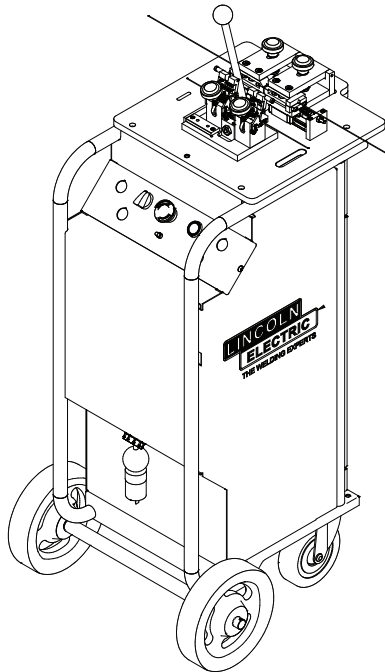


## Operator's Manual

# ***DOCKING STATION Butt Welder***



For use with machines having K Numbers:

**K3921-1**



**Register your machine:**

[www.lincolnelectric.com/register](http://www.lincolnelectric.com/register)

**Authorized Service and Distributor Locator:**

[www.lincolnelectric.com/locator](http://www.lincolnelectric.com/locator)

### Save for future reference

Date Purchased

Code: (ex: 10859)

Serial: (ex: U1060512345)

# THANK YOU FOR SELECTING A QUALITY PRODUCT BY LINCOLN ELECTRIC.

## PLEASE EXAMINE CARTON AND EQUIPMENT FOR DAMAGE IMMEDIATELY

When this equipment is shipped, title passes to the purchaser upon receipt by the carrier. Consequently, claims for material damaged in shipment must be made by the purchaser against the transportation company at the time the shipment is received.

## SAFETY DEPENDS ON YOU

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

### **WARNING**

This statement appears where the information must be followed exactly to avoid serious personal injury or loss of life.

### **CAUTION**

This statement appears where the information must be followed to avoid minor personal injury or damage to this equipment.



## KEEP YOUR HEAD OUT OF THE FUMES.

**DON'T** get too close to the arc. Use corrective lenses if necessary to stay a reasonable distance away from the arc.

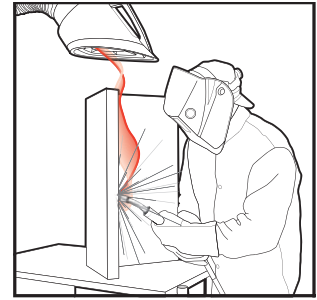
**READ** and obey the Safety Data Sheet (SDS) and the warning label that appears on all containers of welding materials.

**USE ENOUGH VENTILATION** or exhaust at the arc, or both, to keep the fumes and gases from your breathing zone and the general area.

**IN A LARGE ROOM OR OUTDOORS**, natural ventilation may be adequate if you keep your head out of the fumes (See below).

**USE NATURAL DRAFTS** or fans to keep the fumes away from your face.

If you develop unusual symptoms, see your supervisor. Perhaps the welding atmosphere and ventilation system should be checked.



## WEAR CORRECT EYE, EAR & BODY PROTECTION

**PROTECT** your eyes and face with welding helmet properly fitted and with proper grade of filter plate (See ANSI Z49.1).

**PROTECT** your body from welding spatter and arc flash with protective clothing including woolen clothing, flame-proof apron and gloves, leather leggings, and high boots.

**PROTECT** others from splatter, flash, and glare with protective screens or barriers.

**IN SOME AREAS**, protection from noise may be appropriate.

**BE SURE** protective equipment is in good condition.

Also, wear safety glasses in work area **AT ALL TIMES.**



## SPECIAL SITUATIONS

**DO NOT WELD OR CUT** containers or materials which previously had been in contact with hazardous substances unless they are properly cleaned. This is extremely dangerous.

**DO NOT WELD OR CUT** painted or plated parts unless special precautions with ventilation have been taken. They can release highly toxic fumes or gases.

## Additional precautionary measures

**PROTECT** compressed gas cylinders from excessive heat, mechanical shocks, and arcs; fasten cylinders so they cannot fall.

**BE SURE** cylinders are never grounded or part of an electrical circuit.

**REMOVE** all potential fire hazards from welding area.

**ALWAYS HAVE FIRE FIGHTING EQUIPMENT READY FOR IMMEDIATE USE AND KNOW HOW TO USE IT.**



## SECTION A: WARNINGS



### CALIFORNIA PROPOSITION 65 WARNINGS



**WARNING:** Breathing diesel engine exhaust exposes you to chemicals known to the State of California to cause cancer and birth defects, or other reproductive harm.

- Always start and operate the engine in a well-ventilated area.
- If in an exposed area, vent the exhaust to the outside.
- Do not modify or tamper with the exhaust system.
- Do not idle the engine except as necessary.

For more information go to [www.P65warnings.ca.gov/diesel](http://www.P65warnings.ca.gov/diesel)

**WARNING:** This product, when used for welding or cutting, 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 § 25249.5 *et seq.*)



**WARNING:** Cancer and Reproductive Harm  
[www.P65warnings.ca.gov](http://www.P65warnings.ca.gov)

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

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

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



### FOR ENGINE POWERED EQUIPMENT.

- 1.a. Turn the engine off before troubleshooting and maintenance work unless the maintenance work requires it to be running.
- 1.b. Operate engines in open, well-ventilated areas or vent the engine exhaust fumes outdoors.
- 1.c. Do not add the fuel near an open flame welding arc or when the engine is running. Stop the engine and allow it to cool before refueling to prevent spilled fuel from vaporizing on contact



with hot engine parts and igniting. Do not spill fuel when filling tank. If fuel is spilled, wipe it up and do not start engine until fumes have been eliminated.

- 1.d. Keep all equipment safety guards, covers and devices in position and in good repair. Keep hands, hair, clothing and tools away from V-belts, gears, fans and all other moving parts when starting, operating or repairing equipment.
- 1.e. In some cases it may be necessary to remove safety guards to perform required maintenance. Remove guards only when necessary and replace them when the maintenance requiring their removal is complete. Always use the greatest care when working near moving parts.
- 1.f. Do not put your hands near the engine fan. Do not attempt to override the governor or idler by pushing on the throttle control rods while the engine is running.
- 1.g. To prevent accidentally starting gasoline engines while turning the engine or welding generator during maintenance work, disconnect the spark plug wires, distributor cap or magneto wire as appropriate.
- 1.h. To avoid scalding, do not remove the radiator pressure cap when the engine is hot.



### ELECTRIC AND MAGNETIC FIELDS MAY BE DANGEROUS



- 2.a. Electric current flowing through any conductor causes localized Electric and Magnetic Fields (EMF). Welding current creates EMF fields around welding cables and welding machines
- 2.b. EMF fields may interfere with some pacemakers, and welders having a pacemaker should consult their physician before welding.
- 2.c. Exposure to EMF fields in welding may have other health effects which are now not known.
- 2.d. All welders should use the following procedures in order to minimize exposure to EMF fields from the welding circuit:
  - 2.d.1. Route the electrode and work cables together - Secure them with tape when possible.
  - 2.d.2. Never coil the electrode lead around your body.
  - 2.d.3. Do not place your body between the electrode and work cables. If the electrode cable is on your right side, the work cable should also be on your right side.
  - 2.d.4. Connect the work cable to the workpiece as close as possible to the area being welded.
  - 2.d.5. Do not work next to welding power source.



## ELECTRIC SHOCK CAN KILL.



- 3.a. The electrode and work (or ground) circuits are electrically “hot” when the welder is on. Do not touch these “hot” parts with your bare skin or wet clothing. Wear dry, hole-free gloves to insulate hands.
- 3.b. Insulate yourself from work and ground using dry insulation. Make certain the insulation is large enough to cover your full area of physical contact with work and ground.

**In addition to the normal safety precautions, if welding must be performed under electrically hazardous conditions (in damp locations or while wearing wet clothing; on metal structures such as floors, gratings or scaffolds; when in cramped positions such as sitting, kneeling or lying, if there is a high risk of unavoidable or accidental contact with the workpiece or ground) use the following equipment:**

- Semiautomatic DC Constant Voltage (Wire) Welder.
  - DC Manual (Stick) Welder.
  - AC Welder with Reduced Voltage Control.
- 3.c. In semiautomatic or automatic wire welding, the electrode, electrode reel, welding head, nozzle or semiautomatic welding gun are also electrically “hot”.
  - 3.d. Always be sure the work cable makes a good electrical connection with the metal being welded. The connection should be as close as possible to the area being welded.
  - 3.e. Ground the work or metal to be welded to a good electrical (earth) ground.
  - 3.f. Maintain the electrode holder, work clamp, welding cable and welding machine in good, safe operating condition. Replace damaged insulation.
  - 3.g. Never dip the electrode in water for cooling.
  - 3.h. Never simultaneously touch electrically “hot” parts of electrode holders connected to two welders because voltage between the two can be the total of the open circuit voltage of both welders.
  - 3.i. When working above floor level, use a safety belt to protect yourself from a fall should you get a shock.
  - 3.j. Also see Items 6.c. and 8.



## ARC RAYS CAN BURN.



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



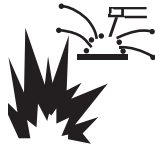
## FUMES AND GASES CAN BE DANGEROUS.



- 5.a. Welding may produce fumes and gases hazardous to health. Avoid breathing these fumes and gases. When welding, keep your head out of the fume. Use enough ventilation and/or exhaust at the arc to keep fumes and gases away from the breathing zone. **When welding hardfacing (see instructions on container or SDS) or on lead or cadmium plated steel and other metals or coatings which produce highly toxic fumes, keep exposure as low as possible and within applicable OSHA PEL and ACGIH TLV limits using local exhaust or mechanical ventilation unless exposure assessments indicate otherwise. In confined spaces or in some circumstances, outdoors, a respirator may also be required. Additional precautions are also required when welding on galvanized steel.**
- 5.b. The operation of welding fume control equipment is affected by various factors including proper use and positioning of the equipment, maintenance of the equipment and the specific welding procedure and application involved. Worker exposure level should be checked upon installation and periodically thereafter to be certain it is within applicable OSHA PEL and ACGIH TLV limits.
- 5.c. Do not weld in locations near chlorinated hydrocarbon vapors coming from degreasing, cleaning or spraying operations. The heat and rays of the arc can react with solvent vapors to form phosgene, a highly toxic gas, and other irritating products.
- 5.d. Shielding gases used for arc welding can displace air and cause injury or death. Always use enough ventilation, especially in confined areas, to insure breathing air is safe.
- 5.e. Read and understand the manufacturer’s instructions for this equipment and the consumables to be used, including the Safety Data Sheet (SDS) and follow your employer’s safety practices. SDS forms are available from your welding distributor or from the manufacturer.
- 5.f. Also see item 1.b.



## WELDING AND CUTTING SPARKS CAN CAUSE FIRE OR EXPLOSION.



- 6.a. Remove fire hazards from the welding area. If this is not possible, cover them to prevent the welding sparks from starting a fire. Remember that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas. Avoid welding near hydraulic lines. Have a fire extinguisher readily available.
- 6.b. Where compressed gases are to be used at the job site, special precautions should be used to prevent hazardous situations. Refer to "Safety in Welding and Cutting" (ANSI Standard Z49.1) and the operating information for the equipment being used.
- 6.c. When not welding, make certain no part of the electrode circuit is touching the work or ground. Accidental contact can cause overheating and create a fire hazard.
- 6.d. Do not heat, cut or weld tanks, drums or containers until the proper steps have been taken to insure that such procedures will not cause flammable or toxic vapors from substances inside. They can cause an explosion even though they have been "cleaned". For information, purchase "Recommended Safe Practices for the Preparation for Welding and Cutting of Containers and Piping That Have Held Hazardous Substances", AWS F4.1 from the American Welding Society (see address above).
- 6.e. Vent hollow castings or containers before heating, cutting or welding. They may explode.
- 6.f. Sparks and spatter are thrown from the welding arc. Wear oil free protective garments such as leather gloves, heavy shirt, cuffless trousers, high shoes and a cap over your hair. Wear ear plugs when welding out of position or in confined places. Always wear safety glasses with side shields when in a welding area.
- 6.g. Connect the work cable to the work as close to the welding area as practical. Work cables connected to the building framework or other locations away from the welding area increase the possibility of the welding current passing through lifting chains, crane cables or other alternate circuits. This can create fire hazards or overheat lifting chains or cables until they fail.
- 6.h. Also see item 1.c.
- 6.i. Read and follow NFPA 51B "Standard for Fire Prevention During Welding, Cutting and Other Hot Work", available from NFPA, 1 Batterymarch Park, PO box 9101, Quincy, MA 022690-9101.
- 6.j. Do not use a welding power source for pipe thawing.



## CYLINDER MAY EXPLODE IF DAMAGED.



- 7.a. Use only compressed gas cylinders containing the correct shielding gas for the process used and properly operating regulators designed for the gas and pressure used. All hoses, fittings, etc. should be suitable for the application and maintained in good condition.
- 7.b. Always keep cylinders in an upright position securely chained to an undercarriage or fixed support.
- 7.c. Cylinders should be located:
  - Away from areas where they may be struck or subjected to physical damage.
  - A safe distance from arc welding or cutting operations and any other source of heat, sparks, or flame.
- 7.d. Never allow the electrode, electrode holder or any other electrically "hot" parts to touch a cylinder.
- 7.e. Keep your head and face away from the cylinder valve outlet when opening the cylinder valve.
- 7.f. Valve protection caps should always be in place and hand tight except when the cylinder is in use or connected for use.
- 7.g. Read and follow the instructions on compressed gas cylinders, associated equipment, and CGA publication P-1, "Precautions for Safe Handling of Compressed Gases in Cylinders," available from the Compressed Gas Association, 14501 George Carter Way Chantilly, VA 20151.



## FOR ELECTRICALLY POWERED EQUIPMENT.



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

**Refer to**  
**<http://www.lincolnelectric.com/safety>**  
**for additional safety information.**



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# GENERAL DESCRIPTION

Designed for use with the Infinity Pak® Wire Dispensing System, the Lincoln Electric Docking Station Butt Welder quickly and efficiently joins ferrous metal wires up to .078 (2mm) in diameter.

This unit will weld both solid and cored ferrous wires. Not compatible with non-ferrous wires, such as aluminum.

## SAFETY PRECAUTIONS:

- Do not touch the wire or butt welder components during the butt welding cycle
- Protective gloves and safety glasses are required when operating this unit
- Do not operate near explosive or flammable materials
- Inspect cables for damage prior to use
- Do not operate butt welder with exterior cover removed



## WARNING

**THIS WELDING MACHINE MUST BE CONNECTED TO POWER SOURCE IN ACCORDANCE WITH APPLICABLE ELECTRICAL CODES.**



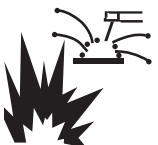
## ELECTRIC SHOCK CAN KILL

- Do not touch electrically live parts or electrode with skin or wet clothing.
- Insulate your self from work and ground.
- Always wear dry insulating gloves.
- Turn off arc welding power source before performing butt welder operation.
- **CAUTION:** Parts may be at welding voltage during butt welding operation.



## FUMES AND GASSES CAN BE DANGEROUS

- Keep your head out of fumes.
- Use enough ventilation or exhaust at the arc, or both, to remove fumes and gases from your breathing zone and general area.



## WELDING SPARKS CAN CAUSE FIRE OR EXPLOSION.

- Keep flammable material away.
- Do not weld on containers which have held flammable material.



## ARC RAYS CAN BURN.

- Wear eye, ear and body protection.



## MOVING PARTS CAN INJURE.

- Turn off arc welding power source before performing butt welder operation.
- Do not operate with panel open or guards off.

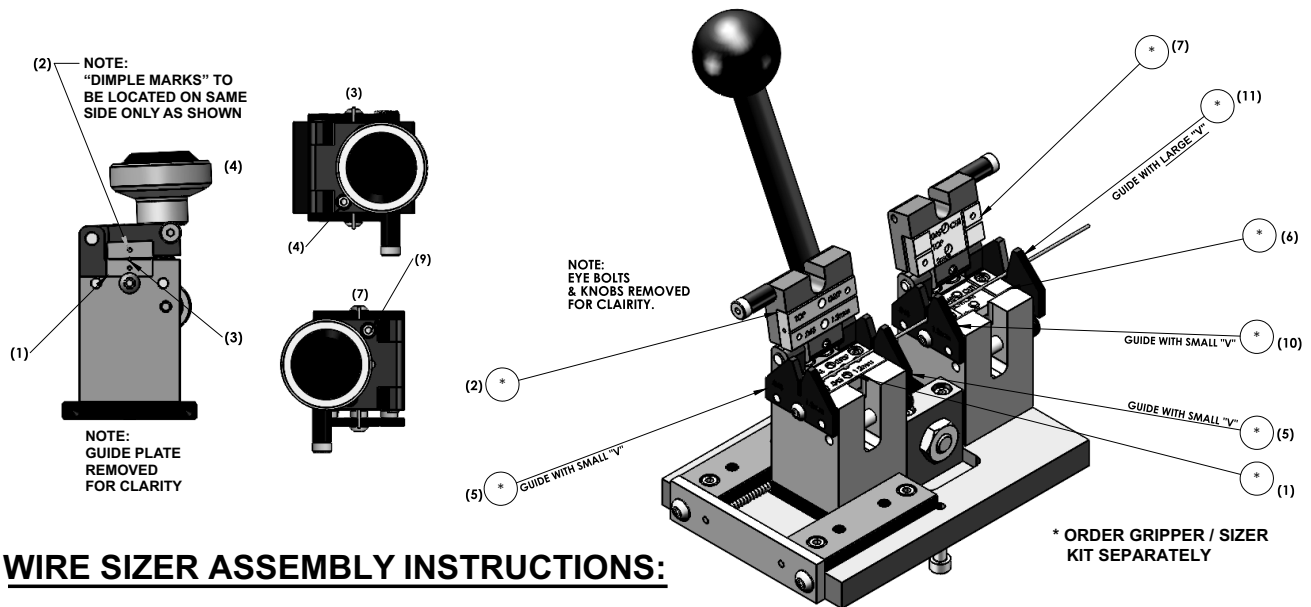


# INSTALLATION

## TECHNICAL SPECIFICATIONS

<b>Weight:</b> 100 lbs / 45.4 kg	<b>Wire Compatibility:</b> .030 to .078 (0.8 to 2 mm) ferrous wire
<b>Dimensions:</b> 20" W x 24" L x 42"H / 508 x 610 x 1067 mm	<b>Power Requirements:</b> 120V, 5 Amps

## WIRE SIZER FLASH REMOVAL TOOL (Optional Accessory)



## WIRE SIZER ASSEMBLY INSTRUCTIONS:

### "GRIP" SIDE OF TOOL ASSEMBLY INSTRUCTIONS:

1. PLACE "BOTTOM GRIP" DIE OVER DOWEL PINS & TIGHTEN BOLTS IN PLACE.
2. PLACE "TOP GRIP" DIE IN SWING COVER OVER DOWEL PINS & ASSEMBLE WITH BOLTS BUT DO NOT TIGHTEN.
3. PLACE .045 GAGE PIN IN "BOTTOM GRIP" DIE, SWING OVER COVER AND ALIGN "TOP GRIP" DIE ON GAGE PIN & LIGHTLY TIGHTEN HAND KNOB (1-TURN).
4. TIGHTEN BOLTS ON SWING COVER TO SECURE "TOP GRIP" DIE, UN-TIGHTEN HAND KNOB, OPEN SWING COVER AND REMOVE GAGE PIN.
5. PLACE GUIDE PLATES (REF. SMALL "V") ON BOTH SIDES OF CENTER BLOCK OVER DOWEL PINS AND MOUNT WITH CENTER SCREW.

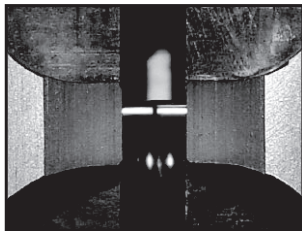
### "CUT (SIZER)" SIDE OF TOOL ASSEMBLY INSTRUCTIONS:

6. PLACE "BOTTOM CUT" DIE OVER DOWEL PINS & TIGHTEN BOLTS IN PLACE.
7. PLACE "TOP CUT" DIE IN SWING COVER OVER DOWEL PINS & ASSEMBLE WITH BOLTS BUT DO NOT TIGHTEN.
8. PLACE .046 GAGE PIN IN "BOTTOM CUT" DIE, SWING OVER COVER AND ALIGN "TOP CUT" DIE ON GAGE PIN & LIGHTLY TIGHTEN HAND KNOB (1-TURN).
9. TIGHTEN BOLTS ON SWING COVER TO SECURE "TOP CUT" DIE, UN-TIGHTEN HAND KNOB, OPEN SWING COVER AND REMOVE GAGE PIN.
10. PLACE GUIDE PLATE (REF. SMALL "V") ON LEFT SIDE OF CENTER BLOCK OVER DOWEL PINS (NO SPACERS) AND MOUNT WITH CENTER SCREW.
11. PLACE GUIDE PLATE (REF. LARGE "V") ON RIGHT SIDE OF CENTER BLOCK OVER DOWEL PINS (WITH SPACERS) AND MOUNT WITH CENTER SCREW.
12. TEST: PLACE .045 GAGE PIN IN "BOTTOM CUT" DIE, SWING OVER COVER AND CLAMP CLOSED WITH HAND KNOB, GAGE PIN SHOULD MOVE FREELY THRU DIES.

# OPERATION

## BUTT WELDING INSTRUCTIONS:

1. Ensure the Wire Size Select switch is in the OFF position (center). Connect Butt Welder to power supply.
2. Pull down both locking knobs to open wire clamps.
3. Pull and turn the Weld/Open switch to the "Open" position.
4. Snip off each end of the wire using a pair of Wire Parters (included). Insert each wire end in groove until centered in the space between the 2 jaws. Lock wire into place one side at a time by pulling the locking knobs back into place. Ensure the wire butts are flat, evenly aligned, and touching. This helps ensure that there is enough force/contact to make a good weld.



**IMPORTANT!**  
Ensure wire ends are evenly aligned prior to butt welding.

5. Turn the Weld/Open switch to the "Weld" position.
6. Turn switch on base unit to appropriate setting for wire size.
7. Press and hold green Cycle Start button on the front panel to weld the wire ends together (there will be a slight delay). If the Reset is popped out, push back in to weld.



### CAUTION

Keep hands clear of butt welder components and wire when welding.

8. Place Wire Size Select back to off (Center) position after welding operation. Open wire clamps by pulling down both locking knobs. Remove wire.



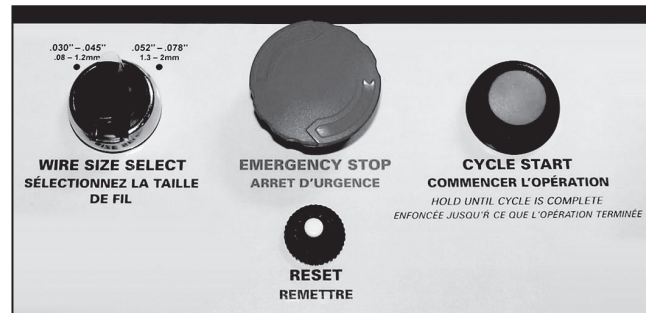
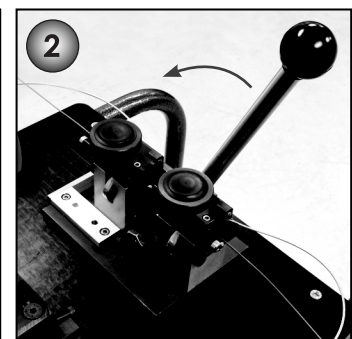
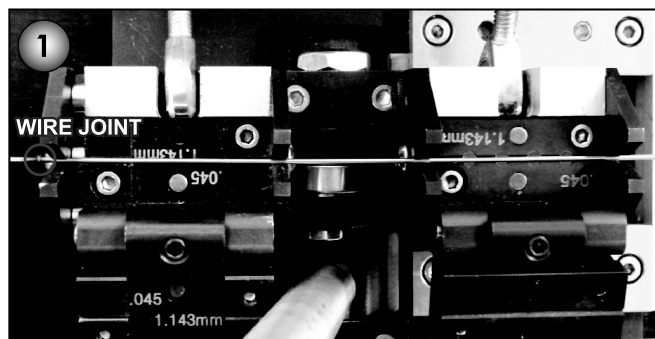
### CAUTION

Wire may be hot!

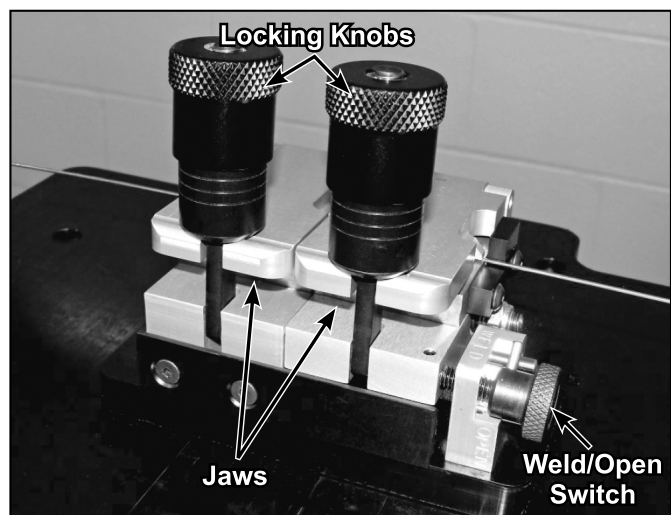
9. Remove the burr in the wire joint using the optional Wire Sizer (see below) or other method of creating a smooth joint. Check the joint using the Wire Gage Block to ensure smooth wire feeding.
10. Insert wire onto pathway between the two wire packages. Repeat process when replacing empty boxes.

## Burr Removal from Wire Joint using the Wire Sizer (Optional Accessory)

To remove the burr in the wire joint, open clamps on the wire sizer and position wire as shown in step 1. The joint should be in the gap on the left side (circled). Close and tighten clamps. Pull the handle firmly to the right to remove the burr. Unlock the clamps and remove wire.



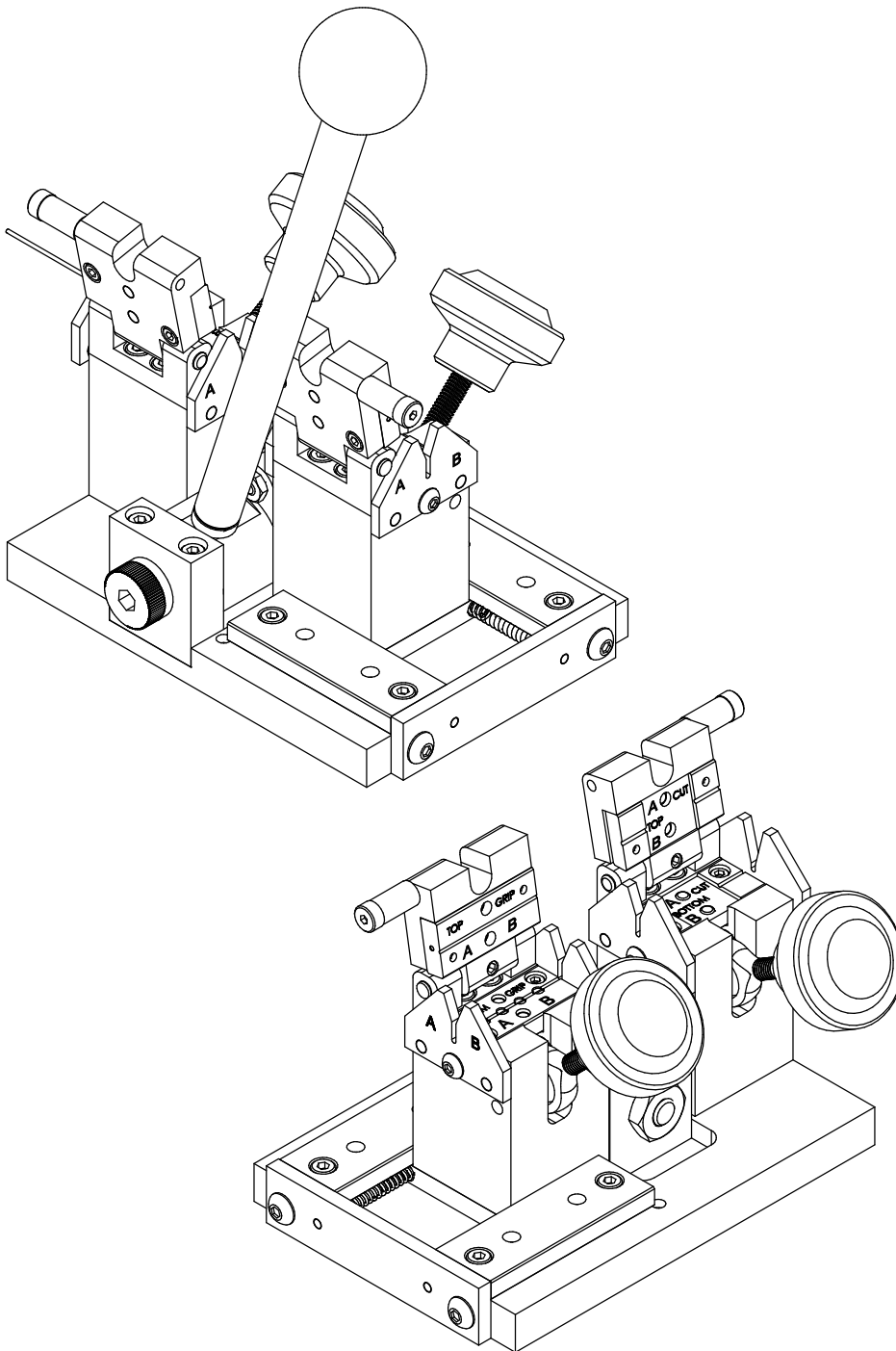
Control Panel



Butt Welder

# ACCESSORIES

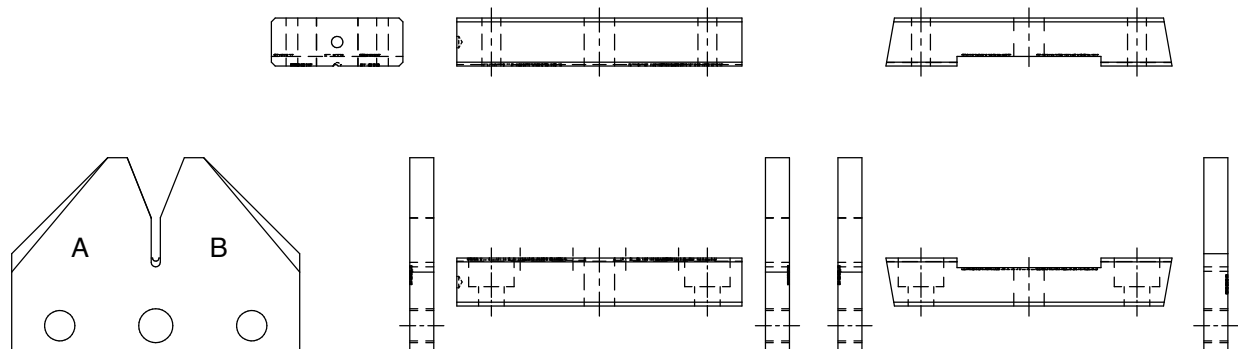
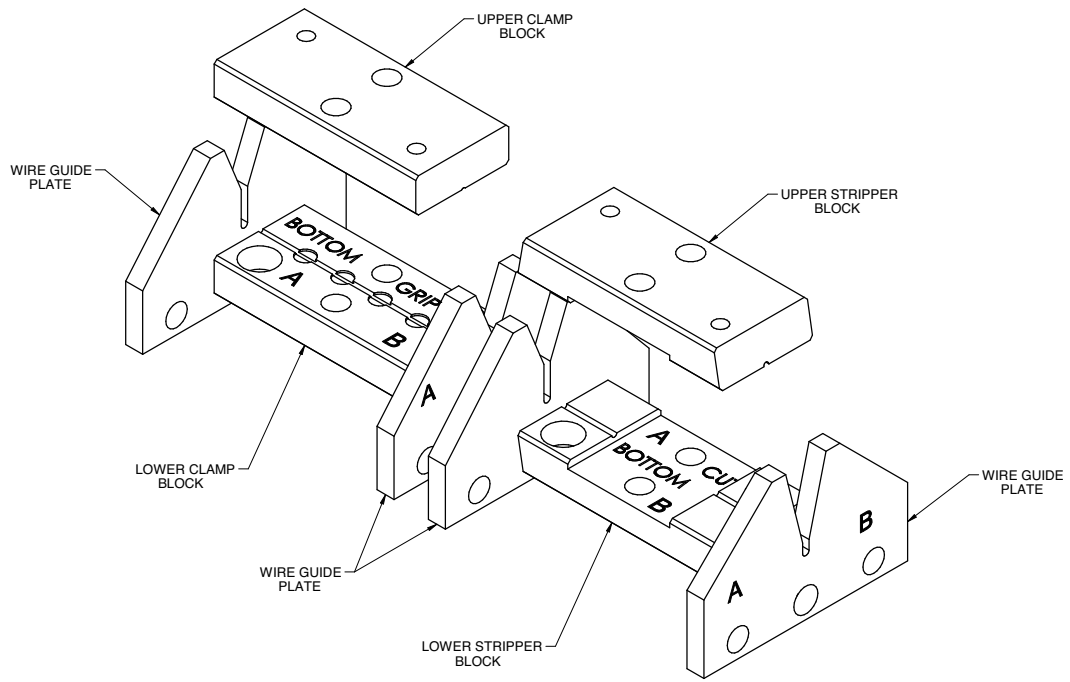
## WIRE SIZER ASSEMBLY W/ DIES



WIRE SIZER LEVER  
NOT SHOWN IN THIS VIEW.

WIRE SIZER ASSEMBLY W/ DIES INCLUDED				
BUY AS PRODUCT NUMBER	VENDOR PART NUMBER	DESCRIPTION	A	B
K3910-1	NSW-BW-WS-035	WIRE SIZER w/.035" (.9mm) DIES	.035	0.9mm
K3913-1	NSW-BW-WS-045	WIRE SIZER w/.045" (1.2mm) DIES	.045	1.2mm
K3914-1	NSW-BW-WS-052	WIRE SIZER w/.052" (1.3mm) DIES	.052	1.3mm
K3917-1	NSW-BW-WS-062	WIRE SIZER w/.062" (1.6mm) DIES	.062	1.6mm
K3919-1	NSW-BW-WS-078	WIRE SIZER w/.078" (2.0mm) DIES	.078	2.0mm

WIRE SIZER DIES



WIRE SIZER DIES				
BUY AS PRODUCT NUMBER	VENDOR PART NUMBER	DESCRIPTION	A	B
K3911-1	NSW-BW-WS-035-GRIPPER	WIRE SIZER DIES FOR .035" (.9mm) WIRE	.035	0.9mm
K3912-1	NSW-BW-WS-045-GRIPPER	WIRE SIZER DIES FOR .045" (1.2mm) WIRE	.045	1.2mm
K3915-1	NSW-BW-WS-052-GRIPPER	WIRE SIZER DIES FOR .052" (1.3mm) WIRE	.052	1.3mm
K3918-1	NSW-BW-WS-062-GRIPPER	WIRE SIZER DIES FOR .062" (1.6mm) WIRE	.062	1.6mm
K3920-1	NSW-BW-WS-078-GRIPPER	WIRE SIZER DIES FOR .078" (2.0mm) WIRE	.078	2.0mm

# MAINTENANCE

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**SAFETY PRECAUTIONS:**

- Do not touch the wire or butt welder components during the butt welding cycle
- Protective gloves and safety glasses are required when operating this unit
- Do not operate near explosive or flammable materials
- Inspect cables for damage prior to use
- Do not operate butt welder with exterior cover removed

**WARNING**

**THIS WELDING MACHINE MUST BE CONNECTED TO  
POWER SOURCE IN ACCORDANCE WITH APPLICABLE  
ELECTRICAL CODES.**

**MAINTENANCE:**

The Docking Station Butt Welder is generally maintenance free. Cables should be inspected for damage periodically and replaced as needed. If dirty, the butt welder jaws may be wiped clean with a dry rag (do not allow moisture to come in contact with any components).



# TROUBLESHOOTING

## HOW TO USE TROUBLESHOOTING GUIDE

### WARNING

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

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

#### **Step 1. LOCATE PROBLEM (SYMPTOM).**

Look under the column labeled "PROBLEM (SYMPTOMS)". This column describes possible symptoms that the machine may exhibit. Find the listing that best describes the symptom that the machine is exhibiting.

#### **Step 2. RECOMMENDED COURSE OF ACTION**

This column provides a course of action for the Possible Cause, generally it states to contact your local Lincoln Authorized Field Service Facility.

#### **Step 3. CONTACT YOUR LOCAL LINCOLN AUTHORIZED FIELD SERVICE FACILITY**

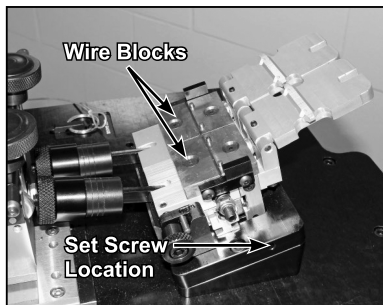
If you do not understand or are unable to perform the Recommended Course of Action safely, contact your local Lincoln Authorized Field Service Facility.

### CAUTION

If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your **Local Lincoln Authorized Field Service Facility** for technical troubleshooting assistance before you proceed.

## Observe all Safety Guidelines detailed throughout this manual

PROBLEM (SYMPTOMS)	RECOMMENDED COURSE OF ACTION
Unit does not power on	<ul style="list-style-type: none"> <li>• Ensure power cable is connected and power source is functioning properly</li> <li>• Press reset button if it has been engaged (popped out)</li> </ul>
Wire does not weld	<ul style="list-style-type: none"> <li>• Check power connection and reset button</li> <li>• Wire ends are not in contact when the weld button is pressed. Open jaws and ensure wire ends are in contact and attempt weld again.</li> <li>• Turn wire block set screw (see photo below) counter-clockwise a quarter turn and attempt weld again, continue to turn the screw in even increments and attempt weld again if the first retry fails.</li> </ul>
Wire ends weld unevenly	<ul style="list-style-type: none"> <li>• Snip each wire end with the wire parters and retry weld. Ensure the wire ends are in contact and evenly aligned prior to welding.</li> <li>• If wire grooves appear uneven, adjust screws on the wire blocks until they are level (see photo below)</li> </ul>
Butt welder continues to cycle after weld is complete (wire will glow red and become extremely hot)	<ul style="list-style-type: none"> <li>• Immediately deactivate by pressing the Emergency Stop button</li> <li>• Turn set screw (see photo below) clockwise a quarter turn and attempt weld again, continue to turn the screw in even increments and attempt weld again if the unit is still getting stuck</li> <li>• Contact customer service, unit may require servicing</li> </ul>
Reset button continues to engage	<ul style="list-style-type: none"> <li>• Ensure there are no problems with the power source connected to the unit</li> <li>• Contact customer service, unit may require servicing</li> </ul>



**Note:** Adjustment of the wire blocks / set screw is only necessary when troubleshooting.

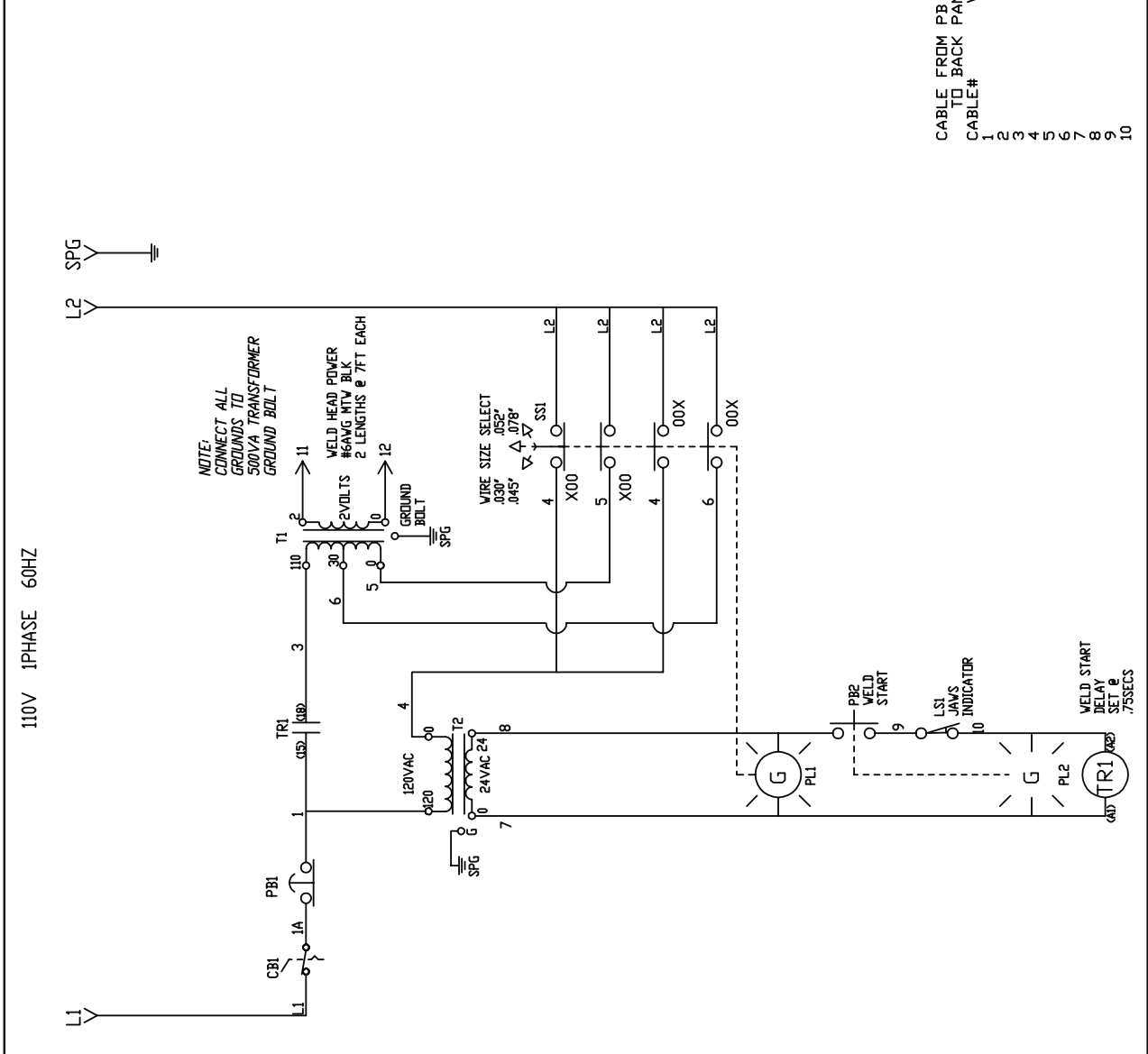
### ⚠ CAUTION

If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your **Local Lincoln Authorized Field Service Facility** for technical troubleshooting assistance before you proceed.



DOCKING STATION BUTT WELDER WIRING DIAGRAM (K3921-1)

ITEM	QTY	DESCRIPTION
PB1	1	RED MUSHROOM TWIST/PULL BUTTON
PB2	1	GREEN ILLUMINATED BUTTON
PL2	1	24VAC/DC GREEN LED
PB2	1	N.O. CONTACT BLOCK
ICB	1	SINGLE POLE SAMP CIRCUIT BREAKER
TR1	1	12VDC DPDT CUBE RELAY
TR1	1	RELAY BASE
TR1	1	RELAY TIMER MODULE
SS1	1	3PDS GREEN ILLUMINATED SELECTOR SWITCH
PL1	1	3 ACROSS LATCH W/24V LIGHT MODULE
SS1	4	SINGLE N.O. CONTACT BLOCK
T1	1	500VA 0/-30/110/220PRI-2SEC TRANSFORMER
T2	1	5VA 110PRI-6/12/24SEC TRANSFORMER
LS1	1	SPDT MINATURE LIMIT SWITCH





## **CUSTOMER ASSISTANCE POLICY**

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customer's particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

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