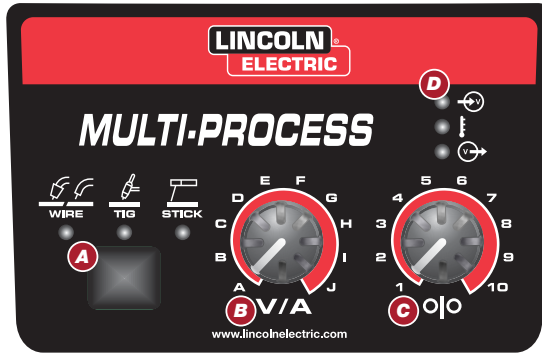


# Multi-Process Welder

**LINCOLN**  
ELECTRIC

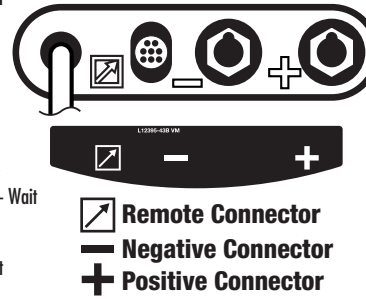
## Quick Start Guide



Before you weld - refer to <http://www.lincolnelectric.com/safety> for additional safety information.

- A Weld Mode Selector**
- B Voltage/Amperage**
- C Wire Feed Speed**
- D Status Indicators**

- Machine is powered ON.
- Duty Cycle Exceeded - Wait for Machine to reset, or Error Detected.
- Caution: Voltage Output is Enabled.



- Remote Connector
- Negative Connector
- Positive Connector



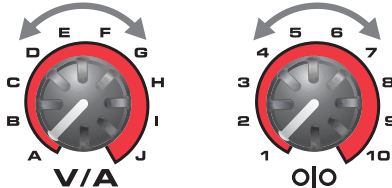
## MIG | FCAW | Spool Gun Setup

### 1. MIG Mode Selection and Settings



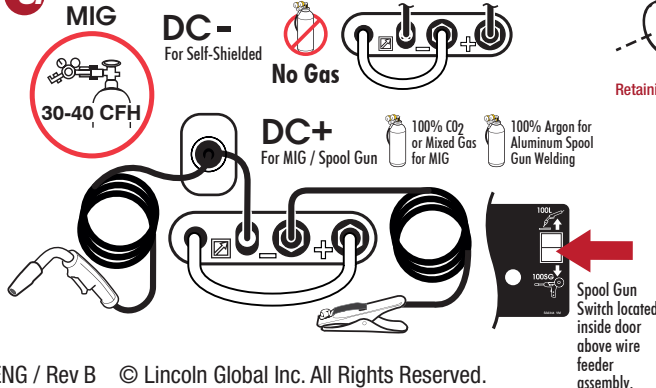
Press Weld Mode Selector Button to navigate to "WIRE"

### 2. Output Voltage and Wire Feed Speed



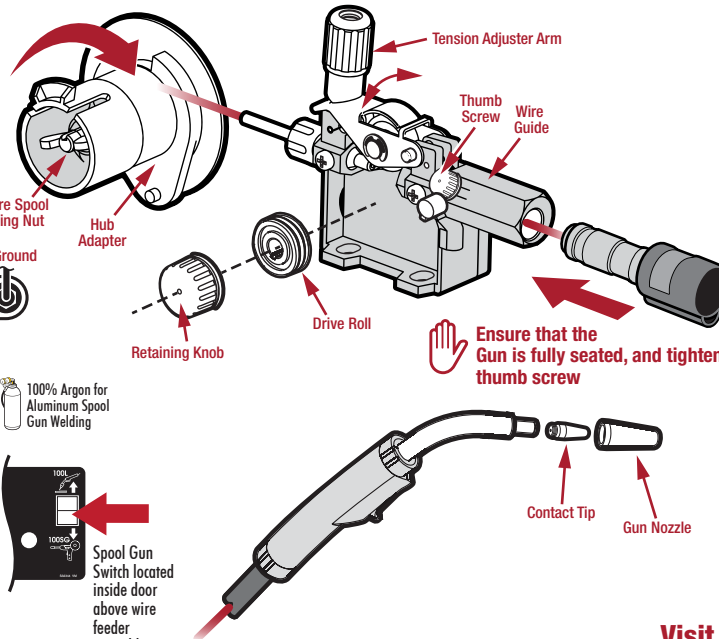
Determine the wire type and plate thickness, and use the "Procedures and Settings" chart inside the wire feeder door to set the "V/A" letter and Wire Feed Speed number.

### 3. Connecting the Gun



### Wire Spool Installation

- Release tension adjuster arm.
- Unscrew retaining knob.
- Ensure proper drive roll is installed: .025 for .025 — .035 for .030/.035
- Hand tighten retaining knob.
- Position the wire spool so that the wire feeds off the top of the spool. Hub adapter required for large spools.
- Secure spool in place by tightening the wing nut against the spacer enough to cause a light drag on the spool, do not overtighten.
- Guide wire over drive roll and into gun liner.
- Return tension adjuster arm to re-engage.
- Take off nozzle and contact tip from gun, hold trigger until wire comes out approximately 4" past the gun tube end. **Welder output is electrically hot while trigger is pressed.**
- Release trigger and replace nozzle and tip.



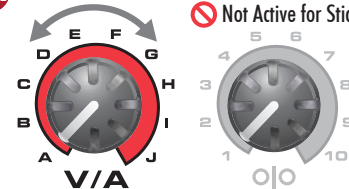
## Stick Setup

### 1. Stick Mode Selection



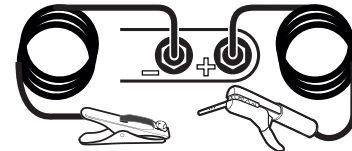
Select "STICK"

### 2. Output Amperage



Choose an electrode and plate thickness, and use the "Procedures and Settings" chart on the door to set the "V/A" letter.

### 3. Connecting the Electrode Holder



**Note:** DC - Polarity may be used for thin materials.



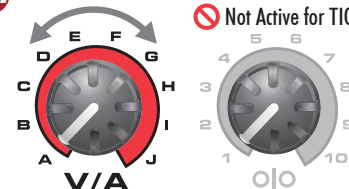
## TIG Setup

### 1. TIG Mode Selection



Select "TIG"

### 2. Output Amperage

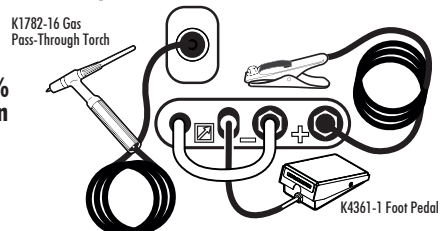


Choose a tungsten diameter and plate thickness, and use the "Procedures and Settings" chart on the door to set the "V/A" letter.

### 3. Connecting the TIG Torch



100% Argon

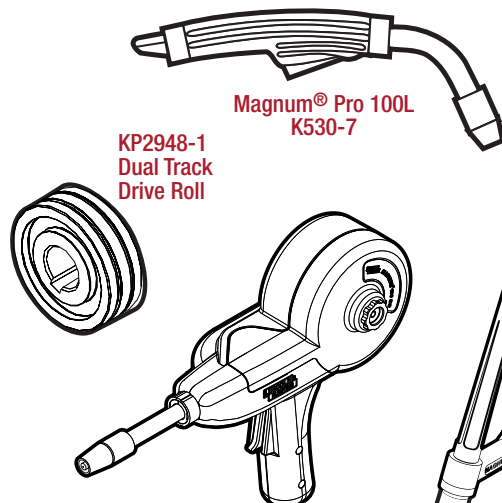
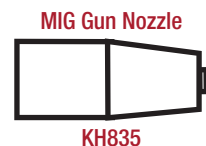
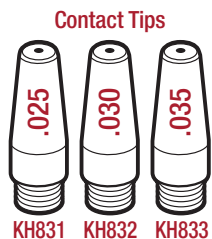


# Multi-Process Welder

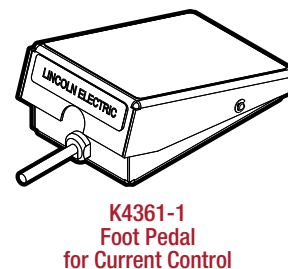
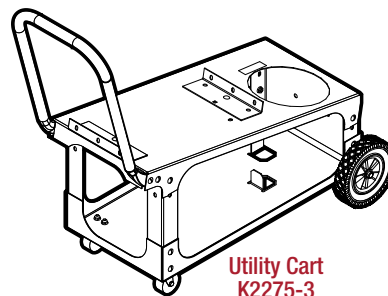
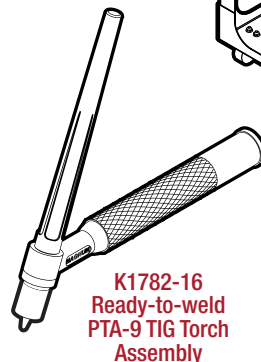
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## Quick Start Guide

### Accessories

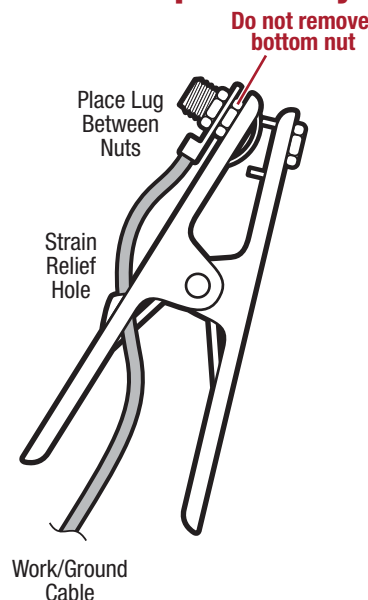


Magnum® Pro 100SG Spool Gun  
For Aluminum Welding  
K4360-1

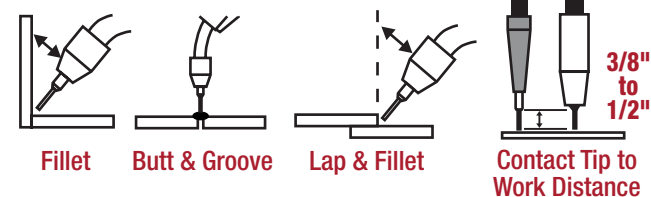


Description	Part Number
Replacement .025/ .030/ .035 Drive Roll For MIG & Flux Cored	KP2948-1
.030/ .035/ .045 Drive Roll For Flux Cored Only	KP3285-1
Replacement Gas Nozzle for MIG	KH835
Replacement Gasless Nozzle for Flux Cored	KH836
Gas Diffuser	KP3076-1
.025 Contact Tip	KH831
.030 Contact Tip	KH832
.035 Contact Tip	KH833
Replacement .025-.035 Liner	KP35-40-15
Replacement Magnum® Pro 100L Gun	K530-7
Foot Pedal For Adjusting Output While TIG Welding	K4361-1
Ready-to-weld PTA-9 TIG Torch Assembly	K1782-16
Magnum® Pro 100SG Spool Gun For Aluminum Welding	K4360-1
Utility Cart	K2275-3

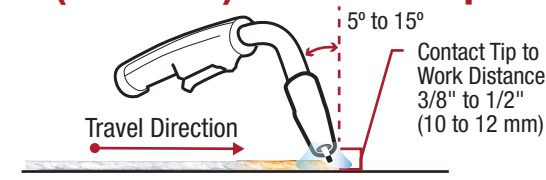
### Work Clamp Assembly



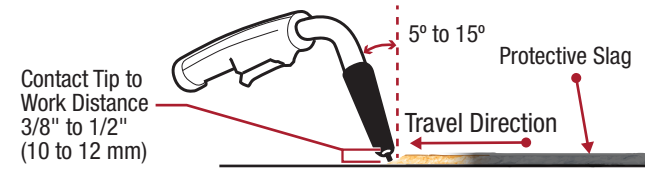
### Gun Positions



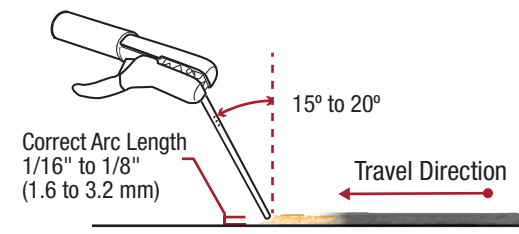
### MIG (Solid Wire) - Push Technique



### Flux Cored (Self-Shielded) - Drag Technique



### Stick - Drag Technique



### TIG - Push Technique

