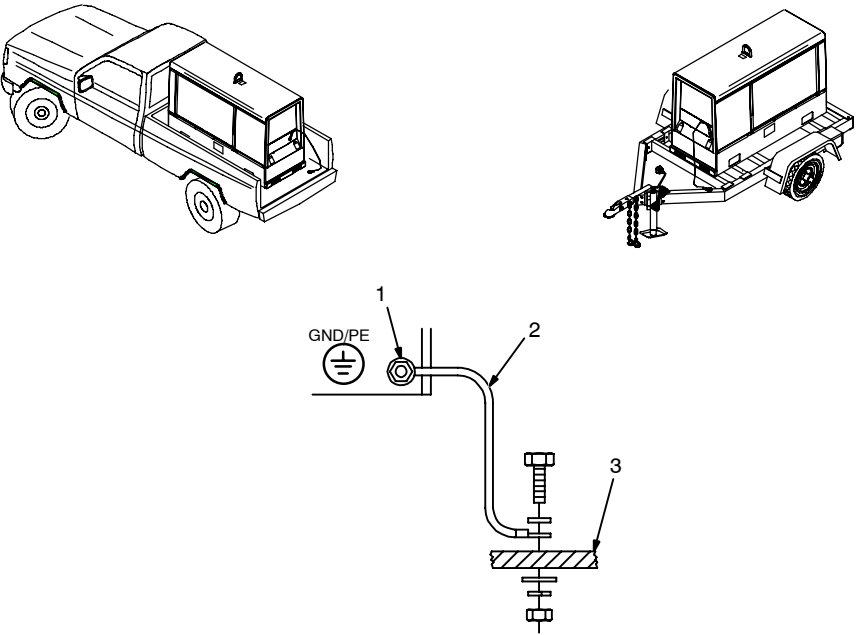
*Be sure equipment has double insulated symbol and/or wording on it.*

**Do not use 2-prong plug unless equipment is double insulated.**

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## 12-2. Grounding Generator To Truck Or Trailer Frame



**Always ground generator frame to vehicle frame to prevent electric shock and static electricity hazards.**

**Also see AWS Safety & Health Fact Sheet No. 29, Grounding of Portable And Vehicle Mounted Welding Generators.**

- 1 Equipment Grounding Terminal (On Front Panel)
- 2 Grounding Cable (Not Supplied)
- 3 Metal Vehicle Frame

Connect cable from equipment ground terminal to metal vehicle frame. Use #10 AWG or larger insulated copper wire.

*Electrically bond generator frame to vehicle frame by metal-to-metal contact.*

**Bed liners, shipping skids, and some running gear insulate the welding generator from the vehicle frame. Always connect a ground wire from the generator equipment grounding terminal to bare metal on the vehicle frame as shown.**

**If unit does not have GFCI receptacles, use GFCI-protected extension cord.**

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## 12-3. Grounding When Supplying Building Systems

1 Equipment Grounding Terminal  
2 Grounding Cable  
Use #10 AWG or larger insulated copper wire.  
3 Ground Device

Use ground device as stated in electrical codes.

**Ground generator to system earth ground if supplying power to a premises (home, shop, farm) wiring system.**

**Also see AWS Safety & Health Fact Sheet No. 29, Grounding of Portable And Vehicle Mounted Welding Generators.**

ST-800 576-B

## 12-4. How Much Power Does Equipment Require?

1 Resistive Load  
A light bulb is a resistive load and requires a constant amount of power.

2 Non-Resistive Load  
Equipment with a motor is a non-resistive load and requires approximately six times more power while starting the motor than when running (see Section 12-8).

3 Rating Data  
Rating shows volts and amperes, or watts required to run equipment.

**Amperes x Volts = Watts**

**Example 1:** If a drill uses 4.5 amperes at 115 volts, calculate its running power requirement in watts.  
 $4.5 \text{ A} \times 115 \text{ V} = 520 \text{ W}$   
 The load applied by the drill is 520 watts.

**Example 2:** If three 200 watt flood lamps are used with the drill from Example 1, add the individual loads to calculate total load.  
 $(3 \times 200\text{W}) + 520 \text{ W} = 1120 \text{ W}$   
 The total load applied by the three flood lamps and drill is 1120 watts.

S-0623

## 12-5. Approximate Power Requirements For Industrial Motors

Industrial Motors	Rating	Starting Watts	Running Watts
Split Phase	1/8 HP	800	300
	1/6 HP	1225	500
	1/4 HP	1600	600
	1/3 HP	2100	700
	1/2 HP	3175	875
Capacitor Start-Induction Run	1/3 HP	2020	720
	1/2 HP	3075	975
	3/4 HP	4500	1400
	1 HP	6100	1600
	1-1/2 HP	8200	2200
	2 HP	10550	2850
	3 HP	15900	3900
Capacitor Start-Capacitor Run	5 HP	23300	6800
	1-1/2 HP	8100	2000
	5 HP	23300	6000
	7-1/2 HP	35000	8000
Fan Duty	10 HP	46700	10700
	1/8 HP	1000	400
	1/6 HP	1400	550
	1/4 HP	1850	650
	1/3 HP	2400	800
	1/2 HP	3500	1100

## 12-6. Approximate Power Requirements For Farm/Home Equipment

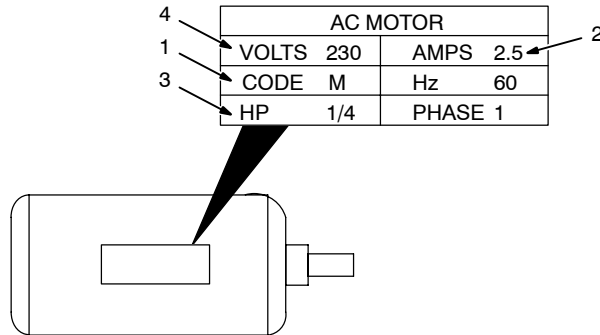
Farm/Home Equipment	Rating	Starting Watts	Running Watts
Stock Tank De-Icer		1000	1000
Grain Cleaner	1/4 HP	1650	650
Portable Conveyor	1/2 HP	3400	1000
Grain Elevator	3/4 HP	4400	1400
Milk Cooler		2900	1100
Milker (Vacuum Pump)	2 HP	10500	2800
FARM DUTY MOTORS	1/3 HP	1720	720
Std. (e.g. Conveyors,	1/2 HP	2575	975
Feed Augers, Air	3/4 HP	4500	1400
Compressors)	1 HP	6100	1600
	1-1/2 HP	8200	2200
	2 HP	10550	2850
	3 HP	15900	3900
	5 HP	23300	6800
High Torque (e.g. Barn	1-1/2 HP	8100	2000
Cleaners, Silo Unloaders,	5 HP	23300	6000
Silo Hoists, Bunk Feeders)	7-1/2 HP	35000	8000
	10 HP	46700	10700
3-1/2 cu. ft. Mixer	1/2 HP	3300	1000
High Pressure 1.8 Gal/Min	500 PSI	3150	950
Washer 2 gal/min	550 PSI	4500	1400
2 gal/min	700 PSI	6100	1600
Refrigerator or Freezer		3100	800
Shallow Well Pump	1/3 HP	2150	750
	1/2 HP	3100	1000
Sump Pump	1/3 HP	2100	800
	1/2 HP	3200	1050

## 12-7. Approximate Power Requirements For Contractor Equipment

Contractor	Rating	Starting Watts	Running Watts
Hand Drill	1/4 in	350	350
	3/8 in	400	400
	1/2 in	600	600
Circular Saw	6-1/2 in	500	500
	7-1/4 in	900	900
	8-1/4 in	1400	1400
Table Saw	9 in	4500	1500
	10 in	6300	1800
Band Saw	14 in	2500	1100
Bench Grinder	6 in	1720	720
	8 in	3900	1400
	10 in	5200	1600
Air Compressor	1/2 HP	3000	1000
	1 HP	6000	1500
	1-1/2 HP	8200	2200
	2 HP	10500	2800
Electric Chain Saw	1-1/2 HP, 12 in	1100	1100
	2 HP, 14 in	1100	1100
Electric Trimmer	Standard 9 in	350	350
	Heavy Duty 12 in	500	500
Electric Cultivator	1/3 HP	2100	700
Elec. Hedge Trimmer	18 in	400	400
Flood Lights	HID	125	100
	Metal Halide	313	250
	Mercury	1000	
	Sodium Vapor	1400	1000
Submersible Pump	400 gph	600	200
Centrifugal Pump	900 gph	900	500
Floor Polisher	3/4 HP, 16 in	4500	1400
	1 HP, 20 in	6100	1600
High Pressure Washer	1/2 HP	3150	950
	3/4 HP	4500	1400
	1 HP	6100	1600
55 gal Drum Mixer	1/4 HP	1900	700
Wet & Dry Vac	1.7 HP	900	900
	2-1/2 HP	1300	1300

## 12-8. Power Required To Start Motor

Single-Phase Induction Motor Starting Requirements								
Motor Start Code	G	H	J	K	L	M	N	P
KVA/HP	6.3	7.1	8.0	9.0	10.0	11.2	12.5	14.0



- 1 Motor Start Code
- 2 Running Amperage
- 3 Motor HP
- 4 Motor Voltage

To find starting amperage:

**Step 1:** Find code and use table to find kVA/HP. If code is not listed, multiply running amperage by six to find starting amperage.

**Step 2:** Find Motor HP and Volts.

**Step 3:** Determine starting amperage (see example).

Welding generator amperage output must be at least twice the motor's running amperage.

$$\frac{(\text{kVA/HP} \times \text{HP} \times 1000)}{\text{Volts}} = \text{Starting Amperage}$$

Example: Calculate starting amperage required for a 230 V, 1/4 HP motor with a motor start code of M.

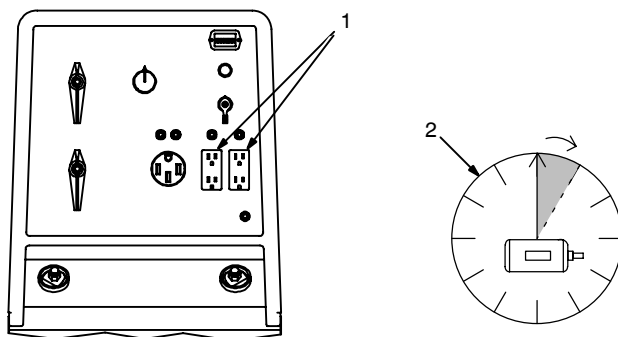
Volts = 230, HP = 1/4, kVA/HP = 11.2

$$(11.2 \times 1/4 \times 1000) / 230 = 12.2\text{A}$$

Starting the motor requires 12.2 amperes.

S-0624

## 12-9. How Much Power Can Generator Supply?



- 1 Limit Load To 90% Of Generator Output

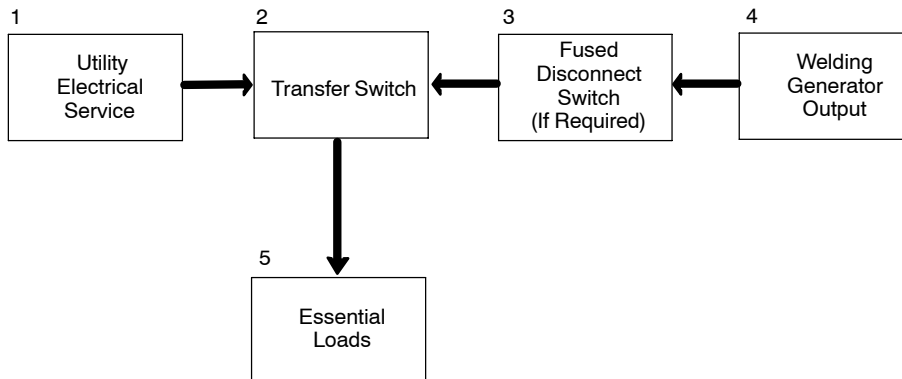
Always start non-resistive (motor) loads in order from largest to smallest, and add resistive loads last.

- 2 5 Second Rule

If motor does not start within 5 seconds, turn off power to prevent motor damage. Motor requires more power than generator can supply.

Ref. ST-800 396-A / S-0625

## 12-10. Typical Connections To Supply Standby Power



**⚠** Have only qualified persons perform these connections according to all applicable codes and safety practices.

**⚠** Properly install and ground this equipment according to its Owner's Manual and national, state, and local codes.

**📖** Customer-supplied equipment is required if generator will supply standby power during emergencies or power outages.

1 Utility Electrical Service

2 Transfer Switch (Double-Throw)

Switch transfers the electrical load from electric utility service to the generator. Transfer load back to electric utility when service is restored.

Install correct switch (customer-supplied). Switch rating must be same as or greater than the branch overcurrent protection.

3 Fused Disconnect Switch

Install correct switch (customer-supplied) if required by electrical code.

4 Welding Generator Output

Generator output voltage and wiring must be consistent with regular (utility) system voltage and wiring.

Connect generator with temporary or permanent wiring suitable for the installation.

Turn off or unplug all equipment connected to generator before starting or stopping engine. When starting or stopping, the engine has low speed which causes low voltage and frequency.

5 Essential Loads

Generator output may not meet the electrical requirements of the premises. If generator does not produce enough output to meet all requirements, connect only essential loads (pumps, freezers, heaters, etc. – See Section 12-4).

## 12-11. Selecting Extension Cord (Use Shortest Cord Possible)



### Cord Lengths for 120 Volt Loads

**⚠** If unit does not have GFCI receptacles, use GFCI-protected extension cord.

Current (Amperes)	Load (Watts)	Maximum Allowable Cord Length in ft (m) for Conductor Size (AWG)*					
		4	6	8	10	12	14
5	600			350 (106)	225 (68)	137 (42)	100 (30)
7	840		400 (122)	250 (76)	150 (46)	100 (30)	62 (19)
10	1200	400 (122)	275 (84)	175 (53)	112 (34)	62 (19)	50 (15)
15	1800	300 (91)	175 (53)	112 (34)	75 (23)	37 (11)	30 (9)
20	2400	225 (68)	137 (42)	87 (26)	50 (15)	30 (9)	
25	3000	175 (53)	112 (34)	62 (19)	37 (11)		
30	3600	150 (46)	87 (26)	50 (15)	37 (11)		
35	4200	125 (38)	75 (23)	50 (15)			
40	4800	112 (34)	62 (19)	37 (11)			
45	5400	100 (30)	62 (19)				
50	6000	87 (26)	50 (15)				

\*Conductor size is based on maximum 2% voltage drop

### Cord Lengths for 240 Volt Loads

**⚠** If unit does not have GFCI receptacles, use GFCI-protected extension cord.

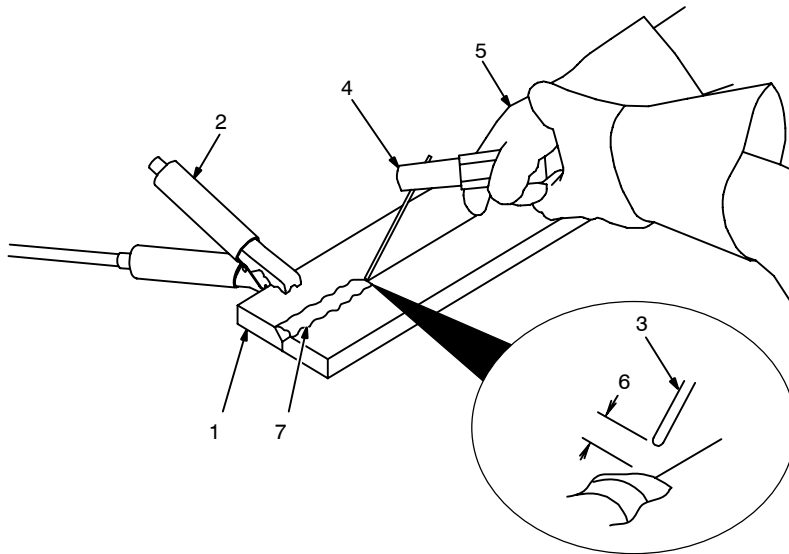
Current (Amperes)	Load (Watts)	Maximum Allowable Cord Length in ft (m) for Conductor Size (AWG)*					
		4	6	8	10	12	14
5	1200			700 (213)	450 (137)	225 (68)	200 (61)
7	1680		800 (244)	500 (152)	300 (91)	200 (61)	125 (38)
10	2400	800 (244)	550 (168)	350 (107)	225 (69)	125 (38)	100 (31)
15	3600	600 (183)	350 (107)	225 (69)	150 (46)	75 (23)	60 (18)
20	4800	450 (137)	275 (84)	175 (53)	100 (31)	60 (18)	
25	6000	350 (107)	225 (69)	125 (38)	75 (23)		
30	7000	300 (91)	175 (53)	100 (31)	75 (23)		
35	8400	250 (76)	150 (46)	100 (31)			
40	9600	225 (69)	125 (38)	75 (23)			
45	10,800	200 (61)	125 (38)				
50	12,000	175 (53)	100 (31)				

\*Conductor size is based on maximum 2% voltage drop

# SECTION 13 – STICK WELDING (SMAW) GUIDELINES



## 13-1. Stick Welding Procedure



**⚠** Weld current starts when electrode touches workpiece.

**⚠** Weld current can damage electronic parts in vehicles. Disconnect both battery cables before welding on a vehicle. Place work clamp as close to the weld as possible.

1 Workpiece

Make sure workpiece is clean before welding.

2 Work Clamp

3 Electrode

A small diameter electrode requires less current than a large one. Follow electrode manufacturer's instructions when setting weld amperage (see Section 13-2).

4 Insulated Electrode Holder

5 Electrode Holder Position

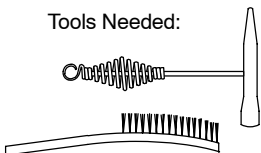
6 Arc Length

Arc length is the distance from the electrode to the workpiece. A short arc with correct amperage will give a sharp, crackling sound.

7 Slag

Use a chipping hammer and wire brush to remove slag. Remove slag and check weld bead before making another weld pass.

Tools Needed:



stick 2007-04 - ST-151 593

### 13-2. Electrode and Amperage Selection Chart

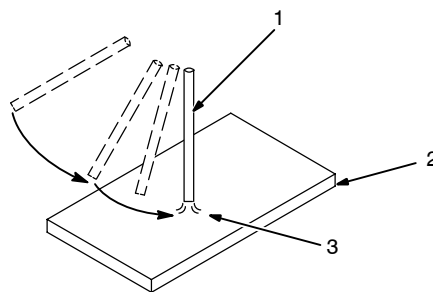
ELECTRODE	DIAMETER	AMPERAGE RANGE								
		50	100	150	200	250	300	350	400	450
6010 & 6011	3/32									
	1/8									
	5/32									
	3/16									
	7/32									
6013	1/4									
	1/16									
	5/64									
	3/32									
	1/8									
	5/32									
	3/16									
7014	7/32									
	1/4									
	3/32									
	1/8									
	5/32									
7018	3/16									
	7/32									
	1/4									
	3/32									
	1/8									
7024	5/32									
	3/16									
	7/32									
	1/4									
	3/32									
Ni-CI	1/8									
	5/32									
	3/16									
308L	3/32									
	1/8									
	5/32									

ELECTRODE	DC*	AC	POSITION	PENETRATION	USAGE
6010	EP		ALL	DEEP	MIN. PREP, ROUGH
6011	EP	✓	ALL	DEEP	HIGH SPATTER
6013	EP,EN	✓	ALL	LOW	GENERAL
7014	EP,EN	✓	ALL	MED	SMOOTH, EASY, FAST
7018	EP	✓	ALL	LOW	LOW HYDROGEN, STRONG
7024	EP,EN	✓	FLAT HORIZ FILLET	LOW	SMOOTH, EASY, FASTER
NI-CL	EP	✓	ALL	LOW	CAST IRON
308L	EP	✓	ALL	LOW	STAINLESS

\*EP = ELECTRODE POSITIVE (REVERSE POLARITY)  
EN = ELECTRODE NEGATIVE (STRAIGHT POLARITY)

Ref. S-087 985-A

### 13-3. Striking an Arc – Scratch Start Technique

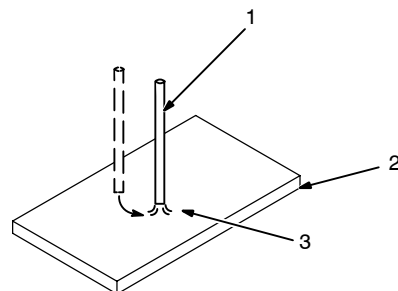


- 1 Electrode
- 2 Workpiece
- 3 Arc

Drag electrode across workpiece like striking a match; lift electrode slightly after touching work. If arc goes out electrode was lifted too high. If electrode sticks to workpiece, use a quick twist to free it.

S-0049

### 13-4. Striking an Arc – Tapping Technique



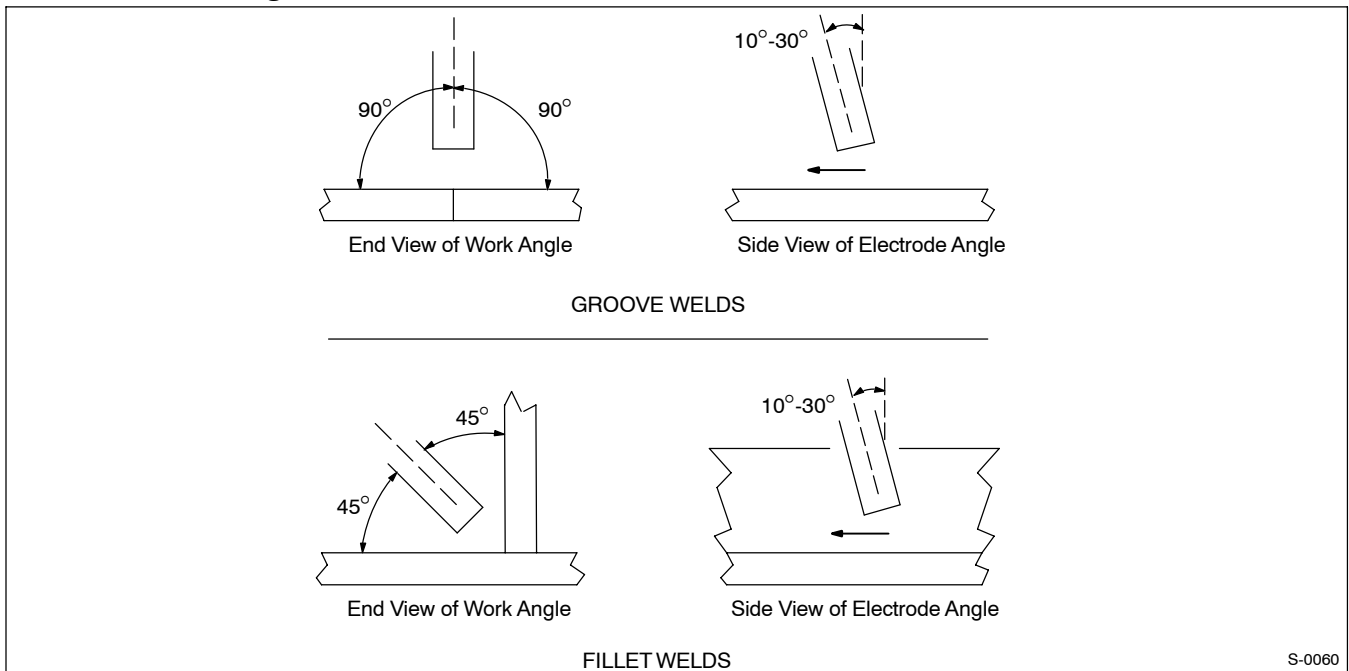
- 1 Electrode
- 2 Workpiece
- 3 Arc

Bring electrode straight down to workpiece; then lift slightly to start arc. If arc goes out, electrode was lifted too high. If electrode sticks to workpiece, use a quick twist to free it.

S-0050

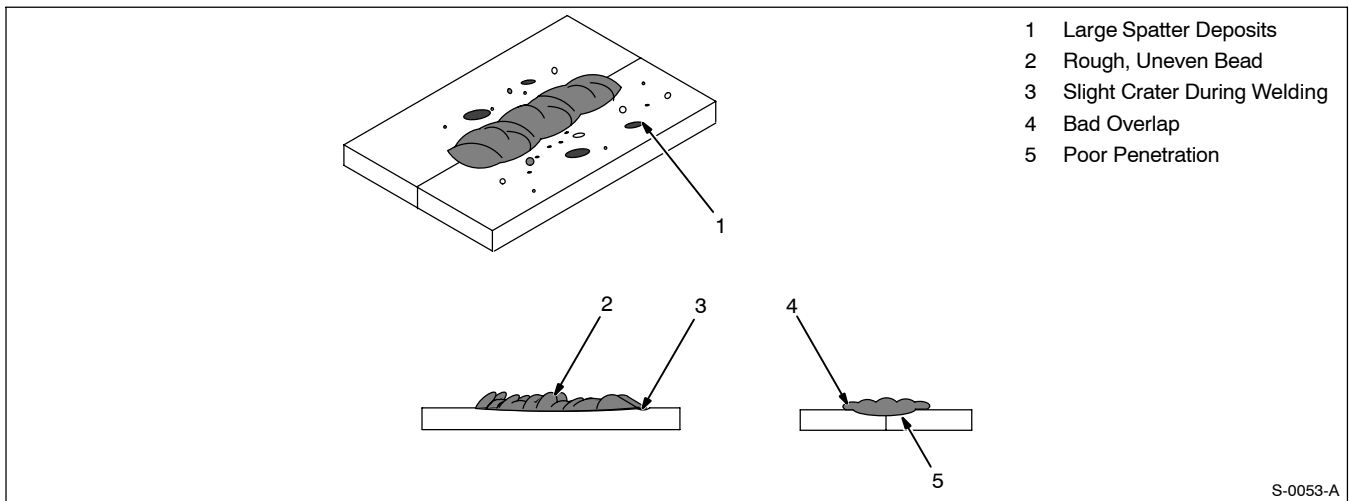


### 13-5. Positioning Electrode Holder



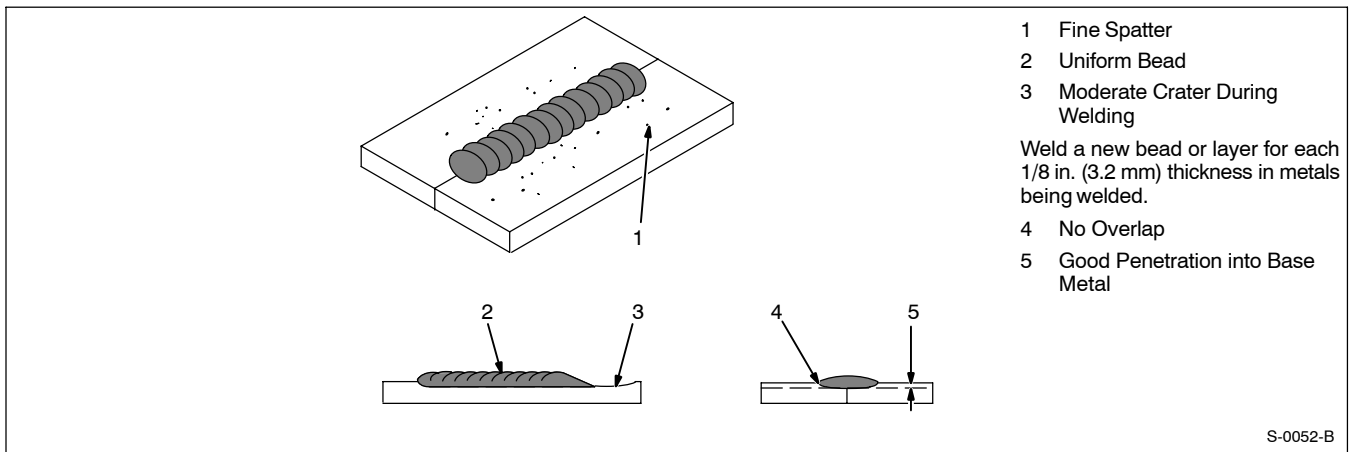
S-0060

### 13-6. Poor Weld Bead Characteristics



S-0053-A

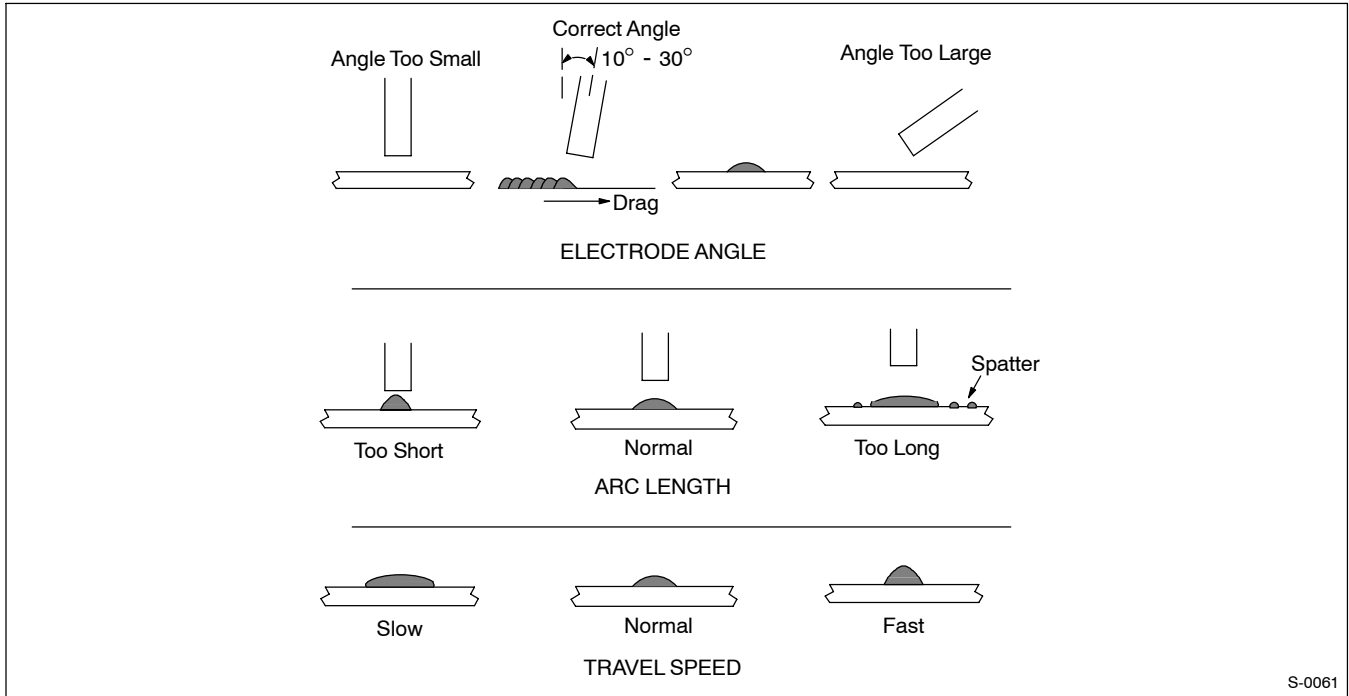
### 13-7. Good Weld Bead Characteristics



S-0052-B

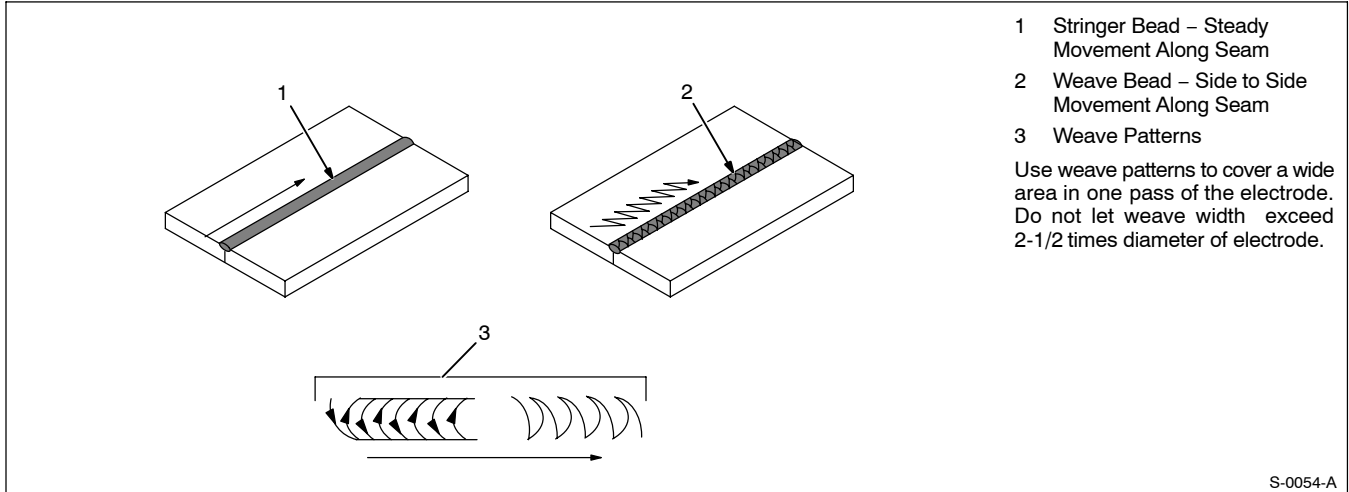
### 13-8. Conditions That Affect Weld Bead Shape

☞ Weld bead shape is affected by electrode angle, arc length, travel speed, and thickness of base metal.

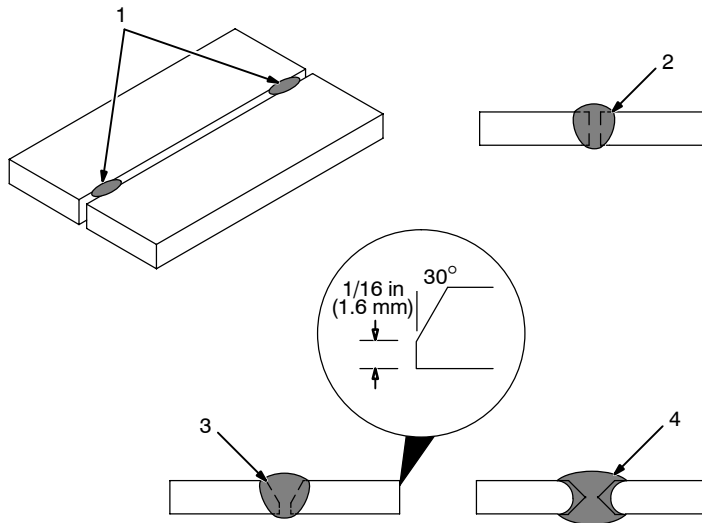


### 13-9. Electrode Movement During Welding

☞ Normally, a single stringer bead is satisfactory for most narrow groove weld joints; however, for wide groove weld joints or bridging across gaps, a weave bead or multiple stringer beads work better.



## 13-10. Butt Joints



### 1 Tack Welds

Prevent edges of joint from drawing together ahead of electrode by tack welding the materials in position before final weld.

### 2 Square Groove Weld

Good for materials up to 3/16 in (5 mm) thick.

### 3 Single V-Groove Weld

Good for materials 3/16 – 3/4 in (5-19 mm) thick. Cut bevel with oxy-acetylene or plasma cutting equipment. Remove scale from material after cutting. A grinder can also be used to prepare bevels.

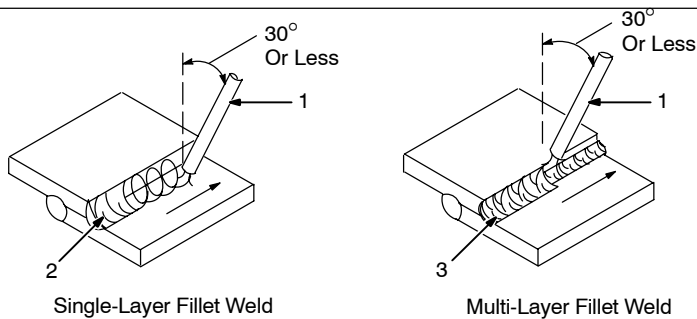
Create 30 degree angle of bevel on materials in V-groove welding.

### 4 Double V-Groove Weld

Good for materials thicker than 3/16 in (5 mm).

S-0662

## 13-11. Lap Joint



### 1 Electrode

### 2 Single-Layer Fillet Weld

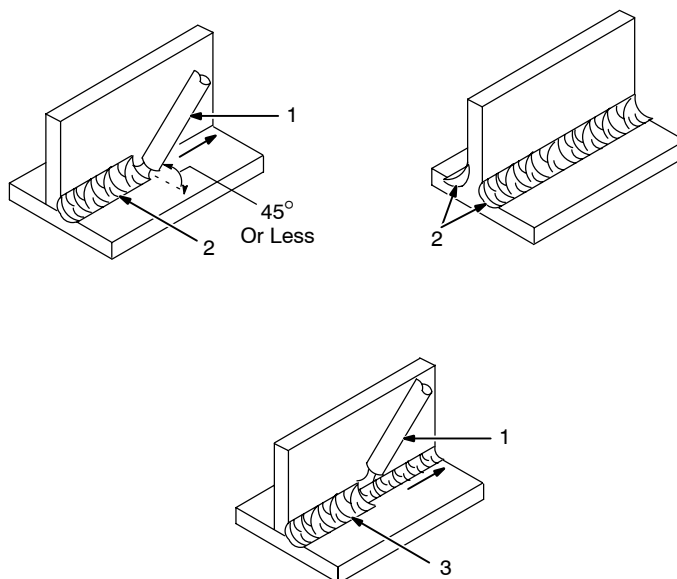
Move electrode in circular motion.

### 3 Multi-Layer Fillet Weld

Weld a second layer when a heavier fillet is needed. Remove slag before making another weld pass. Weld both sides of joint for maximum strength.

S-0063 / S-0064

## 13-12. Tee Joint



### 1 Electrode

### 2 Fillet Weld

Keep arc short and move at definite rate of speed. Hold electrode as shown to provide fusion into the corner. Square edge of the weld surface.

For maximum strength weld both sides of upright section.

### 3 Multi-Layer Deposits

Weld a second layer when a heavier fillet is needed. Use any of the weaving patterns shown in Section 13-9. Remove slag before making another weld pass.

S-0060 / S-0058-A / S-0061

### 13-13. Weld Test

1 Vise  
2 Weld Joint  
3 Hammer

Strike weld joint in direction shown. A good weld bends over but does not break.

S-0057-B

### 13-14. Troubleshooting – Porosity

Porosity – small cavities or holes resulting from gas pockets in weld metal.

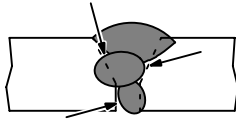
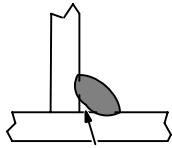
Possible Causes	Corrective Actions
Arc length too long.	Reduce arc length.
Damp electrode.	Use dry electrode.
Workpiece dirty.	Remove all grease, oil, moisture, rust, paint, coatings, slag, and dirt from work surface before welding.

### 13-15. Troubleshooting – Excessive Spatter

Excessive Spatter – scattering of molten metal particles that cool to solid form near weld bead.

Possible Causes	Corrective Actions
Amperage too high for electrode.	Decrease amperage or select larger electrode.
Arc length too long or voltage too high.	Reduce arc length or voltage.

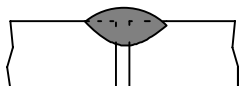
### 13-16. Troubleshooting – Incomplete Fusion



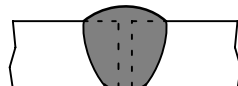
Incomplete Fusion – failure of weld metal to fuse completely with base metal or a preceding weld bead.

Possible Causes	Corrective Actions
Insufficient heat input.	Increase amperage. Select larger electrode and increase amperage.
Improper welding technique.	Place stringer bead in proper location(s) at joint during welding.
	Adjust work angle or widen groove to access bottom during welding.
	Momentarily hold arc on groove side walls when using weaving technique.
	Keep arc on leading edge of weld puddle.
Workpiece dirty.	Remove all grease, oil, moisture, rust, paint, coatings, slag, and dirt from work surface before welding.

### 13-17. Troubleshooting – Lack Of Penetration



Lack of Penetration

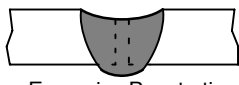


Good Penetration

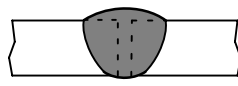
Lack Of Penetration – shallow fusion between weld metal and base metal.

Possible Causes	Corrective Actions
Improper joint preparation.	Material too thick. Joint preparation and design must provide access to bottom of groove.
Improper weld technique.	Keep arc on leading edge of weld puddle.
Insufficient heat input.	Increase amperage. Select larger electrode and increase amperage.
	Reduce travel speed.

### 13-18. Troubleshooting – Excessive Penetration



Excessive Penetration

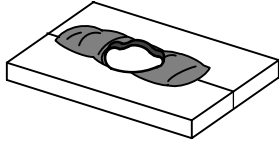


Good Penetration

Excessive Penetration – weld metal melting through base metal and hanging underneath weld.

Possible Causes	Corrective Actions
Excessive heat input.	Select lower amperage. Use smaller electrode.
	Increase and/or maintain steady travel speed.

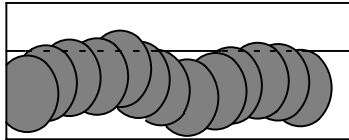
### 13-19. Troubleshooting – Burn-Through



Burn-Through – weld metal melting completely through base metal resulting in holes where no metal remains.

Possible Causes	Corrective Actions
Excessive heat input.	Select lower amperage. Use smaller electrode.
	Increase and/or maintain steady travel speed.

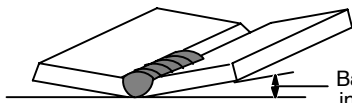
### 13-20. Troubleshooting – Waviness Of Bead



Waviness Of Bead – weld metal that is not parallel and does not cover joint formed by base metal.

Possible Causes	Corrective Actions
Unsteady hand.	Use two hands. Practice technique.

### 13-21. Troubleshooting – Distortion



Base metal moves in the direction of the weld bead.

Distortion – contraction of weld metal during welding that forces base metal to move.

Possible Causes	Corrective Actions
Excessive heat input.	Use restraint (clamp) to hold base metal in position.
	Make tack welds along joint before starting welding operation.
	Select lower amperage for electrode.
	Increase travel speed.
	Weld in small segments and allow cooling between welds.

# TRUE BLUE<sup>®</sup>

## WARRANTY

Effective January 1, 2007

(Equipment with a serial number preface of "LH" or newer)

This limited warranty supersedes all previous Miller warranties and is exclusive with no other guarantees or warranties expressed or implied.

LIMITED WARRANTY – Subject to the terms and conditions below, Miller Electric Mfg. Co., Appleton, Wisconsin, warrants to its original retail purchaser that new Miller equipment sold after the effective date of this limited warranty is free of defects in material and workmanship at the time it is shipped by Miller. THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

Within the warranty periods listed below, Miller will repair or replace any warranted parts or components that fail due to such defects in material or workmanship. Miller must be notified in writing within thirty (30) days of such defect or failure, at which time Miller will provide instructions on the warranty claim procedures to be followed.

Miller shall honor warranty claims on warranted equipment listed below in the event of such a failure within the warranty time periods. All warranty time periods start on the delivery date of the equipment to the original end-user purchaser, and not to exceed one year after the equipment is shipped to a North American distributor or eighteen months after the equipment is shipped to an International distributor.

1. 5 Years Parts — 3 Years Labor
  - \* Original main power rectifiers
2. 3 Years — Parts and Labor
  - \* Transformer/Rectifier Power Sources
  - \* Plasma Arc Cutting Power Sources
  - \* Process Controllers
  - \* Semi-Automatic and Automatic Wire Feeders
  - \* Inverter Power Sources (Unless Otherwise Stated)
  - \* Water Coolant Systems (Integrated)
  - \* Intellitig
  - \* Engine Driven Welding Generators  
**(NOTE: Engines are warranted separately by the engine manufacturer.)**
3. 1 Year — Parts and Labor Unless Specified
  - \* Motor Driven Guns (w/exception of Spoolmate Spoolguns)
  - \* Positioners and Controllers
  - \* Automatic Motion Devices
  - \* RFCS Foot Controls
  - \* Induction Heating Power Sources, Coolers, and Electronic Controls/Recorders
  - \* Water Coolant Systems (Non-Integrated)
  - \* Flowgauge and Flowmeter Regulators (No Labor)
  - \* HF Units
  - \* Grids
  - \* Spot Welders
  - \* Load Banks
  - \* Arc Stud Power Sources & Arc Stud Guns
  - \* Racks
  - \* Running Gear/Trailers
  - \* Plasma Cutting Torches (except APT & SAF Models)
  - \* Field Options  
(NOTE: Field options are covered under True Blue<sup>®</sup> for the remaining warranty period of the product they are installed in, or for a minimum of one year — whichever is greater.)
  - \* Bernard-Branded Mig Guns (No Labor)
  - \* Weldcraft-Branded TIG Torches (No Labor)
  - \* Subarc Wire Drive Assemblies
4. 6 Months — Batteries
5. 90 Days — Parts
  - \* MIG Guns/TIG Torches and Subarc (SAW) Guns

- \* Induction Heating Coils and Blankets, Cables, and Non-Electronic Controls
- \* APT & SAF Model Plasma Cutting Torches
- \* Remote Controls
- \* Accessory (Kits)
- \* Replacement Parts (No labor)
- \* Spoolmate Spoolguns
- \* Canvas Covers

Miller's True Blue<sup>®</sup> Limited Warranty shall not apply to:

1. **Consumable components; such as contact tips, cutting nozzles, contactors, brushes, slip rings, relays or parts that fail due to normal wear. (Exception: brushes, slip rings, and relays are covered on Bobcat, Trailblazer, and Legend models.)**
2. Items furnished by Miller, but manufactured by others, such as engines or trade accessories. These items are covered by the manufacturer's warranty, if any.
3. Equipment that has been modified by any party other than Miller, or equipment that has been improperly installed, improperly operated or misused based upon industry standards, or equipment which has not had reasonable and necessary maintenance, or equipment which has been used for operation outside of the specifications for the equipment.

MILLER PRODUCTS ARE INTENDED FOR PURCHASE AND USE BY COMMERCIAL/INDUSTRIAL USERS AND PERSONS TRAINED AND EXPERIENCED IN THE USE AND MAINTENANCE OF WELDING EQUIPMENT.

In the event of a warranty claim covered by this warranty, the exclusive remedies shall be, at Miller's option: (1) repair; or (2) replacement; or, where authorized in writing by Miller in appropriate cases, (3) the reasonable cost of repair or replacement at an authorized Miller service station; or (4) payment of or credit for the purchase price (less reasonable depreciation based upon actual use) upon return of the goods at customer's risk and expense. Miller's option of repair or replacement will be F.O.B., Factory at Appleton, Wisconsin, or F.O.B. at a Miller authorized service facility as determined by Miller. Therefore no compensation or reimbursement for transportation costs of any kind will be allowed.

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#### Service

You always get the fast,  
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#### Support

Need fast answers to the  
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step of the way.





# Owner's Record

Please complete and retain with your personal records.

Model Name

Serial/Style Number

Purchase Date

(Date which equipment was delivered to original customer.)

Distributor

Address

City

State

Zip



## For Service

**Contact a DISTRIBUTOR or SERVICE AGENCY near you.**

Always provide Model Name and Serial/Style Number.

Contact your Distributor for:

Welding Supplies and Consumables

Options and Accessories

Personal Safety Equipment

Service and Repair

Replacement Parts

Training (Schools, Videos, Books)

Technical Manuals (Servicing Information and Parts)

Circuit Diagrams

Welding Process Handbooks

To locate a Distributor or Service Agency visit [www.millerwelds.com](http://www.millerwelds.com) or call 1-800-4-A-Miller

Contact the Delivering Carrier to:

File a claim for loss or damage during shipment.

For assistance in filing or settling claims, contact your distributor and/or equipment manufacturer's Transportation Department.

### Miller Electric Mfg. Co.

An Illinois Tool Works Company  
1635 West Spencer Street  
Appleton, WI 54914 USA

### International Headquarters—USA

USA Phone: 920-735-4505 Auto-Attended  
USA & Canada FAX: 920-735-4134  
International FAX: 920-735-4125

### European Headquarters – United Kingdom

Phone: 44 (0) 1204-593493  
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