ITEM# 200

QUICK START GUIDE

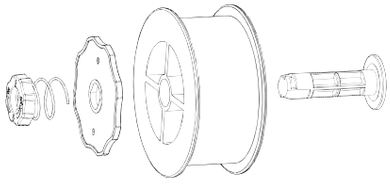
Forney

1.

Read User Manual



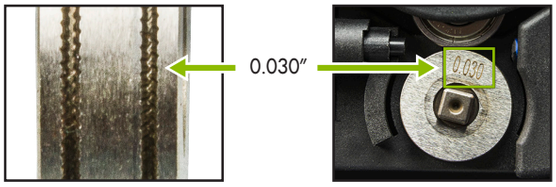
2. Install 2 lb. Wire Spool



See manual for detailed installation instructions.

3. Set Drive Roll

Ensure the 0.030" wire diameter is visible on the drive roll when installed.

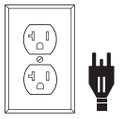


4. Set Drive Roll Pressure

For proper tension align the tops of the screw and nut together.



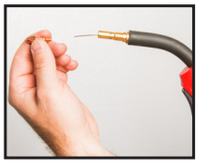
5. Connect to 120V Input Power



- Generator Safe: Use power source with 4000W of continuous output, no low-idle, 5% THD max.
- Extension Cord: #12 AWG or larger, 25' (8m) or shorter.

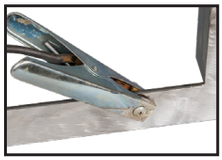
6. Feed Wire

Remove consumables and depress trigger until wire comes out. Replace consumables.



7. Ground Workpiece

Connect ground clamp to clean, bare metal.



8. Adjust Settings

Adjust the wire feed speed (-8-) and voltage (Ⓥ). See the chart on the welder for correct settings.



9. Begin Welding

With contact tip 1/4" from metal, depress trigger completely to initiate arc.



FIND MORE INFORMATION AT FORNEYIND.COM

QUESTIONS OR TROUBLE?
Contact Forney Industries at 1-800-521-6038 customerservice@forneyind.com forneyind.com

ITEM# 200

QUICK START GUIDE

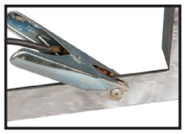
FLUX-CORED TROUBLESHOOTING TIPS

Do Not Weld Aluminum



- Welding aluminum requires shielding gas. This machine is only for gas-less flux-cored welding.
- This machine cannot connect to a spool gun, which is recommended for aluminum.

Workpiece Grounding



Connect the ground clamp to clean, bare metal. No rust, paint or other coatings. Attach the ground clamp directly to the workpiece if you are experiencing issues.

Too Much Spool Tension

Wire from spool to drive should relax with a slight curve after feeding.





Incorrect Drive Roll Pressure

Too little pressure = Roll can slip and feed can be erratic.

Too much pressure = can crush wire, causing wire feeding problems and welder damage.



Frequently Tripping Circuit Breaker or Exceeding Duty Cycle

Trying to weld single pass on material larger than 3/16" (4,78mm) thick is not possible with this machine. Multi-pass recommended for thicker materials.

Welder should be the only thing plugged into the circuit.

Low Weld Output or Poor Fusion

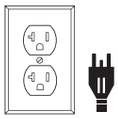
- Usually due to low input power.
- Welder should be only thing plugged into circuit.
- Avoid using extension cords. If one must be used, it must be #12 AWG or larger; 25' (8m) or shorter.
- Generators must be 4000W continuous output and not have a low-idle function (or have it disabled).

Solid Green AND Solid Yellow Lights



Duty cycle exceeded or insufficient air flow. Allow machine to cool.

Incorrect input power. Verify power source is 120V +/- 10%.



Solid Green AND Flashing Yellow Lights



The gun was triggered when the machine was powered on. Release the trigger.

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