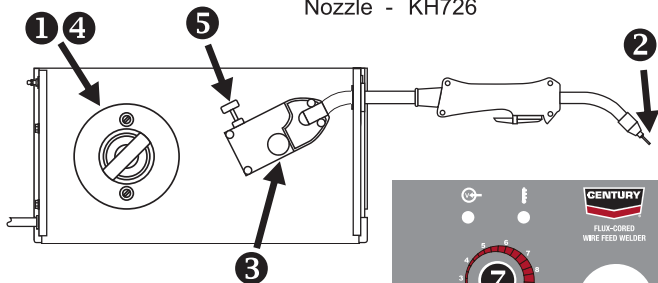


FCAW — Gasless (Flux Cored)

Welding Wire ①	.035 NR-211-MP (Innershield Cored Wire)		
Contact Tip ②	.035 (0.9mm) - Part No. KH712		
Drive Roll ③	0.9mm Knurled groove - Part No. KP4364-035		
Loading The Wire ④	Remember: Remove the contact tip prior to loading wire Keep tension on the wire to prevent unspooling.		
	1. Cutoff the bent portion of the wire and straighten the first 4" for feeding into rolls and gun. 2. Release spring loaded pressure arm and rotate the Idle Roll Arm away from Drive Roll. 3. Thread wire through the guide tube, over drive roll and into gun liner. Close Idle Roll arm.		
Wire Feed Tension ⑤	The suggested Wire Feed Speed settings in the table below are based on a midrange wire tension setting. The tension may be changed if required to improved wire feeding; however, the WFS setting may have to be adjusted from the values in the table below.		
Suggested Settings For Welding	Steel Thickness	Wire Feed Speed ⑥	Heat Range ⑦
	18 Ga Steel	6	5
	16 Ga Steel	6.5	6
	14 Ga Steel	7.5	7
	12 Ga Steel	8	8
	1/8" Steel	8.5	8.5
Helpful Hints	Weld at a Steady Pace Do NOT weave the arc, neither forward, backward, or sideways Remove Slag with the Chipping Hammer to expose weld For Horizontal Weld Joints, remember: "Drag if there's Slag" Refer to Manual for Troubleshooting Poor Weld Quality		

Nozzle - KH726



⚠ WARNING

When the welding power source is on and the gun trigger is depressed, drive rolls, wire reel and electrode are **ELECTRICALLY HOT**.

