PRECISION TIG WIRING DIAGRAM G5646 REV: A

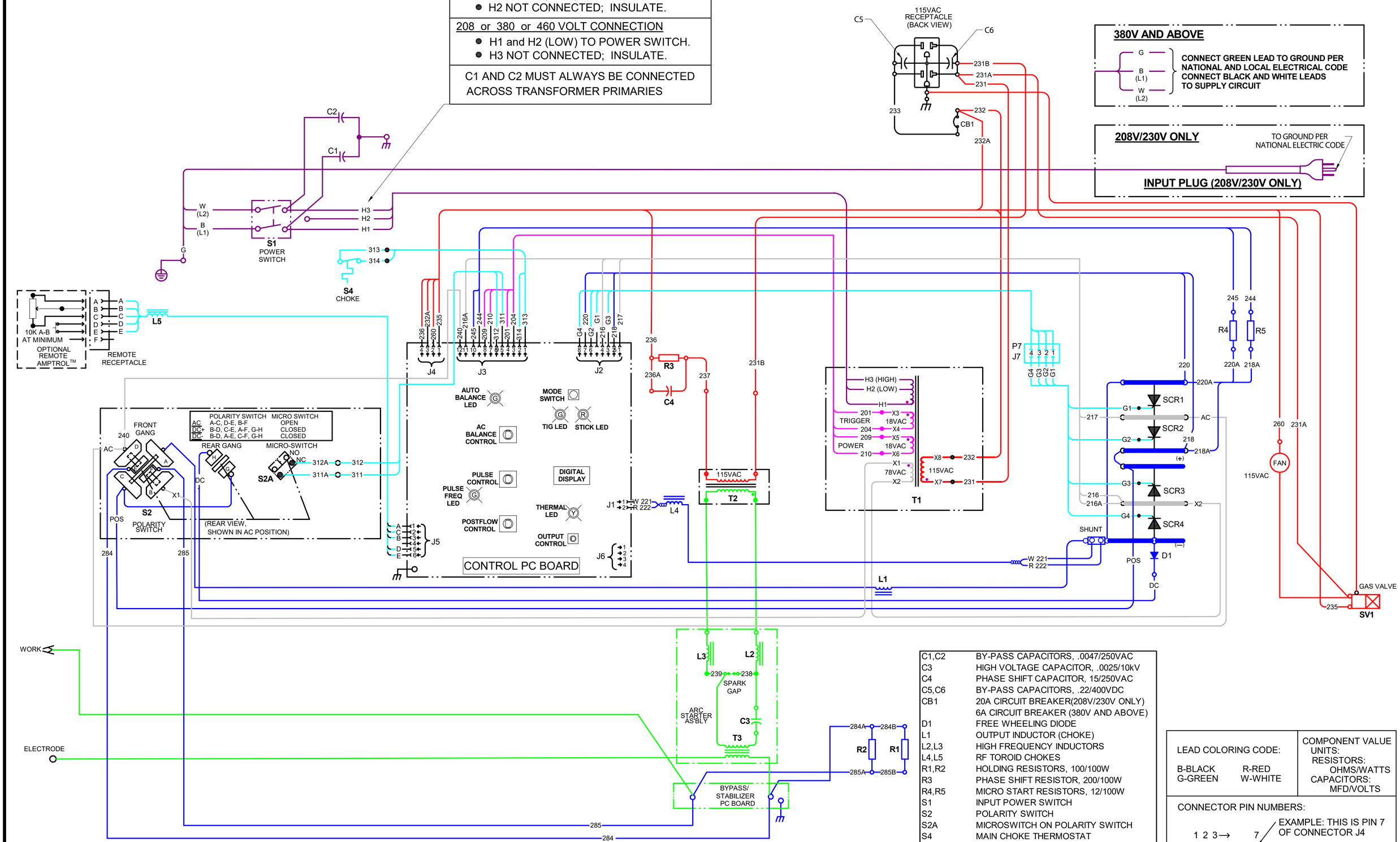
VOLTAGE RECONNECTION

SEE RATING PLATE FOR SPECIFIC VOLTAGES

230 or 400-415 or 575 VOLT CONNECTION
(AS SHOWN & AS SHIPPED FROM FACTORY)
- H1 and H3 (HIGH) TO POWER SWITCH.
- H2 NOT CONNECTED; INSULATE.

208 or 380 or 460 VOLT CONNECTION
- H1 and H2 (LOW) TO POWER SWITCH.
- H3 NOT CONNECTED; INSULATE.

C1 AND C2 MUST ALWAYS BE CONNECTED ACROSS TRANSFORMER PRIMARIES



C1,C2	BY-PASS CAPACITORS, .0047/250VAC
C3	HIGH VOLTAGE CAPACITOR, .0025/10kV
C4	PHASE SHIFT CAPACITOR, 15/250VAC
C5,C6	BY-PASS CAPACITORS, .22/400VDC
CB1	20A CIRCUIT BREAKER(208V/230V ONLY)
	6A CIRCUIT BREAKER (380V AND ABOVE)
D1	FREE WHEELING DIODE
L1	OUTPUT INDUCTOR (CHOKE)
L2,L3	HIGH FREQUENCY INDUCTORS
L4,L5	RF TOROID CHOKES
R1,R2	HOLDING RESISTORS, 100/100W
R3	PHASE SHIFT RESISTOR, 200/100W
R4,R5	MICRO START RESISTORS, 12/100W
S1	INPUT POWER SWITCH
S2	POLARITY SWITCH
S2A	MICROSWITCH ON POLARITY SWITCH
S4	MAIN CHOKE THERMOSTAT
SCR1,2,3,4	MAIN POWER SCR'S
SV1	GAS SOLENOID VALVE, 115VAC
T1	MAIN TRANSFORMER
T2	HIGH VOLTAGE TRANSFORMER
T3	HIGH FREQUENCY TRANSFORMER

LEAD COLORING CODE:

B-BLACK R-RED
G-GREEN W-WHITE

COMPONENT VALUE UNITS:
RESISTORS: OHMS/WATTS
CAPACITORS: MFD/VOLTS

CONNECTOR PIN NUMBERS:

1 2 3→ 7
8→ 14
J4
LATCH

EXAMPLE: THIS IS PIN 7 OF CONNECTOR J4

VIEW OF CONNECTOR ON PC BOARD

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LINCOLN ELECTRIC

CLEVELAND , OHIO