THERMAL ARC®

181i

FABRICATOR

3 IN 1 MULTI-PROCESS WELDING SYSTEMS

Operating Manual

Revision: AB **Issue Date:** April 24, 2012 **Manual No.:** 0-5191

Operating Features:

INVERTER | GMAW FCAW | GTAW | SMAW | 180 AMP | CC CV | DC | 230 V | 1 PHASE

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Intertek
3163339

WE APPRECIATE YOUR BUSINESS!

Congratulations on your new Thermal Arc product. We are proud to have you as our customer and will strive to provide you with the best service and reliability in the industry. This product is backed by our extensive warranty and world-wide service network. To locate your nearest distributor or service agency call 1-800-462-2782 (USA) and 1-905-827-4515 (Canada), or visit us on the web at **www.Thermalarc.com**

This Operating Manual has been designed to instruct you on the correct use and operation of your Thermal Arc product. Your satisfaction with this product and its safe operation is our ultimate concern. Therefore please take the time to read the entire manual, especially the Safety Precautions. They will help you to avoid potential hazards that may exist when working with this product. We have made every effort to provide you with accurate instructions, drawings, and photographs of the product(s) we used when writing this manual. However errors do occur and we apologize if there are any contained in this manual.

Due to our constant effort to bring you the best products, we may make an improvement that does not get reflected in the manual. If you are ever in doubt about what you see or read in this manual with the product you received, then check for a newer version of the manual on our website or contact our customer support for assistance.

YOU ARE IN GOOD COMPANY!

The Brand of Choice for Contractors and Fabricators Worldwide.

Thermal Arc is a Global Brand of Arc Welding Products for Thermadyne Industries Inc. We manufacture and supply to major welding industry sectors worldwide including; Manufacturing, Construction, Mining, Automotive, Aerospace, Engineering, Rural and DIY/Hobbyist.

We distinguish ourselves from our competition through market-leading, dependable products that have stood the test of time. We pride ourselves on technical innovation, competitive prices, excellent delivery, superior customer service and technical support, together with excellence in sales and marketing expertise.

Above all, we are committed to develop technologically advanced products to achieve a safer working environment within the welding industry.

WARNINGS

Read and understand this entire Manual and your employer's safety practices before installing, operating, or servicing the equipment.

While the information contained in this Manual represents the Manufacturer's best judgment, the Manufacturer assumes no liability for its use.

Operating Manual Number 0-5191 for:

Thermal Arc Fabricator 181i Portable System Package	Part Number W1003181
Thermal Arc Fabricator 181i Power Source	Part Number W1003180
Thermal Arc Fabricator 181i Portable System Package with Cart	Part Number W1003182

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Record the following information for Warranty purposes:

Where Purchased: _____

Purchase Date: _____

Equipment Serial #: _____

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SAFETY INSTRUCTIONS AND WARNINGS

WARNING

PROTECT YOURSELF AND OTHERS FROM POSSIBLE SERIOUS INJURY OR DEATH. KEEP CHILDREN AWAY. PACEMAKER WEARERS KEEP AWAY UNTIL CONSULTING YOUR DOCTOR. DO NOT LOSE THESE INSTRUCTIONS. READ OPERATING/INSTRUCTION MANUAL BEFORE INSTALLING, OPERATING OR SERVICING THIS EQUIPMENT.

Welding products and welding processes can cause serious injury or death, or damage to other equipment or property, if the operator does not strictly observe all safety rules and take precautionary actions.

Safe practices have developed from past experience in the use of welding and cutting. These practices must be learned through study and training before using this equipment. Some of these practices apply to equipment connected to power lines; other practices apply to engine driven equipment. Anyone not having extensive training in welding and cutting practices should not attempt to weld.

Safe practices are outlined in the American National Standard Z49.1 entitled: SAFETY IN WELDING AND CUTTING. This publication and other guides to what you should learn before operating this equipment are listed at the end of these safety precautions. **HAVE ALL INSTALLATION, OPERATION, MAINTENANCE, AND REPAIR WORK PERFORMED ONLY BY QUALIFIED PEOPLE.**

1.01 Arc Welding Hazards

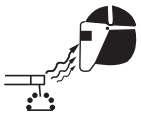
WARNING

ELECTRIC SHOCK can kill.

Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on. The input power circuit and machine internal circuits are also live when power is on. In semi-automatic or automatic wire welding, the wire, wire reel, drive roll housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is a hazard.

1. Do not touch live electrical parts.
2. Wear dry, hole-free insulating gloves and body protection.
3. Insulate yourself from work and ground using dry insulating mats or covers.
4. Disconnect input power or stop engine before installing or servicing this equipment. Lock input power disconnect switch open, or remove line fuses so power cannot be turned on accidentally.
5. Properly install and ground this equipment according to its Owner's Manual and national, state, and local codes.
6. Turn off all equipment when not in use. Disconnect power to equipment if it will be left unattended or out of service.
7. Use fully insulated electrode holders. Never dip holder in water to cool it or lay it down on the ground or the work surface. Do not touch holders connected to two welding machines at the same time or touch other people with the holder or electrode.
8. Do not use worn, damaged, undersized, or poorly spliced cables.
9. Do not wrap cables around your body.
10. Ground the workpiece to a good electrical (earth) ground.
11. Do not touch electrode while in contact with the work (ground) circuit.
12. Use only well-maintained equipment. Repair or replace damaged parts at once.
13. In confined spaces or damp locations, do not use a welder with AC output unless it is equipped with a voltage reducer. Use equipment with DC output.
14. Wear a safety harness to prevent falling if working above floor level.

15. Keep all panels and covers securely in place.



WARNING

ARC RAYS can burn eyes and skin; NOISE can damage hearing. Arc rays from the welding process produce intense heat and strong ultraviolet rays that can burn eyes and skin. Noise from some processes can damage hearing.

1. Wear a welding helmet fitted with a proper shade of filter (see ANSI Z49.1 listed in Safety Standards) to protect your face and eyes when welding or watching.
2. Wear approved safety glasses. Side shields recommended.
3. Use protective screens or barriers to protect others from flash and glare; warn others not to watch the arc.
4. Wear protective clothing made from durable, flame-resistant material (wool and leather) and foot protection.
5. Use approved ear plugs or ear muffs if noise level is high.

WARNING

FUMES AND GASES can be hazardous to your health.

Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

AWS F2.2:2001 (R2010), Adapted with permission of the American Welding Society (AWS), Miami, Florida

Guide for Shade Numbers

Process	Electrode Size in. (mm)	Arc Current (Amperes)	Minimum Protective Shade	Suggested* Shade No. (Comfort)
Shielded Metal Arc Welding (SMAW)	Less than 3/32 (2.4) 3/32-5/32 (2.4-4.0) 5/32-1/4 (4.0-6.4) More than 1/4 (6.4)	Less than 60 60-160 160-250 250-550	7 8 10 11	- 10 12 14
Gas Metal Arc Welding (GMAW) and Flux Cored Arc Welding (FCAW)		Less than 60 60-160 160-250 250-550	7 10 10 10	- 11 12 14
Gas Tungsten arc Welding (GTAW)		Less than 50 50-150 150-500	8 8 10	10 12 14
Air Carbon Arc Cutting (CAC-A)	(Light) (Heavy)	Less than 500 500-1000	10 11	12 14
Plasma Arc Welding (PAW)		Less than 20 20-100 100-400 400-800	6 8 10 11	6 to 8 10 12 14
Plasma Arc Cutting (PAC)		Less than 20 20-40 40-60 60-80 80-300 300-400 400-800	4 5 6 8 8 9 10	4 5 6 8 9 12 14

* As a rule of thumb, start with a shade that is too dark to see the weld zone. Then go to a lighter shade which gives sufficient view of the weld zone without going below the minimum. In oxyfuel gas welding, cutting, or brazing where the torch and/or the flux produces a high yellow light, it is desirable to use a filter lens that absorbs the yellow or sodium line of the visible light spectrum.

1. Keep your head out of the fumes. Do not breathe the fumes.
2. If inside, ventilate the area and/or use exhaust at the arc to remove welding fumes and gases.
3. If ventilation is poor, use an approved air-supplied respirator.
4. Read the Material Safety Data Sheets (MSDSs) and the manufacturer's instruction for metals, consumables, coatings, and cleaners.
5. Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Shielding gases used for welding can displace air causing injury or death. Be sure the breathing air is safe.
6. Do not weld in locations near degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapors to form highly toxic and irritating gases.
7. Do not weld on coated metals, such as galvanized, lead, or cadmium plated steel, unless the coating is removed from the weld area, the area is well ventilated, and if necessary, while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes if welded.

WARNING

WELDING can cause fire or explosion.

Sparks and spatter fly off from the welding arc. The flying sparks and hot metal, weld spatter, hot workpiece, and hot equipment can cause fires and burns. Accidental contact of electrode or welding wire to metal objects can cause sparks, overheating, or fire.

1. Protect yourself and others from flying sparks and hot metal.
2. Do not weld where flying sparks can strike flammable material.
3. Remove all flammables within 35 ft (10.7 m) of the welding arc. If this is not possible, tightly cover them with approved covers.
4. Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas.
5. Watch for fire, and keep a fire extinguisher nearby.
6. Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.
7. Do not weld on closed containers such as tanks or drums.
8. Connect work cable to the work as close to the welding area as practical to prevent welding current from traveling long, possibly unknown paths and causing electric shock and fire hazards.
9. Do not use welder to thaw frozen pipes.
10. Remove stick electrode from holder or cut off welding wire at contact tip when not in use.

WARNING

FLYING SPARKS AND HOT METAL can cause injury.

Chipping and grinding cause flying metal. As welds cool, they can throw off slag.

1. Wear approved face shield or safety goggles. Side shields recommended.
2. Wear proper body protection to protect skin.

WARNING

CYLINDERS can explode if damaged.

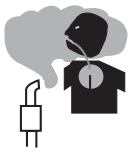
Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Since gas cylinders are normally part of the welding process, be sure to treat them carefully.

1. Protect compressed gas cylinders from excessive heat, mechanical shocks, and arcs.
2. Install and secure cylinders in an upright position by chaining them to a stationary support or equipment cylinder rack to prevent falling or tipping.
3. Keep cylinders away from any welding or other electrical circuits.
4. Never allow a welding electrode to touch any cylinder.
5. Use only correct shielding gas cylinders, regulators, hoses, and fittings designed for the specific application; maintain them and associated parts in good condition.
6. Turn face away from valve outlet when opening cylinder valve.

7. Keep protective cap in place over valve except when cylinder is in use or connected for use.
8. Read and follow instructions on compressed gas cylinders, associated equipment, and CGA publication P-1 listed in Safety Standards.

WARNING

Engines can be dangerous.



WARNING

ENGINE EXHAUST GASES can kill.

Engines produce harmful exhaust gases.

1. Use equipment outside in open, well-ventilated areas.
2. If used in a closed area, vent engine exhaust outside and away from any building air intakes.

WARNING

ENGINE FUEL can cause fire or explosion.

Engine fuel is highly flammable.

1. Stop engine before checking or adding fuel.
2. Do not add fuel while smoking or if unit is near any sparks or open flames.
3. Allow engine to cool before fueling. If possible, check and add fuel to cold engine before beginning job.
4. Do not overfill tank — allow room for fuel to expand.
5. Do not spill fuel. If fuel is spilled, clean up before starting engine.

WARNING

MOVING PARTS can cause injury.

Moving parts, such as fans, rotors, and belts can cut fingers and hands and catch loose clothing.

1. Keep all doors, panels, covers, and guards closed and securely in place.
2. Stop engine before installing or connecting unit.
3. Have only qualified people remove guards or covers for maintenance and troubleshooting as necessary.
4. To prevent accidental starting during servicing, disconnect negative (-) battery cable from battery.
5. Keep hands, hair, loose clothing, and tools away from moving parts.
6. Reinstall panels or guards and close doors when servicing is finished and before starting engine.

WARNING

SPARKS can cause BATTERY GASES TO EXPLODE; BATTERY ACID can burn eyes and skin.

Batteries contain acid and generate explosive gases.

1. Always wear a face shield when working on a battery.
2. Stop engine before disconnecting or connecting battery cables.
3. Do not allow tools to cause sparks when working on a battery.
4. Do not use welder to charge batteries or jump start vehicles.
5. Observe correct polarity (+ and –) on batteries.

WARNING

STEAM AND PRESSURIZED HOT COOLANT can burn face, eyes, and skin.

The coolant in the radiator can be very hot and under pressure.

1. Do not remove radiator cap when engine is hot. Allow engine to cool.
2. Wear gloves and put a rag over cap area when removing cap.
3. Allow pressure to escape before completely removing cap.

NOTE

Considerations About Welding And The Effects of Low Frequency Electric and Magnetic Fields

The following is a quotation from the General Conclusions Section of the U.S. Congress, Office of Technology Assessment, Biological Effects of Power Frequency Electric & Magnetic Fields - Background Paper, OTA-BP-E-63 (Washington, DC: U.S. Government Printing Office, May 1989): "...there is now a very large volume of scientific findings based on experiments at the cellular level and from studies with animals and people which clearly establish that low frequency magnetic fields interact with, and produce changes in, biological systems. While most of this work is of very high quality, the results are complex. Current scientific understanding does not yet allow us to interpret the evidence in a single coherent framework. Even more frustrating, it does not yet allow us to draw definite conclusions about questions of possible risk or to offer clear science-based advice on strategies to minimize or avoid potential risks."

To reduce magnetic fields in the workplace, use the following procedures.

1. Keep cables close together by twisting or taping them.
2. Arrange cables to one side and away from the operator.
3. Do not coil or drape cable around the body.
4. Keep welding Power Source and cables as far away from body as practical.

ABOUT PACEMAKERS:

The above procedures are among those also normally recommended for pacemaker wearers. Consult your doctor for complete information.

1.02 General Safety Information for Victor CS Regulator

A Fire Prevention

Welding and cutting operations use fire or combustion as a basic tool. The process is very useful when properly controlled. However, it can be extremely destructive if not performed correctly in the proper environment.

1. The work area must have a fireproof floor.
2. Work benches or tables used during welding or cutting operations must have fireproof tops.
3. Use heat resistant shields or other approved material to protect nearby walls or unprotected flooring from sparks and hot metal.
4. Keep an approved fire extinguisher of the proper size and type in the work area. Inspect it regularly to ensure that it is in proper working order. Know how to use the fire extinguisher.
5. Move combustible materials away from the work site. If you can not move them, protect them with fireproof covers.

WARNING

NEVER perform welding, heating, or cutting operations on a container that has held toxic, combustible or flammable liquids, or vapors. NEVER perform welding, heating, or cutting operations in an area containing combustible vapors, flammable liquids, or explosive dust.

B Housekeeping

WARNING

NEVER allow oxygen to contact grease, oil, or other flammable substances. Although oxygen by itself will not burn, these substances become highly explosive. They can ignite and burn violently in the presence of oxygen.

Keep ALL apparatus clean and free of grease, oil and other flammable substances.

C Ventilation

WARNING

Adequately ventilate welding, heating, and cutting work areas to prevent accumulation of explosive or toxic concentrations of gases. Certain combinations of metals, coatings, and gases generate toxic fumes. Use respiratory protection equipment in these circumstances. When welding/brazing, read and understand the Material Safety Data Sheet for the welding/brazing alloy.

D Personal Protection

Gas flames produce infrared radiation which may have a harmful effect on the skin and especially on the eyes. Select goggles or a mask with tempered lenses, shaded 4 or darker, to protect your eyes from injury and provide good visibility of the work.

Always wear protective gloves and flame-resistant clothing to protect skin and clothing from sparks and slag. Keep collars, sleeves, and pockets buttoned. **DO NOT** roll up sleeves or cuff pants.

When working in a non-welding or cutting environment, always wear suitable eye protection or face shield.

WARNING

Practice the following safety and operation precautions EVERY TIME you use pressure regulation equipment. Deviation from the following safety and operation instructions can result in fire, explosion, damage to equipment, or injury to the operator.

E Compressed Gas Cylinders

The Department of Transportation (DOT) approves the design and manufacture of cylinders that contain gases used for welding or cutting operations.

1. Place the cylinder (Figure 1-1) where you will use it. Keep the cylinder in a vertical position. Secure it to a cart, wall, work bench, post, etc.

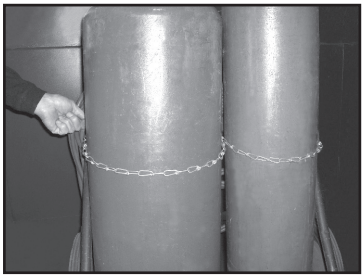


Figure 1-1: Gas Cylinders

WARNING

Cylinders are highly pressurized. Handle with care. Serious accidents can result from improper handling or misuse of compressed gas cylinders DO NOT drop the cylinder, knock it over, or expose it to excessive heat, flames or sparks. DO NOT strike it against other cylinders. Contact your gas supplier or refer to CGA P-1 "Safe Handling of Compressed Gases in Containers" publication.

NOTE

CGA P-1 publication is available by writing the Compressed Gas Association, 4221 Walney Road, 5th Floor, Chantilly,VA 20151-2923

2. Place the valve protection cap on the cylinder whenever moving it, placing it in storage, or not using it. Never drag or roll cylinders in any way. Use a suitable hand truck to move cylinders.
3. Store empty cylinders away from full cylinders. Mark them "EMPTY" and close the cylinder valve.

4. NEVER use compressed gas cylinders without a pressure reducing regulator attached to the cylinder valve.
5. Inspect the cylinder valve for oil, grease, and damaged parts.

WARNING

DO NOT use the cylinder if you find oil, grease or damaged parts. Inform your gas supplier of this condition immediately.

6. Momentarily open and close (called “cracking”) the cylinder valve to dislodge any dust or dirt that may be present in the valve.

CAUTION

Open the cylinder valve slightly. If you open the valve too much, the cylinder could tip over. When cracking the cylinder valve, DO NOT stand directly in front of the cylinder valve. Always perform cracking in a well ventilated area. If an acetylene cylinder sprays a mist when cracked, let it stand for 15 minutes. Then, try to crack the cylinder valve again. If this problem persists, contact your gas supplier.

1.03 Principal Safety Standards

Safety in Welding and Cutting, ANSI Standard Z49.1, from American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126.

Safety and Health Standards, OSHA 29 CFR 1910, from Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402.

Recommended Safe Practices for the Preparation for Welding and Cutting of Containers That Have Held Hazardous Substances, American Welding Society Standard AWS F4.1, from American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126.

National Electrical Code, NFPA Standard 70, from National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1, from Compressed Gas Association, 1235 Jefferson Davis Highway, Suite 501, Arlington, VA 22202.

Code for Safety in Welding and Cutting, CSA Standard W117.2, from Canadian Standards Association, Standards Sales, 178 Rexdale Boulevard, Rexdale, Ontario, Canada M9W 1R3.

Safe Practices for Occupation and Educational Eye and Face Protection, ANSI Standard Z87.1, from American National Standards Institute, 1430 Broadway, New York, NY 10018.

Cutting and Welding Processes, NFPA Standard 51B, from National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

1.04 Symbol Chart

Note that only some of these symbols will appear on your model.

	On
	Off
	Dangerous Voltage
	Increase/Decrease
	Circuit Breaker
	AC Auxiliary Power
	Fuse
A	Amperage
V	Voltage
Hz	Hertz (cycles/sec)
f	Frequency
	Negative
	Positive
	Direct Current (DC)
	Protective Earth (Ground)
	Line
	Line Connection
	Auxiliary Power
115V 15A	Receptacle Rating- Auxiliary Power

1 ~	Single Phase
3 ~	Three Phase
	Three Phase Static Frequency Converter-Transformer-Rectifier
	Remote
X	Duty Cycle
%	Percentage
	Panel/Local
	Shielded Metal Arc Welding (SMAW)
	Gas Metal Arc Welding (GMAW)
	Gas Tungsten Arc Welding (GTAW)
	Air Carbon Arc Cutting (CAC-A)
	Constant Current
	Constant Voltage Or Constant Potential
	High Temperature
	Fault Indication
	Arc Force
	Touch Start (GTAW)
	Variable Inductance
V	Voltage Input

	Wire Feed Function
	Wire Feed Towards Workpiece With Output Voltage Off.
	Welding Gun
	Purging Of Gas
	Continuous Weld Mode
	Spot Weld Mode
t	Spot Time
t1	Preflow Time
t2	Postflow Time
	2 Step Trigger Operation Press to initiate wirefeed and welding, release to stop.
	4 Step Trigger Operation Press and hold for preflow, release to start arc. Press to stop arc, and hold for preflow.
t	Burnback Time
IPM	Inches Per Minute
MPM	Meters Per Minute
S	See Note
	See Note
	Art # A-04130_AB

Note: For environments with increased hazard of electrical shock, Power Supplier bearing the S mark conform to EN50192 when used in conjunction with hand torches with exposed tips, if equipped with properly installed standoff guides.

Cannot be disposed with household garbage.

1.05 Precautions De Securite En Soudage A L'arc

MISE EN GARDE

LE SOUDAGE A L'ARC EST DANGEREUX

PROTEGEZ-VOUS, AINSI QUE LES AUTRES, CONTRE LES BLESSURES GRAVES POSSIBLES OU LA MORT. NE LAISSEZ PAS LES ENFANTS S'APPROCHER, NI LES PORTEURS DE STIMULATEUR CARDIAQUE (A MOINS QU'ILS N'AIENT CONSULTE UN MEDECIN). CONSERVEZ CES INSTRUCTIONS. LISEZ LE MANUEL D'OPERATION OU LES INSTRUCTIONS AVANT D'INSTALLER, UTILISER OU ENTRETENIR CET EQUIPEMENT.

Les produits et procédés de soudage peuvent sauser des blessures graves ou la mort, de même que des dommages au reste du matériel et à la propriété, si l'utilisateur n'adhère pas strictement à toutes les règles de sécurité et ne prend pas les précautions nécessaires.

En soudage et coupage, des pratiques sécuritaires se sont développées suite à l'expérience passée. Ces pratiques doivent être apprises par étude ou entraînement avant d'utiliser l'equipement. Toute personne n'ayant pas suivi un entraînement intensif en soudage et coupage ne devrait pas tenter de souder. Certaines pratiques concernent les équipements raccordés aux lignes d'alimentation alors que d'autres s'adressent aux groupes électrogènes.

La norme Z49.1 de l'American National Standard, intitulée "SAFETY IN WELDING AND CUTTING" présente les pratiques sécuritaires à suivre. Ce document ainsi que d'autres guides que vous devriez connaître avant d'utiliser cet équipement sont présentés à la fin de ces instructions de sécurité.

SEULES DES PERSONNES QUALIFIEES DOIVENT FAIRE DES TRAVAUX D'INSTALLATION, DE REPARATION, D'ENTRETIEN ET D'ESSAI.

1.06 Dangers relatifs au soudage à l'arc

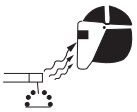
AVERTISSEMENT

L'ELECTROCUTION PEUT ETRE MORTELLE.

Une décharge électrique peut tuer ou brûler gravement. L'électrode et le circuit de soudage sont sous tension dès la mise en circuit. Le circuit d'alimentation et les circuits internes de l'équipement sont aussi sous tension dès la mise en marche. En soudage automatique ou semi-automatique avec fil, ce dernier, le rouleau ou la bobine de fil, le logement des galets d'entrainement et toutes les pièces métalliques en contact avec le fil de soudage sont sous tension. Un équipement inadéquatement installé ou inadéquatement mis à la terre est dangereux.

1. Ne touchez pas à des pièces sous tension.
2. Portez des gants et des vêtements isolants, secs et non troués.
3. Isolez-vous de la pièce à souder et de la mise à la terre au moyen de tapis isolants ou autres.
4. Déconnectez la prise d'alimentation de l'équipement ou arrêtez le moteur avant de l'installer ou d'en faire l'entretien. Bloquez le commutateur en circuit ouvert ou enlevez les fusibles de l'alimentation afin d'éviter une mise en marche accidentelle.
5. Veuillez à installer cet équipement et à le mettre à la terre selon le manuel d'utilisation et les codes nationaux, provinciaux et locaux applicables.
6. Arrêtez tout équipement après usage. Coupez l'alimentation de l'équipement s'il est hors d'usage ou inutilisé.
7. N'utilisez que des porte-électrodes bien isolés. Ne jamais plonger les porte-électrodes dans l'eau pour les refroidir. Ne jamais les laisser traîner par terre ou sur les pièces à souder. Ne touchez pas aux porte-électrodes raccordés à deux sources de courant en même temps. Ne jamais toucher quelqu'un d'autre avec l'électrode ou le porte-électrode.
8. N'utilisez pas de câbles électriques usés, endommagés, mal épissés ou de section trop petite.

9. N'enroulez pas de câbles électriques autour de votre corps.
10. N'utilisez qu'une bonne prise de masse pour la mise à la terre de la pièce à souder.
11. Ne touchez pas à l'électrode lorsqu'en contact avec le circuit de soudage (terre).
12. N'utilisez que des équipements en bon état. Réparez ou remplacez aussitôt les pièces endommagées.
13. Dans des espaces confinés ou mouillés, n'utilisez pas de source de courant alternatif, à moins qu'il soit muni d'un réducteur de tension. Utilisez plutôt une source de courant continu.
14. Portez un harnais de sécurité si vous travaillez en hauteur.
15. Fermez solidement tous les panneaux et les capots.



AVERTISSEMENT

LE RAYONNEMENT DE L'ARC PEUT BRÛLER LES YEUX ET LA PEAU; LE BRUIT PEUT ENDOMMAGER L'OUIE.

L'arc de soudage produit une chaleur et des rayons ultraviolets intenses, susceptibles de brûler les yeux et la peau. Le bruit causé par certains procédés peut endommager l'ouïe.

1. Portez une casque de soudeur avec filtre oculaire de nuance appropriée (consultez la norme ANSI Z49 indiquée ci-après) pour vous protéger le visage et les yeux lorsque vous soudez ou que vous observez l'exécution d'une soudure.

AWS F2.2:2001 (R2010), Adapted with permission of the American Welding Society (AWS), Miami, Florida

Guide for Shade Numbers

Process	Electrode Size in. (mm)	Arc Current (Amperes)	Minimum Protective Shade	Suggested* Shade No. (Comfort)
Shielded Metal Arc Welding (SMAW)	Less than 3/32 (2.4) 3/32-5/32 (2.4-4.0) 5/32-1/4 (4.0-6.4) More than 1/4 (6.4)	Less than 60 60-160 160-250 250-550	7 8 10 11	- 10 12 14
Gas Metal Arc Welding (GMAW) and Flux Cored Arc Welding (FCAW)		Less than 60 60-160 160-250 250-550	7 10 10 10	- 11 12 14
Gas Tungsten arc Welding (GTAW)		Less than 50 50-150 150-500	8 8 10	10 12 14
Air Carbon Arc Cutting (CAC-A)	(Light) (Heavy)	Less than 500 500-1000	10 11	12 14
Plasma Arc Welding (PAW)		Less than 20 20-100 100-400 400-800	6 8 10 11	6 to 8 10 12 14
Plasma Arc Cutting (PAC)		Less than 20 20-40 40-60 60-80 80-300 300-400 400-800	4 5 6 8 8 9 10	4 5 6 8 9 12 14

* As a rule of thumb, start with a shade that is too dark to see the weld zone. Then go to a lighter shade which gives sufficient view of the weld zone without going below the minimum. In oxyfuel gas welding, cutting, or brazing where the torch and/or the flux produces a high yellow light, it is desirable to use a filter lens that absorbs the yellow or sodium line of the visible light spectrum.

2. Portez des lunettes de sécurité approuvées. Des écrans latéraux sont recommandés.
3. Entourez l'aire de soudage de rideaux ou de cloisons pour protéger les autres des coups d'arc ou de l'éblouissement; avertissez les observateurs de ne pas regarder l'arc.
4. Portez des vêtements en matériaux ignifuges et durables (laine et cuir) et des chaussures de sécurité.
5. Portez un casque antibruit ou des bouchons d'oreille approuvés lorsque le niveau de bruit est élevé.

AVERTISSEMENT

LES VAPEURS ET LES FUMEES SONT DANGEREUSES POUR LA SANTE.

Le soudage dégage des vapeurs et des fumées dangereuses à respirer.

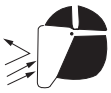
1. Eloignez la tête des fumées pour éviter de les respirer.
2. A l'intérieur, assurez-vous que l'aire de soudage est bien ventilée ou que les fumées et les vapeurs sont aspirées à l'arc.
3. Si la ventilation est inadequate, portez un respirateur à adduction d'air approuvé.
4. Lisez les fiches signalétiques et les consignes du fabricant relatives aux métaux, aux produits consummables, aux revêtements et aux produits nettoyants.
5. Ne travaillez dans un espace confiné que s'il est bien ventilé; sinon, portez un respirateur à adduction d'air. Les gaz protecteurs de soudage peuvent déplacer l'oxygène de l'air et ainsi causer des malaises ou la mort. Assurez-vous que l'air est propre à la respiration.
6. Ne soudez pas à proximité d'opérations de dégraissage, de nettoyage ou de pulvérisation. La chaleur et les rayons de l'arc peuvent réagir avec des vapeurs et former des gaz hautement toxiques et irritants.
7. Ne soudez des tôles galvanisées ou plaquées au plomb ou au cadmium que si les zones à souder ont été grattées à fond, que si l'espace est bien ventilé; si nécessaire portez un respirateur à adduction d'air. Car ces revêtements et tout métal qui contient ces éléments peuvent dégager des fumées toxiques au moment du soudage.

AVERTISSEMENT

LE SOUDAGE PEUT CAUSER UN INCENDIE OU UNE EXPLOSION

L'arc produit des étincellies et des projections. Les particules volantes, le métal chaud, les projections de soudure et l'équipement surchauffé peuvent causer un incendie et des brûlures. Le contact accidentel de l'électrode ou du fil-électrode avec un objet métallique peut provoquer des étincelles, un échauffement ou un incendie.

1. Protégez-vous, ainsi que les autres, contre les étincelles et du métal chaud.
2. Ne soudez pas dans un endroit où des particules volantes ou des projections peuvent atteindre des matériaux inflammables.
3. Enlevez toutes matières inflammables dans un rayon de 10, 7 mètres autour de l'arc, ou couvrez-les soigneusement avec des bâches approuvées.
4. Méfiez-vous des projections brulantes de soudage susceptibles de pénétrer dans des aires adjacentes par de petites ouvertures ou fissures.
5. Méfiez-vous des incendies et gardez un extincteur à portée de la main.
6. N'oubliez pas qu'une soudure réalisée sur un plafond, un plancher, une cloison ou une paroi peut enflammer l'autre côté.
7. Ne soudez pas un récipient fermé, tel un réservoir ou un baril.
8. Connectez le câble de soudage le plus près possible de la zone de soudage pour empêcher le courant de suivre un long parcours inconnu, et prévenir ainsi les risques d'électrocution et d'incendie.
9. Ne dégelez pas les tuyaux avec un source de courant.
10. Otez l'électrode du porte-électrode ou coupez le fil au tube-contact lorsqu'inutilisé après le soudage.
11. Portez des vêtements protecteurs non huileux, tels des gants en cuir, une chemise épaisse, un pantalon revers, des bottines de sécurité et un casque.



AVERTISSEMENT

LES ETINCELLES ET LES PROJECTIONS BRULANTES PEUVENT CAUSER DES BLESSURES.

Le piquage et le meulage produisent des particules métalliques volantes. En refroidissant, la soudure peut projeter du éclats de laitier.

1. Portez un écran facial ou des lunettes protectrices approuvées. Des écrans latéraux sont recommandés.
2. Portez des vêtements appropriés pour protéger la peau.

AVERTISSEMENT

LES BOUTEILLES ENDOMMAGEES PEUVENT EXPLOSER

Les bouteilles contiennent des gaz protecteurs sous haute pression. Des bouteilles endommagées peuvent exploser. Comme les bouteilles font normalement partie du procédé de soudage, traitez-les avec soin.

1. Protégez les bouteilles de gaz comprimé contre les sources de chaleur intense, les chocs et les arcs de soudage.
2. Enchainez verticalement les bouteilles à un support ou à un cadre fixe pour les empêcher de tomber ou d'être renversées.
3. Eloignez les bouteilles de tout circuit électrique ou de tout soudage.
4. Empêchez tout contact entre une bouteille et une électrode de soudage.
5. N'utilisez que des bouteilles de gaz protecteur, des détendeurs, des boyauxs et des raccords conçus pour chaque application spécifique; ces équipements et les pièces connexes doivent être maintenus en bon état.
6. Ne placez pas le visage face à l'ouverture du robinet de la bouteille lors de son ouverture.
7. Laissez en place le chapeau de bouteille sauf si en utilisation ou lorsque raccordé pour utilisation.
8. Lisez et respectez les consignes relatives aux bouteilles de gaz comprimé et aux équipements connexes, ainsi que la publication P-1 de la CGA, identifiée dans la liste de documents ci-dessous.

AVERTISSEMENT

LES MOTEURS PEUVENT ETRE DANGEREUX

LES GAZ D'ECHAPPEMENT DES MOTEURS PEUVENT ETRE MORTELS.

Les moteurs produisent des gaz d'échappement nocifs.

1. Utilisez l'équipement à l'extérieur dans des aires ouvertes et bien ventilées.
2. Si vous utilisez ces équipements dans un endroit confiné, les fumées d'échappement doivent être envoyées à l'extérieur, loin des prises d'air du bâtiment.

AVERTISSEMENT

LE CARBURANT PEUR CAUSER UN INCENDIE OU UNE EXPLOSION.

Le carburant est hautement inflammable.

1. Arrêtez le moteur avant de vérifier le niveau e carburant ou de faire le plein.
2. Ne faites pas le plein en fumant ou proche d'une source d'étincelles ou d'une flamme nue.
3. Si c'est possible, laissez le moteur refroidir avant de faire le plein de carburant ou d'en vérifier le niveau au début du soudage.
4. Ne faites pas le plein de carburant à ras bord: prévoyez de l'espace pour son expansion.
5. Faites attention de ne pas renverser de carburant. Nettoyez tout carburant renversé avant de faire démarrer le moteur.

AVERTISSEMENT

DES PIECES EN MOUVEMENT PEUVENT CAUSER DES BLESSURES.

Des pièces en mouvement, tels des ventilateurs, des rotors et des courroies peuvent couper doigts et mains, ou accrocher des vêtements amples.

1. Assurez-vous que les portes, les panneaux, les capots et les protecteurs soient bien fermés.
2. Avant d'installer ou de connecter un système, arrêtez le moteur.
3. Seules des personnes qualifiées doivent démonter des protecteurs ou des capots pour faire l'entretien ou le dépannage nécessaire.
4. Pour empêcher un démarrage accidentel pendant l'entretien, débranchez le câble d'accumulateur à la borne négative.
5. N'approchez pas les mains ou les cheveux de pièces en mouvement; elles peuvent aussi accrocher des vêtements amples et des outils.
6. Réinstallez les capots ou les protecteurs et fermez les portes après des travaux d'entretien et avant de faire démarrer le moteur.

AVERTISSEMENT

DES ETINCELLES PEUVENT FAIRE EXPLOSER UN ACCUMULATEUR; L'ELECTROLYTE D'UN ACCUMU-LATEUR PEUT BRULER LA PEAU ET LES YEUX.

Les accumulateurs contiennent de l'électrolyte acide et dégagent des vapeurs explosives.

1. Portez toujours un écran facial en travaillant sur un accumu-lateur.
2. Arrêtez le moteur avant de connecter ou de déconnecter des câbles d'accumulateur.
3. N'utilisez que des outils anti-étincelles pour travailler sur un accumulateur.
4. N'utilisez pas une source de courant de soudage pour charger un accumulateur ou survolter momentanément un véhicule.
5. Utilisez la polarité correcte (+ et –) de l'accumulateur.

AVERTISSEMENT

LA VAPEUR ET LE LIQUIDE DE REFROIDISSEMENT BRULANT SOUS PRESSION PEUVENT BRULER LA PEAU ET LES YEUX.

Le liquide de refroidissement d'un radiateur peut être brûlant et sous pression.

1. N'ôtez pas le bouchon de radiateur tant que le moteur n'est pas refroidi.
2. Mettez des gants et posez un torchon sur le bouchon pour l'ôter.
3. Laissez la pression s'échapper avant d'ôter complètement le bouchon.

1.07 Informations Générales de Sécurité

A Prévention D'incendie

Les opérations de soudage utilisent le feu ou la combustion comme outil de base. Ce processus est très utile quand il est correctement contrôlé.

1. La zone doit comporter un sol ignifugé.
2. Les établis ou tables utilisés pendant les opérations de soudage doivent avoir un revêtement ignifuge.
3. Utilisez des écrans résistants à la chaleur ou en matériau approuvé pour protéger les cloisons proches ou le sol vulnérable des étincelles et du métal chaud.
4. Gardez un extincteur approuvé du bon type et de la bonne taille dans la zone de travail. Inspectez-le régulièrement pour vous assurer qu'il est en état de fonctionner. Apprenez à vous en servir.
5. Enlevez tous les matériaux combustibles de la zone de travail. Si vous ne pouvez pas les enlever, protégez-les avec une couvre ignifuge.

AVERTISSEMENT

N'effectuez ***JAMAIS*** *d'opérations de soudage sur un récipient qui a contenu des liquides ou vapeurs toxiques, combustibles ou inflammables. N'effectuez* ***JAMAIS*** *d'opérations de soudage dans une zone contenant des vapeurs combustibles, des liquides inflammables ou des poussières explosives.*

B Entretien des Locaux

AVERTISSEMENT

Ne laissez jamais l'oxygène en contact avec la graisse, l'huile ou d'autres substances inflammables. Bien que l'oxygène ellemême ne brûle pas, ces substances peuvent devenir extrêmement explosives. Elles peuvent prendre feu et brûler violemment en présence d'oxygène.

Gardez **TOUS** les appareils propres et exempts de graisse, huile ou autres substances inflammables.

C Aération

AVERTISSEMENT

Ventilez les zones de soudage, chauffage et découpage de façon adéquate pour éviter l'accumulation de gaz explosifs ou toxiques. Certaines combinaisons de métaux, revêtements et gaz génèrent des fumées toxiques: Utilisez un équipement de protection respiratoire dans ces circonstances. Si vous soudez ou brasez, lisez et assimilez la fiche technique de sécurité de matériau relative à l'alliage de soudage/brasage.

D Protection Personnelle

Les flammes de gaz produisent une radiation infrarouge qui peut avoir un effet néfaste sur la peau, et particulièrement sur les yeux. Choisissez des lunettes ou un masque avec des verres trempés assombris au niveau 4 ou plus sombre, pour protéger vos yeux des dommages et garder une bonne visibilité sur le travail.

Portez en permanence des gants de protection et des vêtements ignifuges pour la protection de la peau et des vêtements contre les étincelles et le laitier. Gardez col, manches et poches boutonnés. Il ne faut pas remonter vos manches ou les pantalons à revers.

Quand vous travaillez dans un environnement non dédié au soudage ou découpage, portez toujours une protection des yeux appropriées ou un masque facial.

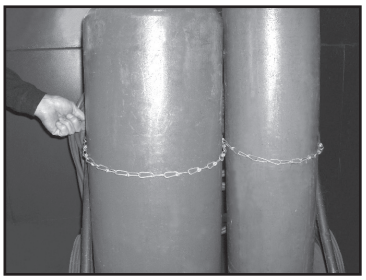
AVERTISSEMENT

Mettez en pratique les procédures de sécurité et de mode opératoire suivantes à chaque fois que vous utilisez cet appareil de régulation de pression. Si vous déviez de ces procédures, cela peut entraîner incendie, explosion, dégâts matériels et/ou blessures corporelles pour l'opérateur.

E Bouteilles de Gaz Comprimé

Le Département des Transports américain (DOT) approuve la conception et la fabrication des bouteilles qui contiennent les gaz utilisés pour les opérations de soudage ou de découpage.

1. Placez la bouteille (Le schéma 1) là où elle sera utilisée. Gardez-la en position verticale. Fixez-la sur un chariot une cloison, un établi, etc.



Le schéma 1-1: Cylindres de gaz

AVERTISSEMENT

Les bouteilles sont sous haute pression. Manipulez-les avec précautions. Des accidents sérieux peuvent résulter d'une mauvaise manutention ou d'un mauvais emploi des bouteilles de gaz comprimé. NE faites PAS tomber la bouteille, ne la cognez pas, ne l'exposez pas à une chaleur excessive, aux flammes ou étincelles. NE la cognez PAS contre d'autres bouteilles. Contactez votre fournisseur de gaz ou reportezvous à la publication CGA P-1 "Manipulation sécurisée des gaz comprimés en conteneur" pour plus d'informations sur l'utilisation et la manutention des bouteilles.

AVIS

Ce document CGA p. t peut être obtenu en écrivant à "Compressed Gas Association", 4221 Walney Roed, 5th Floor. Chantilly, VA 20151.2923, USA.

2. Placez le bouchon de protection de vanne sur la bouteille à chaque fois que vous la déplacez ou ne l'utilisez pas. Ne faites jamais glisser ou rouler d'aucune manière les bouteilles. Utilisez un diable approprié pour les déplacer.
3. Entreposez les bouteilles vides à l'écart des bouteilles pleines. Marquez-les "VIDE" et refermez leur vanne.
4. N'utilisez **JAMAIS** des bouteilles de gaz comprimé sans un régulateur de pression en série sur la vanne de bouteille.
5. Inspectez la vanne de bouteille pour y détecter de l'huile ou de la graisse, ou dès pièces endommagées.

AVERTISSEMENT

N'UTILISEZ PAS la bouteille si vous trouvez de l'huile, de la graisse ou des pièces endommagées. Informez immédiatement votre fournisseur de' gaz de cet état.

6. Ouvrez et fermez momentanément la vanne de la bouteille, délogeant ainsi d'éventu lles poussières ou saletés. qui pourraient être présentes dans la vanne.

Mise en Garde

Ouvrez la vanne de bouteille légèrement. Si vous l'ouvrez trop en grand, la bouteille pourrait se renverser. Quand vous ouvrez/ fermez rapidement la vanne de bouteille, ne vous tenez pas directement devant. Opérez toujours cette opération dans une zone bien ventilée. Si une bouteille d'acétylène crache un brouillard, laissez reposer pendant 15 minutes. Essayez de nouveau la vanne. Si le problème persiste, contactez votre fournisseur de gaz.

1.08 Principales Normes De Securite

Safety in Welding and Cutting, norme ANSI Z49.1, American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33128.

Safety and Health Standards, OSHA 29 CFR 1910, Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402.

Recommended Safe Practices for the Preparation for Welding and Cutting of Containers That Have Held Hazardous Substances, norme AWS F4.1, American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33128.

National Electrical Code, norme 70 NFPA, National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

Safe Handling of Compressed Gases in Cylinders, document P-1, Compressed Gas Association, 1235 Jefferson Davis Highway, Suite 501, Arlington, VA 22202.

Code for Safety in Welding and Cutting, norme CSA W117.2 Association canadienne de normalisation, Standards Sales, 276 Rexdale Boulevard, Rexdale, Ontario, Canada M9W 1R3.

Safe Practices for Occupation and Educational Eye and Face Protection, norme ANSI Z87.1, American National Standards Institute, 1430 Broadway, New York, NY 10018.

Cutting and Welding Processes, norme 51B NFPA, National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

1.09 Graphique de Symbole

Seulement certains de ces symboles apparaîtront sur votre modèle.

	Sous Tension
	Hors Tension
	Tension dangereuse
	Augmentez/Diminuer
	Disjoncteur
	Source AC Auxiliaire
	Fusible
A	Intensité de Courant
V	Tension
Hz	Hertz (cycles/sec)
f	Fréquence
	Négatif
	Positif
	Courant Continue (DC)
	Terre de Protection
	Ligne
	Connexion de la Ligne
	Source Auxiliaire
115V 15A	Classement de Prise-Source Auxiliaire

1 ~	Mono Phasé
3 ~	Trois Phasé
	Tri-Phase Statique Fréquence Convertisseur Transformateur-Redresseur
	Distant
X	Facteur de Marche
%	Pourcentage
	Panneau/Local
	Soudage Arc Electrique Avec Electrode Enrobé (SMAW)
	Soudage á L'arc Avec Fil Electrodes Fusible (GMAW)
	Soudage á L'arc Avec Electrode Non Fusible (GTAW)
	Decoupe Arc Carbone (CAC-A)
	Courant Constant
	Tension Constante Ou Potentiel Constant
	Haute Température
	Force d'Arc
	Amorçage de L'arc au Contact (GTAW)
	Inductance Variable
V	Tension

	Déroulement du Fil
	Alimentation du Fil Vers la Pièce de Fabrication Hors Tension
	Torch de Soudage
	Purge Du Gaz
	Mode Continu de Soudure
	Soudure Par Point
t	Duréc du Pulse
t1	Durée de Pré-Dèbit
t2	Durée de Post-Dèbit
	Détente à 2-Temps Appuyez pour dèruarer l'alimentation du fils et la soudure, le relâcher pour arrêter.
	Détente à 4-Temps Maintenez appuyez pour pré-dèbit, relailez pour initier l'arc. Appuyez pour arrêter l'arc, et mainteuir pour pré-dèbit.
t	Probléme de Terre
IPM	Pouces Par Minute
MPM	Mètres Par Minute
S	Voir Note
	Voir Note
	Art # A-07639_AB

Note: Pour les environnements avec des risques de choc électrique, le fournisseur d'énergie portant la marque S conforme à EN50192 lorsqu'utilisé en conjonction avec des lampes de poche avec des conseils exposés, si équipés avec des guide à l'hauteur de buse correctement installé.

Ne pas déposer avec les déchets ménagers.

1.10 Declaration Of Conformity

Manufacturer: Thermadyne Corporation
Address: 16052 Swingley Ridge Road,
Suite 300
St. Louis, MO 63017

The equipment described in this manual has been designed to all applicable aspects and regulations of the 'Low Voltage Directive' (2006/95 EC) and to the National legislation for the enforcement of this Directive.

Serial numbers are unique with each individual piece of equipment and details description, parts used to manufacture a unit and date of manufacture.

National Standard and Technical Specifications

The product is designed and manufactured to a number of standards and technical requirements. Among them are:

- CSA E60974-1, UL 60974-1 and IEC 60974-1 applicable to welding equipment and associated accessories.
- 2002/95/EC RoHS directive
- Extensive product design verification is conducted at the manufacturing facility as part of the routine design and manufacturing process. This is to ensure the product is safe, when used according to instructions in this manual and related industry standards, and performs as specified. Rigorous testing is incorporated into the manufacturing process to ensure the manufactured product meets or exceeds all design specifications.

Thermadyne has been manufacturing products for more than 30 years, and will continue to achieve excellence in our area of manufacture.

Manufacturers responsible representative:

Tom Wermert
Senior Brand Manager Thermal Arc
Thermadyne Industries, Inc
16052 Swingley Ridge Road
Chesterfield, Missouri 63017 USA

Elaine Slatter
Country Manager/Director
Thermadyne Canada
2070 Wyecroft Raod
Oakville, Ontario L6L5V6 Canada

RoHS

C ETL US LISTED
Intertek
3163339

SECTION 2:
INTRODUCTION

2.01 How to Use This Manual

This Manual usually applies to the part numbers listed on page i. To ensure safe operation, read the entire manual, including the chapter on safety instructions and warnings. Throughout this manual, the word WARNING, CAUTION and NOTE may appear. Pay particular attention to the information provided under these headings. These special annotations are easily recognized as follows:

WARNING

Gives information regarding possible personal injury. Warnings will be enclosed in a box such as this.

CAUTION

Refers to possible equipment damage. Cautions will be shown in bold type.

NOTE

Offers helpful information concerning certain operating procedures. Notes will be shown in italics

You will also notice icons from the safety section appearing throughout the manual. These are to advise you of specific types of hazards or cautions related to the portion of information that follows. Some may have multiple hazards that apply and would look something like this:

2.02 Equipment Identification

The Power Source's identification number (specification or part number), model, and serial number usually appear on a nameplate attached to the machine. Equipment which does not have a nameplate attached to the machine is identified only by the specification or part number printed on the shipping container. Record these numbers for future reference.

2.03 Receipt of Equipment

When you receive the equipment, check it against the invoice to make sure it is complete and inspect the equipment for possible damage due to shipping. If there is any damage, notify the carrier immediately to file a claim. Furnish complete information concerning damage claims or shipping errors to the location in your area listed in the inside back cover of this manual. Include all equipment identification numbers as described above along with a full description of the parts in error.

2.04 Description

The Thermal Arc Fabricator 181i is a self contained single phase multi process welding system that is capable of performing MIG (GMAW/FCAW), STICK (SMAW) and LIFT TIG (GTAW) welding processes. The Power Source is equipped with an integrated wire feed unit, digital voltage and amperage meters, and a host of other features in order to fully satisfy the broad operating needs of the modern welding professional. The Power Source is also fully compliant to Standard CSA E60974-1-00 and UL 60974.1.

The Fabricator 181i MIG provides excellent welding performance across a broad range of applications when used with the correct welding consumables and procedures. The following instructions detail how to correctly and safely set up the machine and give guidelines on gaining the best efficiency and quality from the Power Source. Please read these instructions thoroughly before using this equipment.

2.05 Transportation Methods

Disconnect input power conductors from de-energized supply line before moving the welding Power Source.

Lift Power Source with handle on top of case. Use handcart or similar device of adequate capacity. If using a fork lift vehicle, secure the Power Source on a proper skid before transporting.

2.06 User Responsibility

This equipment will perform as per the information contained herein when installed, operated, maintained and repaired in accordance with the instructions provided. This equipment must be checked periodically. Defective equipment (including welding leads) should not be used. Parts that are broken, missing, plainly worn, distorted or contaminated, should be replaced immediately. Should such repairs or replacements become necessary, it is recommended that such repairs be carried out by appropriately qualified persons approved by Thermal Arc. Advice in this regard can be obtained by contacting an Accredited Thermal Arc Distributor.

This equipment or any of its parts should not be altered from standard specification without prior written approval of Thermal Arc. The user of this equipment shall have the sole responsibility for any malfunction which results from improper use or unauthorized modification from standard specification, faulty maintenance, damage or improper repair by anyone other than appropriately qualified persons approved by Thermal Arc.

2.07 Fabricator 181i Portable System Package (Part No. W1003181)

Comes Complete with:

1. Fabricator 181i Power Source
2. 12ft. Tweco WeldSkill 180 amp MIG Gun
3. Contact Tips (1 each):
   - .023 (.6mm)
   - .030 (.8mm) Fitted
   - .035 (.9mm)
4. Victor Argon Regulator/Gauge & Hose
5. Tweco WeldSkill 200 Amp electrode holder with 13ft. (4m) lead
6. Tweco WeldSkill 200 Amp ground clamp with 10ft. (3m) lead
7. Drive Rolls:
   - .023”-.030” (0.6mm-0.8mm) V Groove fitted with 0.030" groove lined up
   - .023”-.035” (0.6mm-0.9mm) V Groove
   - .030”-.035” (0.8mm-0.9mm) V knurled for Flux Cored Wire
8. 4 general purpose stick electrodes (E6013)
9. Operator’s Manual & Set-up DVD
10. 9ft.(2.75m) Power Cord and NEMA 6-50P 230V AC Plug
11. Shoulder Strap

2.08 Duty Cycle

The rated duty cycle of a Welding Power Source, is a statement of the time it may be operated at its rated welding current output without exceeding the temperature limits of the insulation of the component parts. To explain the 10 minute duty cycle period the following example is used. Suppose a Welding Power Source is designed to operate at a 20% duty cycle, 180 amperes at 23 volts. This means that it has been designed and built to provide the rated amperage (180 A) for 2 minutes, i.e. arc welding time, out of every 10 minute period (20% of 10 minutes is 2 minutes). During the other 8 minutes of the 10 minute period the Welding Power Source must idle and be allowed to cool.

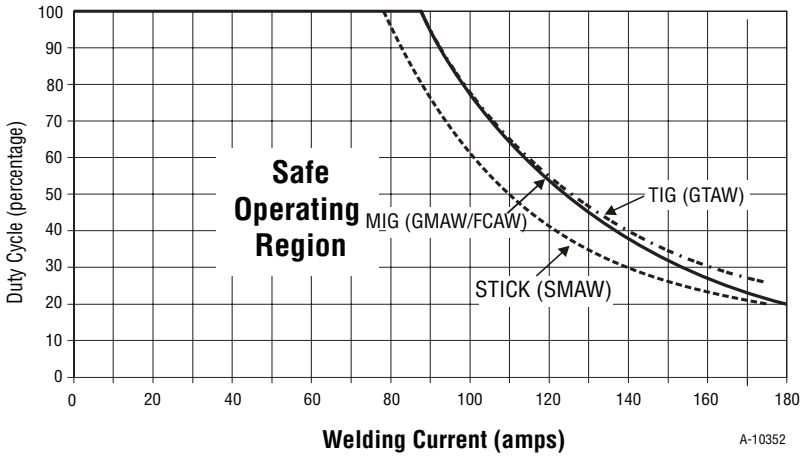


Figure 2-1: Fabricator 181i Duty Cycle

2.09 Specifications

DESCRIPTION	FABRICATOR 181i MULTI PROCESS 3 IN 1 WELDER
Power Source Part No.	W1003180
Power Source Dimensions	H16.14" x W8.27" x D17.72" (410mm x 210mm x 450mm)
Power Source Mass	32.2lb(14.6kg)
Cooling	Fan Cooled
Welder Type	Multi Process Welding System
Output Terminal Type	Dinse™ 50
Standards	CSA E60974-1-00 / UL60974-1 / IEC 60974-1
Number of Phases	Single Phase
Nominal Supply Voltage	230V AC
Supply Voltage Range	208-265V AC
Supply Frequency	50/60Hz
Welding Current Range (MIG Mode)	10-180A
Wirefeed Speed Range	100 - 650 IPM
MIG Welding Voltage Range	14.5 - 23V DC
Nominal OCV	62V DC
Effective Input Current (I_{1eff}) for MIG (GMAW/FCAW) for LIFT TIG (GTAW) for STICK (SMAW)	 15.9 Amps 14.3 Amps 17.2 Amps
Maximum Input Current (I_{1max}) for MIG (GMAW/FCAW) for LIFT TIG (GTAW) for STICK (SMAW)	 35.6 Amps 28.6 Amps 35.7 Amps
Single Phase Generator Requirement	9 KVA
MIG (GMAW/FCAW) Welding Output at 104°F (40°C)	180A @ 20%, 23V 113A @ 60%, 19.7V 88A @ 100%, 18.4V
STICK (SMAW) Welding Output at 104°F (40°C).	175A @ 20%, 27V 101A @ 60%, 24V 78A @ 100%, 23.1V
LIFT TIG (GTAW) Welding Output at 104°F (40°C).	175A @ 25%, 17V 113A @ 60%, 14.5V 88A @ 100%, 13.5V
Protection Class	IP23S

Table 2-1: Fabricator 181i Specification

NOTE

The recommended time delay fuse or circuit breaker size is 50 amp. An individual branch circuit capable of carrying 50 amperes and protected by fuses or circuit breaker is recommended for this application. Fuse size is based on not more than 200 percent of the rated input amperage of the welding Power Source (Based on Article 630, National Electrical Code)

Thermal Arc continuously strives to produce the best product possible and therefore reserves the right to change, improve or revise the specifications or design of this or any product without prior notice. Such updates or changes do not entitle the buyer of equipment previously sold or shipped to the corresponding changes, updates, improvements or replacement of such items.

The values specified in the table above are optimal values, your values may differ. Individual equipment may differ from the above specifications due to in part, but not exclusively, to any one or more of the following; variations or changes in manufactured components, installation location and conditions and local power grid supply conditions.

The thermal protection switch is rated at 80°C.

2.10 Options and Accessories

DESCRIPTION	PART NUMBER
Tweco WeldSkill 180A MIG Gun, 12ft (3.6m) Length	WS180TA-12-3035
Tweco Spool Gun 160A,12ft (3.6M) Length, suits 4" (100mm) spools for aluminum welding	SG160TA-12-3035
TIG Torch, 17V, 12.5 ft, 8 pin and accessory kit with 1/16", 3/32", 1/8" thoriated tungstens; 1/16", 3/32", 1/8" collets; 1/16", 3/32", 1/8" collet bodies; No. 5, 6, 7 Alumina nozzle; short back cap; long back cap	W4013802
Fabricator 141i-181i Carry Bag	W4015300
Basic 4 Wheel Cart	W4014700
Foot Control for remote amperage control when TIG welding	600285
Tweco WeldSkill Auto-Darkening Helmet Skull & Fire (USA Only)	4100-1004
Drive Roll .023" - .035" (0.6-0.9mm) V groove for steel & stainless steel	W4014800
Drive Roll .023"- .030" (0.6-0.8mm) V groove for steel & stainless steel wires [Fitted]	7977036
Drive Roll .035"/.045" (0.9/1.2mm) V groove for steel & stainless steel wires	7977660
Drive Roll .030"-.035" (0.8-0.9mm) U grooved for aluminum wires	7977731
Drive Roll .040"-.045" (1.0-1.2mm) U grooved for aluminum wires	7977264
Drive Roll .030"-.035" (0.8-0.9mm) V knurled groove for flux cored wires	7977732
Drive Roll .045" (1.2mm) V knurled groove for flux cored wire	704277
Stick Lead, 200A, 13ft, 50mm Dinse	WS200E13
Ground Lead, 200A,10ft, 50mm Dinse	WS200G10
Victor Argon Regulator/Flowgauge	0781-4169
Accessory Kit for TIG Torch with 1/16", 3/32", 1/8" thoriated tungstens; 1/16", 3/32", 1/8" collets; 1/16", 3/32", 1/8" collet bodies; No. 5, 6, 7 Alumina nozzle; short back cap; long back cap	P062900010

Table 2-2: Fabricator 181i Options and Accessories List

SECTION 3:
INSTALLATION, OPERATION AND SETUP

3.01 Environment

This Power Source is designed for use in environments with increased hazard of electric shock.

A. Examples of environments with increased hazard of electric shock are:

   1. In locations in which freedom of movement is restricted, so that the operator is forced to perform the work in a cramped (kneeling, sitting or lying) position with physical contact with conductive parts.

   2. In locations which are fully or partially limited by conductive elements, and in which there is a high risk of unavoidable or accidental contact by the operator.

   3. In wet or damp hot locations where humidity or perspiration considerable reduces the skin resistance of the human body and the insulation properties of accessories.

B. Environments with increased hazard of electric shock do not include places where electrically conductive parts in the near vicinity of the operator, which can cause increased hazard, have been insulated.

3.02 Location

Be sure to locate the welder according to the following guidelines:

A. In areas, free from moisture and dust.

B. Ambient temperature between 32 to 104° F (0 to 40° C).

C. In areas, free from oil, steam and corrosive gases.

D. In areas, not subjected to abnormal vibration or shock.

E. In areas, not exposed to direct sunlight or rain.

F. Place at a distance of 12"(300mm) or more from walls or similar that could restrict natural air flow for cooling.

G. The enclosure design of this Power Source meets the requirements of IP23S as outlined in EN 60529. This provides adequate protection against solid objects (greater than 1/2", 12mm), and direct protection from vertical drops. Under no circumstances should the Power Source be operated or connected in a micro environment that will exceed the stated conditions. For further information please refer to EN 60529.

H. Precautions must be taken against the power source toppling over. The power source must be located on a suitable horizontal surface in the upright position when in use.

WARNING

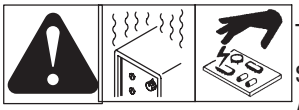
This equipment should be electrically connected by a qualified electrician.

3.03 Ventilation

WARNING

Since the inhalation of welding fumes can be harmful, ensure that the welding area is effectively ventilated.

3.04 Electricity Supply Voltage



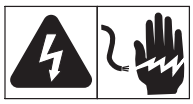
The Electricity Supply voltage should be within 208-265V AC. Too low a voltage may cause poor welding performance in STICK mode. Too high a supply voltage will cause components to overheat and possibly fail.

The Welding Power Source must be:

- Correctly installed, if necessary, by a qualified electrician.
- Correctly earthed (electrically) in accordance with local regulations.
- Connected to the correct size power point and fuse as per the Specifications on page 2-4.

WARNING

The Fabricator 211i must be electrically connected by a qualified electrical trades-person. Damage to the PCA (Power Control Assembly) could occur if 265 VAC or higher is applied to the Primary Power Cable



WARNING

ELECTRIC SHOCK can kill; SIGNIFICANT DC VOLTAGE is present after removal of input power. ***DO NOT TOUCH*** *live electrical parts.*

SHUT DOWN welding Power Source, disconnect input power employing lockout/tagging procedures. Lock-out/tagging procedures consist of padlocking line disconnect switch in open position, removing fuses from fuse box, or shutting off and red-tagging circuit breaker or other disconnecting device.

Electrical Input Requirements

Operate the welding Power Source from a single-phase 50/60 Hz, AC power supply. The input voltage must match one of the electrical input voltages shown on the input data label on the unit nameplate. Contact the local electric utility for information about the type of electrical service available, how proper connections should be made, and inspection required. The line disconnect switch provides a safe and convenient means to completely remove all electrical power from the welding power source whenever necessary to inspect or service the unit.

Do not connect an input (WHITE or BLACK) conductor to the ground terminal.

Do not connect the ground (GREEN) conductor to an input line terminal.

- Correctly installed, if necessary, by a qualified electrician.
- Correctly earthed (electrically) in accordance with local regulations.
- Connected to the correct size power point, fuse and primary supply lead based on Table 3-1. Refer to Table 3-1.

WARNING

An electric shock or fire hazard is probable if the following t electrical service guide recommendations are not followed. These recommendations are for a dedicated branch circuit sized for the rated output and duty cycle of the welding Power Source.

	50 / 60 Hz Single Phase Supply
Supply Voltage	230V AC
Input Current at Maximum Output	35.7 Amps
Maximum Recommended Fuse* or Circuit Breaker Rating *Time Delay Fuse, UL class RK5. Refer to UL248 Maximum Recommended Fuse^ or Circuit Breaker Rating ^Normal Operating , UL class K5. Refer to UL248	50 Amps 50 Amps
Minimum Recommended Input Cable Size	12 AWG
Maximum Recommended Input Conductor Length	50 ft (15m)
Minimum Recommended Grounding Conductor Size	12 AWG

Table 3-1: Electrical Service Guide

NOTE

Welding arc outs may be experienced if an extension cord is used when STICK welding when operation the Power Source on 208 VAC due to the lack of DC voltage at the STICK electrode.

Input Power

Each unit incorporates an INRUSH circuit. When the MAIN CIRCUIT SWITCH is turned on, the inrush circuit provides pre-charging for the input capacitors. A relay in the Power Control Assembly (PCA) will turn on after the input capacitors have charged to operating voltage (after approximately 5 seconds)

NOTE

Damage to the PCA could occur if 265V AC or higher is applied to the Primary Power Cord.

Model	Primary Supply Cord Size (Factory Fitted)	Minimum Primary Current Circuit Size (Vin/Amps)	Current & Duty Cycle		
			MIG (GMAW/ FCAW)	STICK (SMAW)	LIFT TIG (GTAW)
Fabricator 181i	12 AWG (3.3mm²)	208-230V/40A	180A @ 20%	175A @ 20%	
		208-230V/25A			175A @ 25%

Table 3-2: Primary Circuit Sizes to Achieve Maximum Current

3.05 Electromagnetic Compatibility

WARNING

Extra precautions for Electromagnetic Compatibility may be required when this Welding Power Source is used in a domestic situation.

A. Installation and Use - Users Responsibility

The user is responsible for installing and using the welding equipment according to the manufacturer's instructions. If electromagnetic disturbances are detected then it shall be the responsibility of the user of the welding equipment to resolve the situation with the technical assistance of the manufacturer. In some cases this remedial action may be as simple as earthing the welding circuit, see NOTE below. In other cases it could involve constructing an electromagnetic screen enclosing the Welding Power Source and the work, complete with associated input filters. In all cases, electromagnetic disturbances shall be reduced to the point where they are no longer troublesome.

NOTE

The welding circuit may or may not be earthed for safety reasons. Changing the earthing arrangements should only be authorized by a person who is competent to assess whether the changes will increase the risk of injury, e.g. by allowing parallel welding current return paths which may damage the earth circuits of other equipment. Further guidance is given in EN 60974-13 Arc Welding Equipment - Installation and use (under preparation).

B. Assessment of Area

Before installing welding equipment, the user shall make an assessment of potential electromagnetic problems in the surrounding area. The following shall be taken into account

1. Other supply cables, control cables, signaling and telephone cables; above, below and adjacent to the welding equipment.
2. Radio and television transmitters and receivers.
3. Computer and other control equipment.
4. Safety critical equipment, e.g. guarding of industrial equipment.
5. The health of people around, e.g. the use of pacemakers and hearing aids.
6. Equipment used for calibration and measurement.
7. The time of day that welding or other activities are to be carried out.

8. The immunity of other equipment in the environment: the user shall ensure that other equipment being used in the environment is compatible: this may require additional protection measures.

The size of the surrounding area to be considered will depend on the structure of the building and other activities that are taking place. The surrounding area may extend beyond the boundaries of the premises.

C. Methods of Reducing Electromagnetic Emissions

1. Electricity Supply

   Welding equipment should be connected to the Electricity Supply according to the manufacturer's recommendations. If interference occurs, it may be necessary to take additional precautions such as filtering of the Electricity Supply. Consideration should be given to shielding the supply cable of permanently installed welding equipment in metallic conduit or equivalent. Shielding should be electrically continuous throughout it's length. The shielding should be connected to the Welding Power Source so that good electrical contact is maintained between the conduit and the Welding Power Source enclosure.

2. Maintenance of Welding Equipment

   The welding equipment should be routinely maintained according to the manufacturer's recommendations. All access and service doors and covers should be closed and properly fastened when the welding equipment is in operation. The welding equipment should not be modified in any way except for those changes and adjustments covered in the manufacturer's instructions. In particular, the spark gaps of arc striking and stabilizing devices should be adjusted and maintained according to the manufacturer's recommendations.

3. Welding Cables

   The welding cables should be kept as short as possible and should be positioned close together, running at or close to the floor level.

4. Equipotential Bonding

   Bonding of all metallic components in the welding installation and adjacent to it should be considered. However. Metallic components bonded to the work piece will increase the risk that the operator could receive a shock by touching the metallic components and the electrode at the same time. The operator should be insulated from all such bonded metallic components.

5. Earthing of the Workpiece

   Where the workpiece is not bonded to earth for electrical safety, nor connected to earth because of it's size and position, e.g. ship's hull or building steelwork, a connection bonding the workpiece to earth may reduce emissions in some, but not all instances. Care should be taken to prevent the earthing of the workpiece increasing the risk of injury to users, or damage to other electrical equipment. Where necessary, the connection of the workpiece to earth should be made by direct connection to the workpiece, but in some countries where direct connection is not permitted, the bonding should be achieved by suitable capacitance, selected according to national regulations.

6. Screening and Shielding

   Selective screening and shielding of other cables and equipment in the surrounding area may alleviate problems of interference. Screening the entire welding installation may be considered for special applications.

3.06 Victor Regulator

Pressure regulator (Figure 3-1) attached to the cylinder valve reduce high cylinder pressures to suitable low working pressures for welding, cutting, and other applications.

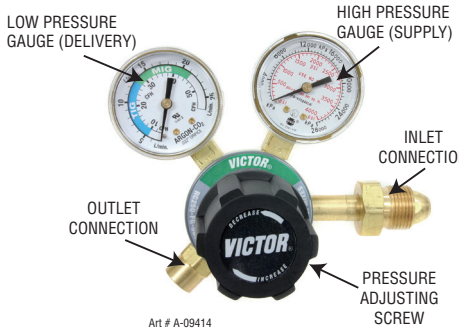


Figure 3-1: Victor CS Regulator

WARNING

Use the regulator for the gas and pressure for which it is designed. NEVER alter a regulator for use with any other gas.

NOTE

Regulators purchased with open 1/8", 1/4", 3/8", or 1/2" NPT ports must be assembled to their intended system.

1. Note the maximum inlet pressure stamped on the regulator. DO NOT attach the regulator to a system that has a higher pressure than the maximum rated pressure stamped on the regulator.
2. The regulator body will be stamped "IN" or "HP" at the inlet port. Attach the inlet port to the system supply pressure connection.
3. Wrap pipe threads with Teflon tape 1 1/2 to 2 turns to effect a seal. If other sealants are used, they must be compatible with the gas that will be used in the system.
4. If gauges are to be attached to the regulator and the regulator is stamped and listed by a third party (i.e. "UL" or "ETL"). The following requirements must be met:
   a) Inlet gauges over 1000 PSIG (6.87 mPa) shall conform with the requirements of UL 404, "Indicating Pressure Gauges for Compressed Gas Service."
   b) Low pressure gauges must be UL recognized for the class of regulator they are being used on according to UL252A.

WARNING

DO NOT use a regulator that delivers pressure exceeding the pressure rating of the downstream equipment unless provisions are made to prevent over-pressurization (i.e. system relief valve). Make sure the pressure rating of the downstream equipment is compatible with the maximum delivery pressure of the regulator.

5. Be sure that the regulator has the correct pressure rating and gas service for the cylinder used.
6. Carefully inspect the regulator for damaged threads, dirt, dust, grease, oil, or other flammable substances. Remove dust and dirt with a clean cloth. Be sure the inlet swivel filter is clean and in place. Attach the regulator (Figure 3-2) to the cylinder valve. Tighten securely with a wrench.

WARNING

DO NOT attach or use the regulator if oil, grease, flammable substances or damage is present! Have a qualified repair technician clean the regulator or repair any damage.

Figure 3-2: Regulator to Cylinder Valve

7. Before opening the cylinder valve, turn the regulator adjusting screw counterclockwise until there is no pressure on the adjusting spring and the screw turns freely.
8. Relief Valve (where provided): The relief valve is designed to protect the low pressure side of the regulator from high pressures. Relief valves are not intended to protect downstream equipment from high pressures.

WARNING

DO NOT tamper with the relief valve or remove it from the regulator.

WARNING

Stand to the side of the cylinder opposite the regulator when opening the cylinder valve. Keep the cylinder valve between you and the regulator. For your safety, NEVER STAND IN FRONT OF OR BEHIND A REGULATOR WHEN OPENING THE CYLINDER VALVE!

9. Slowly and carefully open the cylinder valve (Figure 3-3) until the maximum pressure shows on the high pressure gauge.

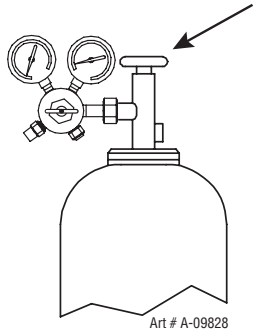


Figure 3-3: Open Cylinder Valve

10. On all cylinders, except acetylene, open the valve completely to seal the valve packing. On gaugeless regulators, the indicator will register the cylinder contents open.

11. On acetylene cylinders, open the valve 3/4 of a turn and no more than 1-1/2.

WARNING

Acetylene delivery pressure must not exceed 15 PSIG (103 kPa) or 30 PSIG (207 kPa). Acetylene can dissociate (decompose with explosive violence) above these pressure limits.

CAUTION

Keep the cylinder valve wrench, if one is required, on the cylinder valve to turn off the cylinder quickly, if necessary.

12. Attach the desired downstream equipment.

3.07 Leak Testing the System

Leak test the system before putting into operation.

1. Be sure that there is a valve in the downstream equipment to turn off the gas flow.
2. With the cylinder valve open, adjust the regulator to deliver the maximum required delivery pressure.
3. Close the cylinder valve.
4. Turn the adjusting screw/knob counterclockwise one turn.
   a) If the high-pressure gauge reading drops, there is a leak in the cylinder valve, inlet fitting, or high-pressure gauge.
   b) If the low-pressure gauge drops, there is a leak in the downstream equipment, hose, hose fitting, outlet fitting or low-pressure gauge. Check for leaks using an approved leak detector solution.
   c) If the high-pressure gauge drops and the low-pressure gauge increases at the same time, there is a leak in the regulator seat.
   d) If the regulator requires service or repair, take it to a qualified repair technician.
5. Once leak testing has been performed and there are no leaks in the system, slowly open the cylinder valve and proceed.

WARNING

If a leak has been detected anywhere in the system, discontinue use and have the system repaired. DO NOT use leaking equipment. Do not attempt to repair a leaking system while the system is under pressure.

3.08 When You Finish Using the Regulator

1. Close the cylinder valve.
2. Open the valve on the downstream equipment. This drains all pressure from the system.
3. Close the valve on the downstream equipment.
4. Turn the adjusting screw counterclockwise to release the tension on the adjusting spring.
5. Check the gauges after a few minutes for verification that the cylinder valve is closed completely.

3.09 Storage of the Regulator

When the regulator is not in use and has been removed from the cylinder, it should be stored in an area where it will be protected from dust, oil, and grease. The inlet and outlet should be capped to protect against internal contamination and prevent insects from nesting.

3.10 Power Source Controls, Indicators and Features

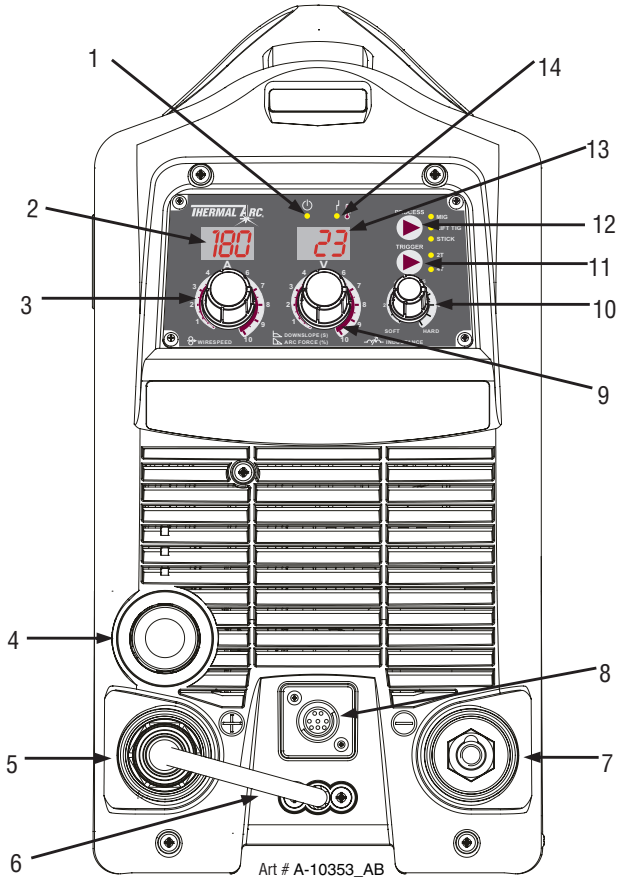


Figure 3-4: Front Panel

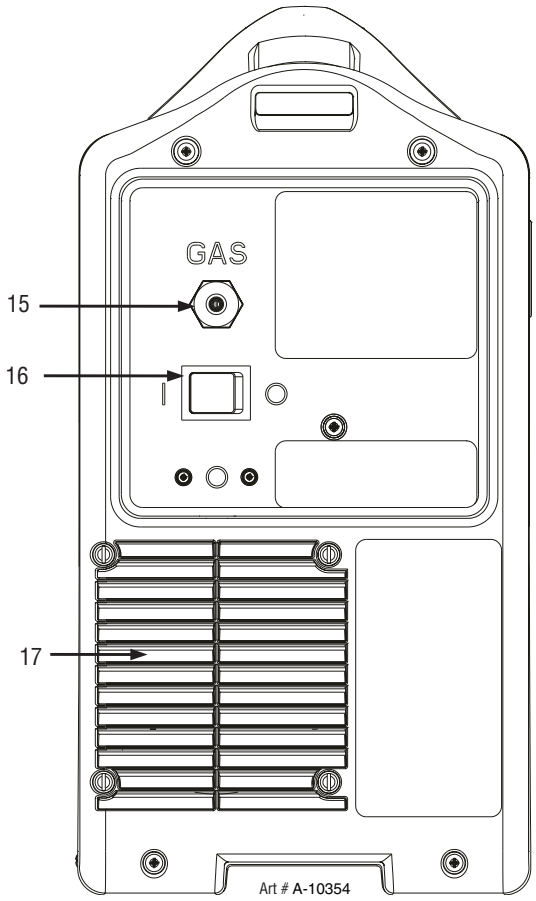


Figure 3-5: Rear Panel

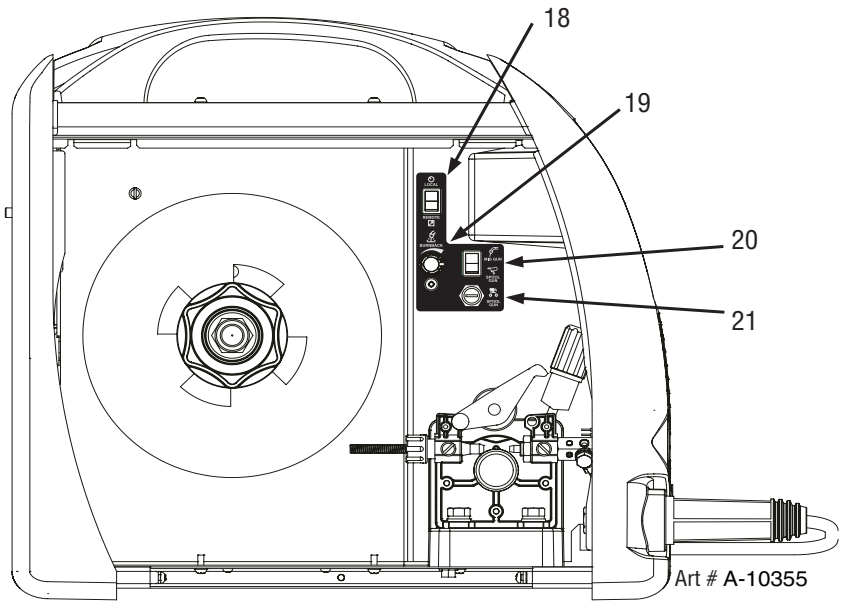


Figure 3-6: Wire Feed Compartment Control

1. Power Indicator

The power indicator is illuminated when the Electricity Supply is applied to the Power Source and when the ON/OFF switch located on the rear panel is in the ON position.

2. Digital Wirespeed/Amperage Meter (Left Digital Display)

This digital meter displays preview Wirespeed in MIG mode only then actual amperage (weld current) once an arc has been established. It also displays preview amperage in both the STICK and LIFT TIG modes only then actual amperage (weld current) once an arc has been established.

At times of non-welding, the amperage meter will display a preview value in both STICK and LIFT TIG modes. This value can be adjusted by varying the amperage potentiometer (Control No. 3). At times of non-welding, the amperage meter will preview a wirefeed speed value (Inches Per Minute) in MIG mode only. This can be identified as preview wirefeed speed by a decimal point at the lower right hand side of the display.

When welding, the amperage meter will display actual amperage (weld current) in all modes.

At the completion of welding, the amperage meter will hold the last recorded amperage value for a period of approximately 10 seconds in all modes. The amperage meter will hold the value until; (1) any of the front panel controls are adjusted in which case the Power Source will revert to preview mode, (2) welding is recommenced, in which case actual welding amperage will be displayed, or (3) a period of 10 seconds elapses following the completion of welding in which case the Power Source will return to preview mode.

NOTE

The preview functionality provided on this power source is intended to act as a guide only. Some differences may be observed between preview values and actual welding values due to factors including the mode of welding, differences in consumables/gas mixtures, individual welding techniques and the transfer mode of the welding arc (ie dip versus spray transfer). Where exact settings are required (in the case of procedural work), it is recommended that alternate measurement methods be utilized to ensure output values are accurate.

3. Wirespeed/Amperage Control

In MIG mode, the Wirespeed/Amperage control knob adjusts the speed of the wire feed motor (which in turn adjusts the output current by varying the amount of MIG wire delivered to the welding arc). The optimum wire speed depends upon the material type and the welding application. The setup chart on the inside of the wire feed compartment door provides a brief summary of the required settings for a basic range of MIG (GMAW/FCAW) welding applications.

In STICK and LIFT TIG modes, the Wirespeed/Amperage control knob adjusts the amount of amperage (weld current) delivered to the welding arc by the Power Source. It directly adjusts the Power Source to deliver the desired level of weld current.

4. MIG Gun Adaptor (Tweco Style)

The MIG Gun adaptor is the connection point for the Tweco Gun. Connect the MIG Gun by pushing the MIG Gun connector into the brass MIG Gun Adaptor firmly and screw the locking screw in the MIG Gun Adapter within the Wire Feed Compartment to secure the Tweco MIG Gun in position. Failure to properly lock the Tweco MIG Gun into the MIG Gun Adapter will result in the Tweco MIG Gun being pushed out of the MIG Gun Adapter by the MIG welding wire or lack of shielding gas (porosity in the weld) at the weld zone.

5. Positive Welding Output Terminal

The positive welding terminal is used to connect the welding output of the Power Source to the appropriate welding accessory such as the MIG Gun (via the MIG Gun polarity lead), electrode holder lead or work lead. Positive welding current flows from the Power Source via this heavy duty bayonet type terminal. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.

CAUTION

Loose welding terminal connections can cause overheating and result in the male plug being fused in the bayonet terminal.

6. MIG Gun Polarity Lead

The polarity lead is used to connect the MIG Gun to the appropriate positive or negative output terminal (allowing polarity reversal for different welding applications). In general, the polarity lead should be connected in to the positive welding terminal (+) when using steel, stainless steel or aluminum electrode wire. When using flux cored (gasless) wire, the polarity lead is generally connected to the negative welding terminal (-). If in doubt, consult the manufacturer of the electrode wire for the correct polarity. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.

CAUTION

Loose welding terminal connections can cause overheating and result in the male plug being fused in the bayonet terminal.

7. Negative Welding Output Terminal

The negative welding terminal is used to connect the welding output of the Power Source to the appropriate welding accessory such as the MIG Gun (via the MIG Gun polarity lead), TIG Torch or work lead. Negative welding current flows to the Power Source via this heavy duty bayonet type terminal. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.

CAUTION

Loose welding terminal connections can cause overheating and result in the male plug being fused in the bayonet terminal.

8. Remote Control and Spool Gun Socket

The 8 pin socket is used to connect the Tweco MIG Gun, remote control device or spool gun plug to the welding Power Source. To make connections, align keyway, insert plug, and rotate threaded collar fully clockwise.

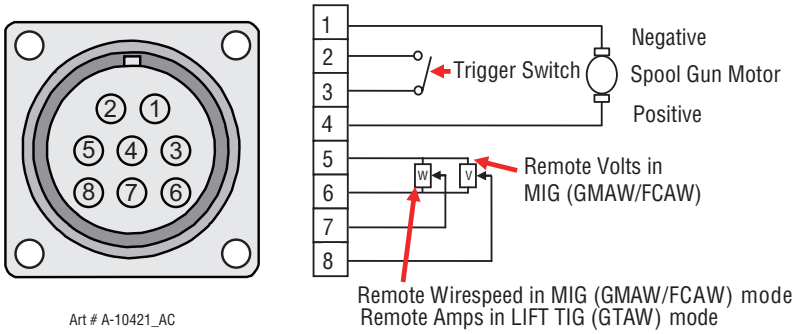


Figure 3-7: Remote Control Socket

Socket Pin	Function
1	Spool gun motor (0V)
2	Trigger Switch Input
3	Trigger Switch Input
4	Spool gun motor (+24V DC)
5	5k ohm (maximum) connection to 5k ohm remote control potentiometer.
6	Zero ohm (minimum) connection to 5k ohm remote control potentiometer.
7	Wiper arm connection to 5k ohm potentiometer for the remote control of the Wirespeed in MIG mode. Wiper arm connection to 5k ohm potentiometer for the remote control of the Amperage (Weld Current) in LIFT TIG mode.
8	Wiper arm connection to 5k ohm remote control Volts MIG mode potentiometer.

Table 3-3

Note that the Remote / Local Switch (Control No. 28) located in the wirefeed compartment should be set to Remote for remote amperage/voltage controls to operate.

9. Multifunction Control - Voltage, Down Slope & Arc Force

The multifunction control knob is used to adjust Voltage (MIG Mode), Down slope (LIFT TIG Mode) and Arc Force (STICK Mode) depending on the welding mode selected.

NOTE

The preview functionality provided on this power source is intended to act as a guide only. Some differences may be observed between preview values and actual welding values due to factors including the mode of welding, differences in consumables/gas mixtures, individual welding techniques and the transfer mode of the welding arc (ie dip versus spray transfer). Where exact settings are required (in the case of procedural work), it is recommended that alternate measurement methods be utilized to ensure output values are accurate.

When MIG Mode is Selected

In this mode the control knob is used to adjust the MIG welding voltage of the Power Source. The welding voltage is increased by turning the knob clockwise or decreased by turning the knob counterclockwise. The optimum voltage level required will depend on the type of welding application. The setup chart on the inside of the wire feed compartment door provides a brief summary of the required output settings for a basic range of MIG welding applications.

When STICK Mode is Selected

In this mode the multifunction control knob is used to adjust arc force. Arc force control provides an adjustable amount of welding force (or "dig") control. This feature can be particularly beneficial in providing the operator the ability to compensate for variability in joint fit-up in certain situations with particular electrodes. In general increasing the arc force control toward '10' (maximum arc force) allows greater penetration control to be achieved. Arc force is increased by turning the control knob clockwise or decreased by turning the knob counterclockwise.

When LIFT TIG Mode is Selected

In this mode the multifunction control knob is used to adjust down slope. Down slope allows the user to select the ramp down time of the amperage at the completion of the weld. The main function of down slope is to allow the welding current to be gradually reduced over a pre-set time frame such that the welding pool is given time to cool sufficiently.

Note that when in 2T normal mode (Control No. 11), the Power Source will enter down slope mode as soon as the trigger switch is released (ie if the multifunction control knob is set to 5, the Power Source will ramp down from the present welding current to zero over 5 seconds). If no down slope time is set then the welding output will cease immediately. If the Power Source is set to 4T latch mode, to enter down slope mode the trigger must be held in for the selected time period (ie press and release trigger to commence welding, then press and hold trigger again to enter down slope mode). Should the trigger be released during the down slope phase (4T only), the output will cease immediately.

10. Arc Control (Inductance)

The arc control operates in MIG mode only and is used to adjust the intensity of the welding arc. Lower arc control settings make the arc softer with less weld spatter. Higher arc control settings give a stronger driving arc which can increase weld penetration. Soft means maximum inductance while Hard means minimum inductance.

11. Trigger Mode Control (MIG and LIFT TIG Mode only)

The trigger mode control is used to switch the functionality of the of the MIG or TIG Trigger Switch between 2T (normal) and 4T (latch mode)

2T (Normal Mode)

In this mode, the MIG or TIG Trigger Switch must remain depressed for the welding output to be active. Press and hold the MIG or TIG Trigger Switch to activate the Power Source (weld). Release the MIG or TIG Trigger Switch to cease welding.

4T (Latch Mode)

This mode of welding is mainly used for long welding runs to reduce operator fatigue. In this mode the operator can press and release the MIG or TIG Trigger Switch and the output will remain active. To deactivate the Power Source, the trigger switch must again be depressed and released, thus eliminating the need for the operator to hold the MIG or TIG Trigger Switch

Note that when operating in LIFT TIG mode, the Power Source will remain activated until the selected Downslope time has elapsed (refer Control No. 9).

12. Process Selection Control

The process selection control is used to select the desired welding mode. Three modes are available, MIG, LIFT TIG and STICK modes. Refer to section 3.15 or 3.16 for MIG (GMAW/FCAW) set up details, section 3.17 for LIFT TIG (GTAW) set-up details or section 3.18 for STICK (SMAW) set-up details.

Note that when the Power Source is powered off the mode selection control will automatically default to MIG mode. This is necessary so as to prevent inadvertent arcing should an electrode holder be connected to the Power Source and mistakenly be in contact with the work piece during power up.

13. Digital Voltage Meter (Right Digital Display)

The digital voltage meter is used to display the both the preview voltage (MIG mode only) and actual output voltage (all modes) of the Power Source.

At times of non-welding, the voltage meter will display a preview value in MIG mode. This value can be adjusted by varying the multifunction control knob (Control No. 9). Note that in STICK and LIFT TIG modes, the voltage meter will not preview welding voltage but will display Open Circuit Voltage in STICK mode and 0V in LIFT TIG mode.

When welding, the voltage meter will display actual welding voltage in all modes.

At the completion of welding, the digital voltage meter will hold the last recorded voltage value for a period of approximately 10 seconds in all modes. The voltage meter will hold the value until; (1) any of the front panel controls are adjusted in which case the Power Source will revert to preview mode, (2) welding is recommenced, in which case actual welding amperage will be displayed, or (3) a period of 10 seconds elapses following the completion of welding in which case the Power Source will return to preview mode.

NOTE

The preview functionality provided on this power source is intended to act as a guide only. Some differences may be observed between preview values and actual welding values due to factors including the mode of welding, differences in consumables/gas mixtures, individual welding techniques and the transfer mode of the welding arc (ie dip versus spray transfer). Where exact settings are required (in the case of procedural work), it is recommended that alternate measurement methods be utilized to ensure output values are accurate.

14. Thermal Overload Indicator

This welding Power Source is protected by a self resetting thermostat. The indicator will illuminate if the duty cycle of the Power Source has been exceeded. Should the thermal overload indicator illuminate the output of the Power Source will be disabled. Once the Power Source cools down this light will go OFF and the over temperature condition will automatically reset. Note that the power switch should remain in the on position such that the fan continues to operate thus allowing the Power Source to cool sufficiently. Do not switch the Power Source off should a thermal overload condition be present.

15. Gas Inlet (MIG mode only for MIG Gun or Spool Gun operation)

The Gas Inlet connection is used to supply the appropriate MIG welding gas to the Power Source. Refer to section 3.15 or 3.16 for MIG (FCAW/GMAW) set up details.

WARNING

Only Welding Shielding Gases specifically designed for arc welding applications should be used.

16. On / Off Switch

This switch is used to turn the Power Source on/off.

WARNING

When the front digital displays are lit, the machine is connected to the Mains supply voltage and the internal electrical components are at Mains voltage potential.

17. Intelligent Fan Control

The Fabricator 181i is designed with an intelligent fan control. It automatically switches the cooling fan off when it is not required. This has two main advantages; (1) to minimize power consumption, and (2) to minimize the amount of contaminants such as dust that are drawn into the Power Source.

Note that the fan will only operate when required for cooling purposes and will automatically switch off when not required.

Note in STICK mode the fan operates continuously.

18. Local / Remote Switch (located in wirefeed compartment)

The remote / local switch is used only when a remote control device (such as a TIG Torch with remote current control) is fitted to the Power Source via the remote control socket (Control No. 8). When the local/remote switch is in the remote position, the Power Source will detect a remote device and work accordingly. When in the local mode, the Power Source will not detect the remote device and will operate from the Power Source controls only. Note that the trigger will operate at all times on the remote control socket irrespective of the position of the local remote switch (ie in both local and remote modes).

Should a remote device be connected and the remote/local switch set to remote, the maximum setting of the Power Source will be determined by the respective front panel control, irrespective of the remote control device setting. As an example, if the output current on the Power Source front panel is set to 50% and the remote control device is set to 100%, the maximum achievable output from the Power Source will be 50%. Should 100% output be required, the respective front panel control must be set to 100%, in which case the remote device will then be able to control between 0-100% output.

19. Burnback Control (located in wirefeed compartment)

The Burnback control is used to adjust the amount of MIG wire that protrudes from the MIG Gun after the completion of MIG welding (commonly referred to as stick-out). To decrease the Burnback time (or lengthen the amount of wire protruding from the MIG Gun at the completing of welding), turn the Burnback control knob counterclockwise . To increase the Burnback time (or shorten the amount of wire protruding from the MIG Gun at the completing of welding), turn the Burnback Control knob clockwise.

20. MIG Gun & Spool Gun Switch

The MIG Gun / Spool Gun switch is used to switch welding mode between MIG Gun functionality and Spool Gun functionality

21. 10A Fuse

The 10A fuse is used to protect the spool gun motor.

3.11 Attaching the Tweco WeldSkill 180 Gun

Fit the MIG Gun to the Power Source by pushing the MIG Gun connector into the MIG Gun Adaptor and tightening the Locking Screw to secure the MIG Gun in the MIG Gun Adapter.

Connect the 8 pin plug by aligning the keyway then inserting the 8 pin plug into the 8 pin socket and rotate threaded collar fully clockwise to lock the plug into position.

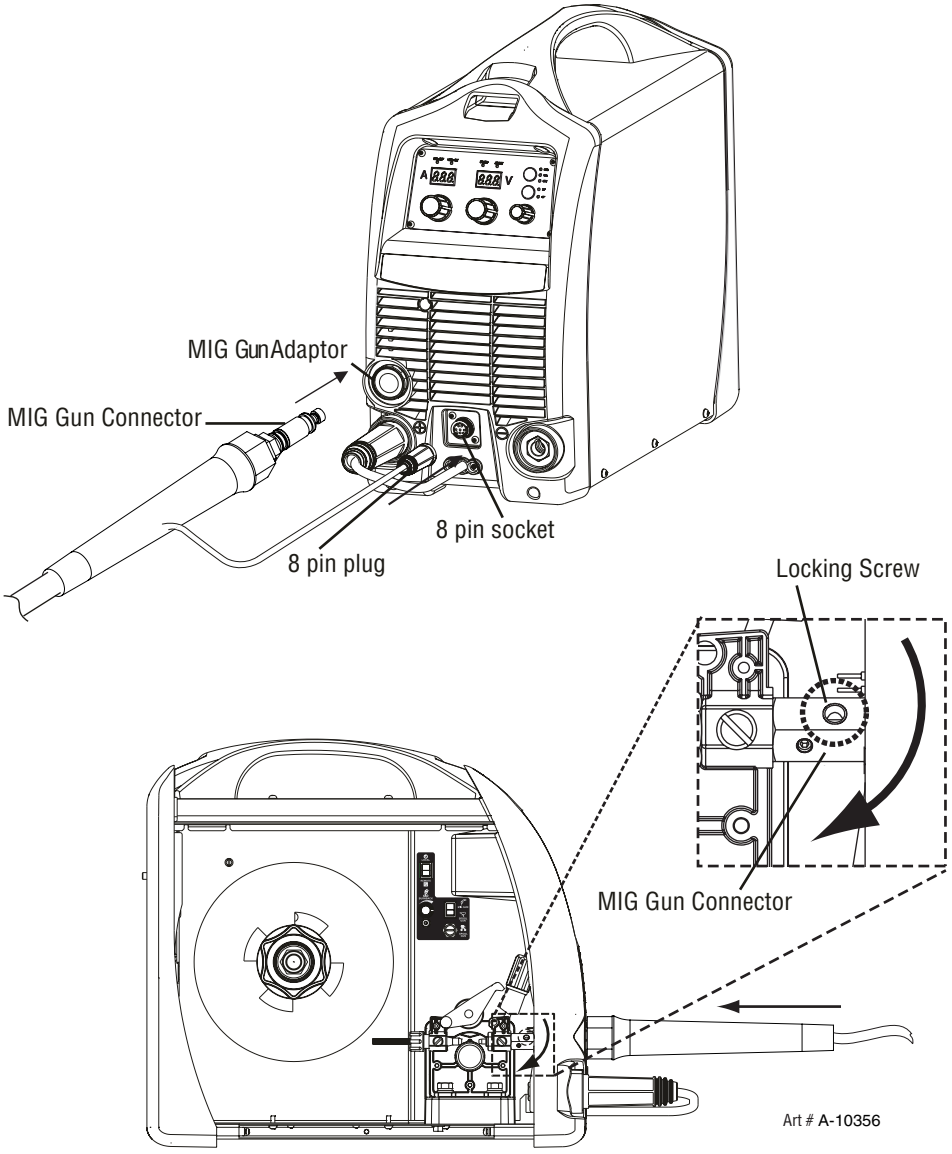


Figure 3-8: Attaching MIG Gun

3.12 Installing 4" (100mm) Diameter Spool

As delivered from the factory, the Power Source is fitted with a Wire Spool Hub which accepts a 8" (200mm) diameter spools. In order to fit a 4" (100mm) diameter spool assemble parts in the sequence shown below in Figure 3-9.

Adjustment of the nut with nylon insert will control the MIG Wire Spool Brake. Clockwise rotation of this nut with nylon insert tightens the brake. The brake is correctly adjusted when the spool stops within 4" (100mm) to 8" (200mm) (measured at the outer edge of the spool) after MIG Gun trigger is released. Wire should be slack without becoming dislodged from the spool.

CAUTION

Overtension of brake will cause rapid wear of mechanical WIREFEED parts, overheating of electrical components and possibly an increased incidence of electrode wire Burnback into contact tip.

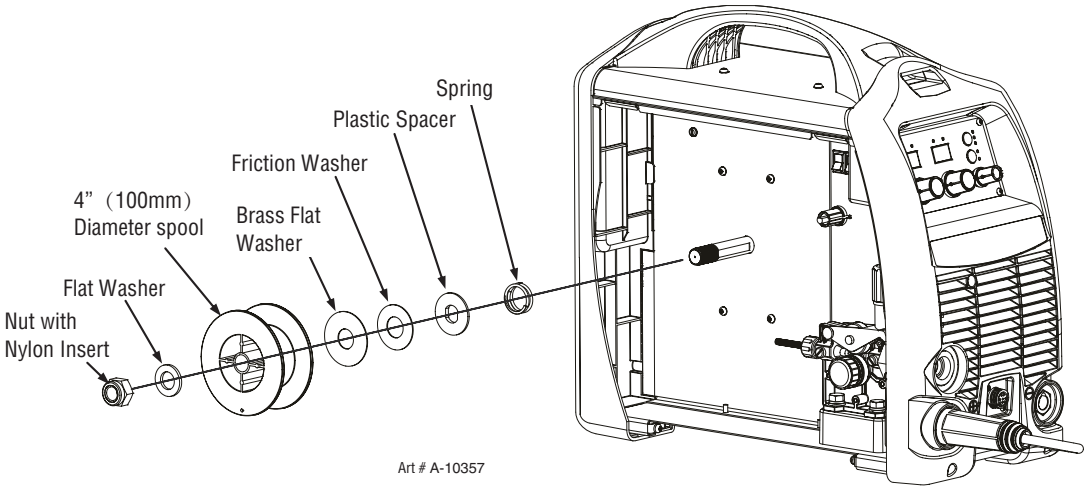


Figure 3-9: 4" (100mm)Diameter Spool Installation

3.13 Installing 8" (200mm) Diameter Spool

As delivered from the factory, the Power Source is set for a 8" (200mm) diameter spool.

In order to re-fit a 8" (200mm) spool assemble parts in the sequence shown below in Figure 3-10.

Adjustment of the nut with nylon insert will control the MIG Wire Spool Brake. Clockwise rotation of this nut with nylon insert tightens the brake. The Brake is correctly adjusted when the spool stops within 3/8" (10mm) to 3/4" (20mm) (measured at the outer edge of the spool) after MIG Gun trigger is released. Wire should be slack without becoming dislodged from the spool.

CAUTION

Overtension of brake will cause rapid wear of mechanical WIREFEED parts, overheating of electrical components and possibly an increased incidence of electrode wire Burnback into contact tip.

Ensure that the alignment pin on the wire spool hub aligns with the hole allocated in 8" (200mm) diameter spool.

NOTE

This alignment pin can be removed by unscrewing in an counterclockwise direction and locating in the appropriate position.

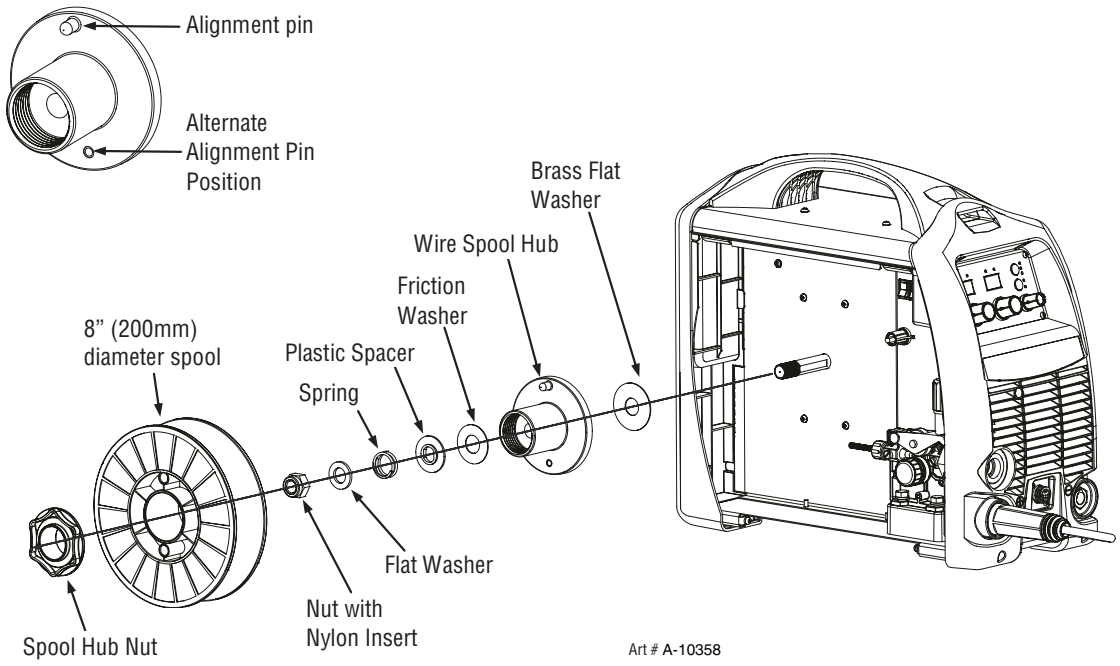


Figure 3-10: 8" (200mm) Diameter Spool Installation

3.14 Inserting Wire into the Wire Feed Mechanism

Release the tension from the Pressure Roller Arm by turning the adjustable Wire Drive Tension Screw in an counterclockwise. Then to release the pressure roller arm push the tension screw toward the front of the machine which releases the pressure roller arm (Figure 3-11). With the MIG welding wire feeding from the bottom of the spool (Figure 3-12) pass the electrode wire through the inlet guide, between the rollers, through the outlet guide and into the MIG Gun

. Re-secure the pressure roller arm and wire drive tension screw and adjust the pressure accordingly (Figure 3-11). Remove the contact tip from the MIG Gun. With the MIG Gun lead reasonably straight, feed the wire through the MIG Gun by depressing the trigger switch. Fit the appropriate contact tip.

WARNING

Before connecting the work clamp to the work make sure the Electricity Supply is switched off.

The electrode wire will be at welding voltage potential while it is being fed through the system.

Keep MIG Gun away from eyes and face.

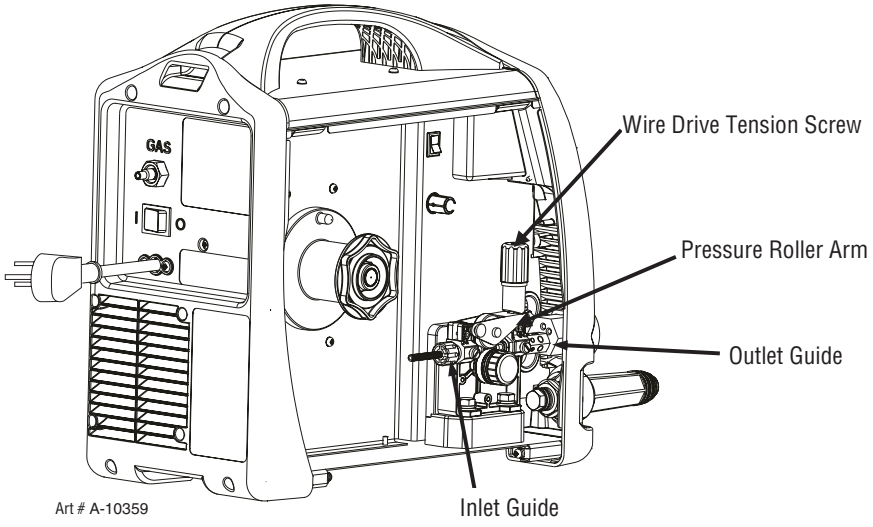


Figure 3-11: Wire Drive Assembly Components

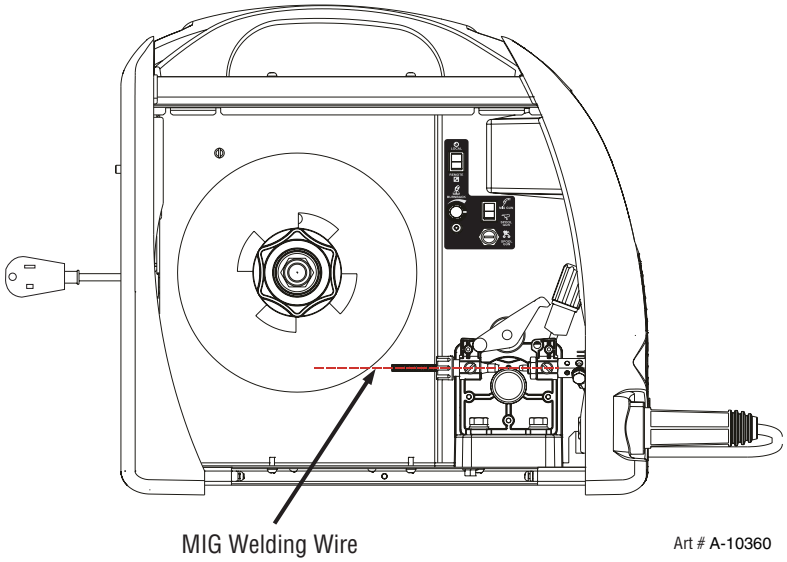


Figure 3-12: MIG Welding Wire - Installation

3.15 Feed Roller Pressure Adjustment

The pressure (top) roller applies pressure to the grooved feed roller via an adjustable pressure screw. These devices should be adjusted to a minimum pressure that will provide satisfactory WIREFEED without slippage. If slipping occurs, and inspection of the wire contact tip reveals no wear, distortion or burn back jam, the conduit liner should be checked for kinks and clogging by metal flakes and swarf. If it is not the cause of slipping, the feed roll pressure can be increased by rotating the pressure screw clockwise.

WARNING

Before changing the feed roller ensure that the Electricity Supply to the Power Source is switched off.

CAUTION

The use of excessive pressure may cause rapid wear of the feed rollers, shafts and bearing.

3.16 Changing the Feed Roll

To change feed roll remove the feed roll retaining screw by turning in an counterclockwise direction. Once the feed roll is removed then to replace feed roll simply reverse these directions.

A dual groove feed roller is supplied as standard. It can accommodate 023"(0.6mm) -.030" (0.8mm) diameter hard wires. Select the roller required with the chosen wire size marking facing outward.

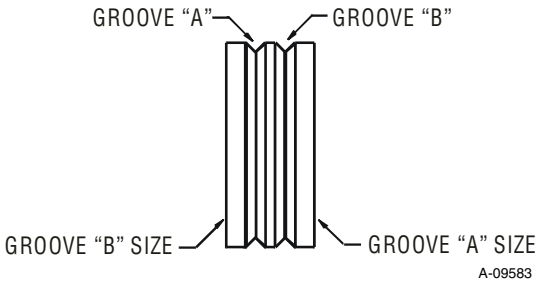


Figure 3-13: Dual Groove Feed Roller

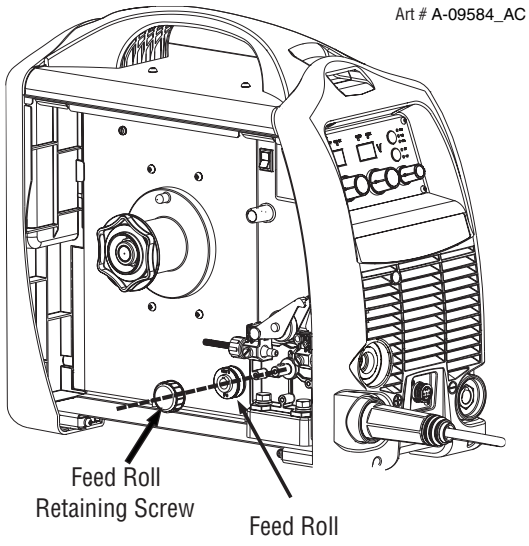


Figure 3-14: Changing the Feed Roll

3.17 Wire Reel Brake

The wire reel hub incorporates a friction brake which is adjusted during manufacture for optimum breaking. If it is considered necessary, adjustment can be made by turning the large nut inside the open end of the hub clockwise to tighten the brake. Correct adjustment will result in the wire reel circumference continuing no further than 3/8" (10mm) - 3/4" (20mm) after release of the trigger. The electrode wire should be slack without becoming dislodged from wire spool.

CAUTION

Overtension of brake will cause rapid wear of mechanical WIREFEED parts, overheating of electrical components and possibly an increased incidence of electrode wire Burnback into contact tip.

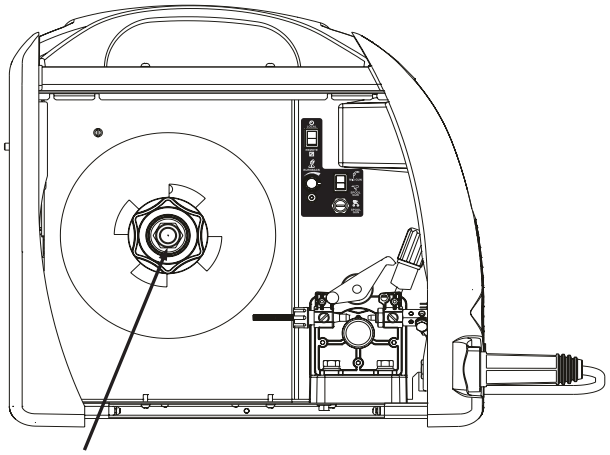


Figure 3-15: Wire Reel Brake

3.18 Gas Regulator Operation

With the regulator connected to cylinder or pipeline, and the adjustment screw/knob fully disengaged, pressurize as follows:

1. Stand to one side of regulator and slowly open the cylinder valve. If opened quickly, a sudden pressure surge may damage internal regulator parts.
2. With valves on downstream equipment closed, adjust regulator to approximate working pressure. It is recommended that testing for leaks at the regulator connection points be carried out using a suitable leak detection solution or soapy water.
3. Purge air or other unwanted welding grade shielding gas from equipment connected to the regulator by individually opening then closing the equipment control valves. Complete purging may take up to ten seconds or more, depending upon the length and size of the hose being purged.

Adjusting Flow Rate

With the regulator ready for operation, adjust working flow rate as follows:

1. Adjust the gas flow rate. The recommended rate for MIG welding is 28-46 CFH. The recommended rate for LIFT TIG welding is 10-28 CFH.

NOTE

It may be necessary to re-check the shielding gas regulator flow rate following the first weld sequence due to back pressure present within shielding gas hose assembly.

Shutdown

Close cylinder valve whenever the regulator is not in use. To shut down for extended periods (more than 30 minutes).

1. Close cylinder or upstream valve tightly.
2. Open downstream equipment valves to drain the lines. Bleed gas into a well ventilated area and away from any ignition source.
3. After gas is drained completely, disengage adjusting screw and close downstream equipment valves.
4. Before transporting cylinders that are not secured on a cart designed for such purposes, remove regulators.

3.19 Setup for MIG (GMAW) Welding with Gas Shielded MIG Wire

A. Select MIG mode with the process selection control. (refer to Section 3.10 for further information)

B. Connect the MIG Gun Polarity Lead to the positive welding terminal (+). If in doubt, consult the electrode wire manufacturer. Welding current flows from the Power Source via heavy duty bayonet type terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.

C. Fit the MIG Gun to the Power Source. (Refer to section 3.07 Attaching the Tweco WeldSkill 180 MIG Gun).

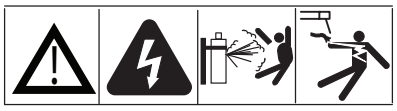
D. Connect the work lead to the negative welding terminal (-). If in doubt, consult the electrode wire manufacturer. Welding current flows from the Power Source via heavy duty bayonet type terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.

E. Fit the gas regulator/flow gauge to the shielding gas cylinder (refer to Section 3.14) then connect the shielding gas hose from the rear of the Power Source to the regulator/flow gauge outlet.

F. Refer to the Weld Guide located on the inside of the wirefeed compartment door for further information.

G. Switch the LOCAL/REMOTE switch inside the wire feed compartment to LOCAL to use the Power Sources Wirespeed and Voltage controls.

H. Switch the MIG GUN/SPOOL GUN switch inside the wire feed compartment to MIG GUN.



WARNING

Before connecting the work clamp to the work make sure the Electricity Supply is switched off.

Secure the welding grade shielding gas cylinder in an upright position by chaining it to a suitable stationary support to prevent falling or tipping.

CAUTION

Loose welding terminal connections can cause overheating and result in the male plug being fused in the terminal.

Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.

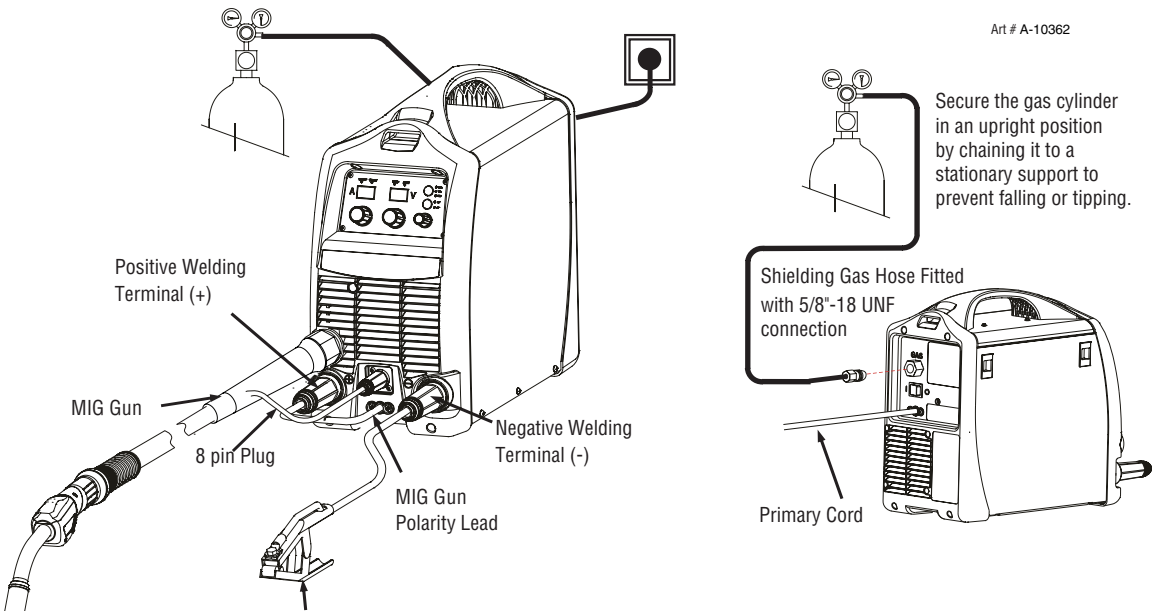


Figure 3-16: Setup for MIG Welding with Gas Shielded MIG Wire

3.20 Setup for MIG (FCAW) Welding with Flux Core (Gasless) Wire

A. Select MIG mode with the process selection control (refer to Section 3.10.12 for further information).

B. Connect the MIG Gun Polarity Lead to the negative welding terminal (-). If in doubt, consult the electrode wire manufacturer. Welding current flows from the Power Source via heavy duty bayonet type terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.

C. Connect the work lead to the positive welding terminal (+). If in doubt, consult the electrode wire manufacturer. Welding current flows from the Power Source via heavy duty bayonet type terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.

D. Refer to the Weld Guide located on the inside of the wirefeed compartment door for further information.

E. Switch the LOCAL/REMOTE switch inside the wire feed compartment to LOCAL to use the Power Sources Wirespeed and Voltage controls.

F. Switch the MIG GUN/SPOOL GUN switch inside the wire feed compartment to MIG GUN.

WARNING

Before connecting the work clamp to the work make sure the Electricity Supply is switched off.

CAUTION

Loose welding terminal connections can cause overheating and result in the male plug being fused in the terminal.

Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.

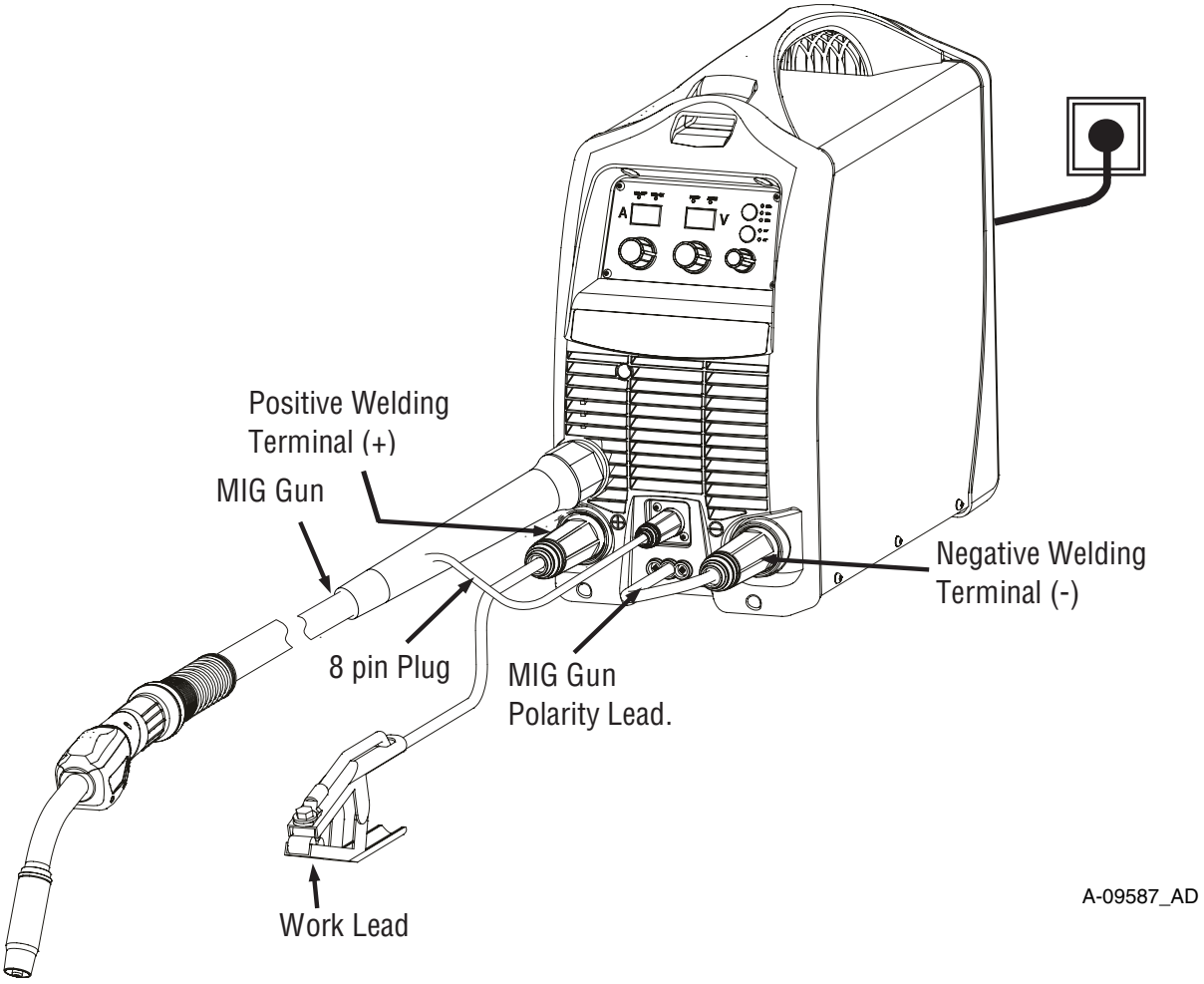


Figure 3-17: Setup for MIG (FCAW) Welding with Flux Cored (Gasless) Wire

3.21 Setup for SPOOL GUN MIG (GMAW) Welding with Gas Shielded MIG Wire

Set the Process Selection Control to MIG for Spool Gun welding.

For setup and operation of the spool gun, please refer to the spool gun operations manual.

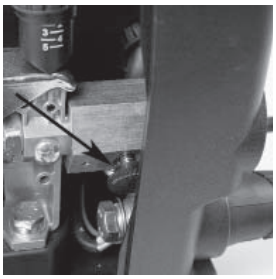
Switch the MIG GUN/SPOOL GUN switch inside the wire feed compartment to SPOOL GUN.

Connect the shielding gas for the to the Shielding Gas Inlet on the rear panel of the Power Source.

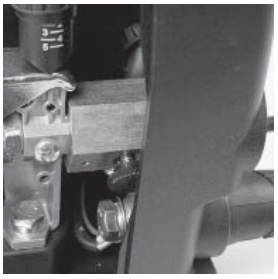
1. Make sure the welding power source is turned OFF before connecting the welding gun.

Art # A-10363

2. Open side panel and loosen thumb screw.
3. Insert the back end of the Spool gun into the gun receiving bushing.



4. Tighten thumb screw and replace side panel.



5. Connect gas supply fi tting and tighten with a wrench.
6. Align Control Plug to panel fi tting and tighten securely.

3.22 Setup for LIFT TIG (GTAW) Welding

A. Select LIFT TIG mode with the process selection control (refer to Section 3.10.12 for further information).

B. Connect the TIG Torch to the negative welding terminal (-). Welding current flows from the Power Source via heavy duty bayonet type terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.

C. Connect the work lead to the positive welding terminal (+). Welding current flows from the Power Source via heavy duty bayonet type terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.

D. Connect the TIG torch trigger switch via the 8 pin socket located on the front of the Power Source as shown below. The TIG torch will require a trigger switch to weld in LIFT TIG Mode.

NOTE

A Thermal Arc 17V TIG torch with an 8 pin plug must be used to turn the weld current on/off via the TIG torch trigger switch to TIG weld OR a Thermal Arc Foot Control with an 8 pin plug must be used to turn the weld current on/off as well as providing remote control of the weld current.

E. Fit the gas regulator/flow gauge to the shielding gas cylinder (refer to Section 3.14) then connect the shielding gas hose from the TIG torch to the regulator/flow gauge outlet. Note that the TIG torch shielding gas hose is connected directly to the regulator/flow gauge. The Power Source is not fitted with a shielding gas solenoid to control the gas flow in LIFT TIG mode therefore the TIG torch will require a gas valve.

WARNING

Before connecting the work clamp to the work and inserting the electrode in the TIG Torch make sure the Electricity Supply is switched off.

Secure the welding grade shielding gas cylinder in an upright position by chaining it to a stationary support to prevent falling or tipping.

CAUTION

Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.

Loose welding terminal connections can cause overheating and result in the male plug being fused in the terminal.

F. Switch the LOCAL/REMOTE switch inside the wire feed compartment to LOCAL to use the Power Sources Amperage control or REMOTE for remote amperage using a Foot Control.

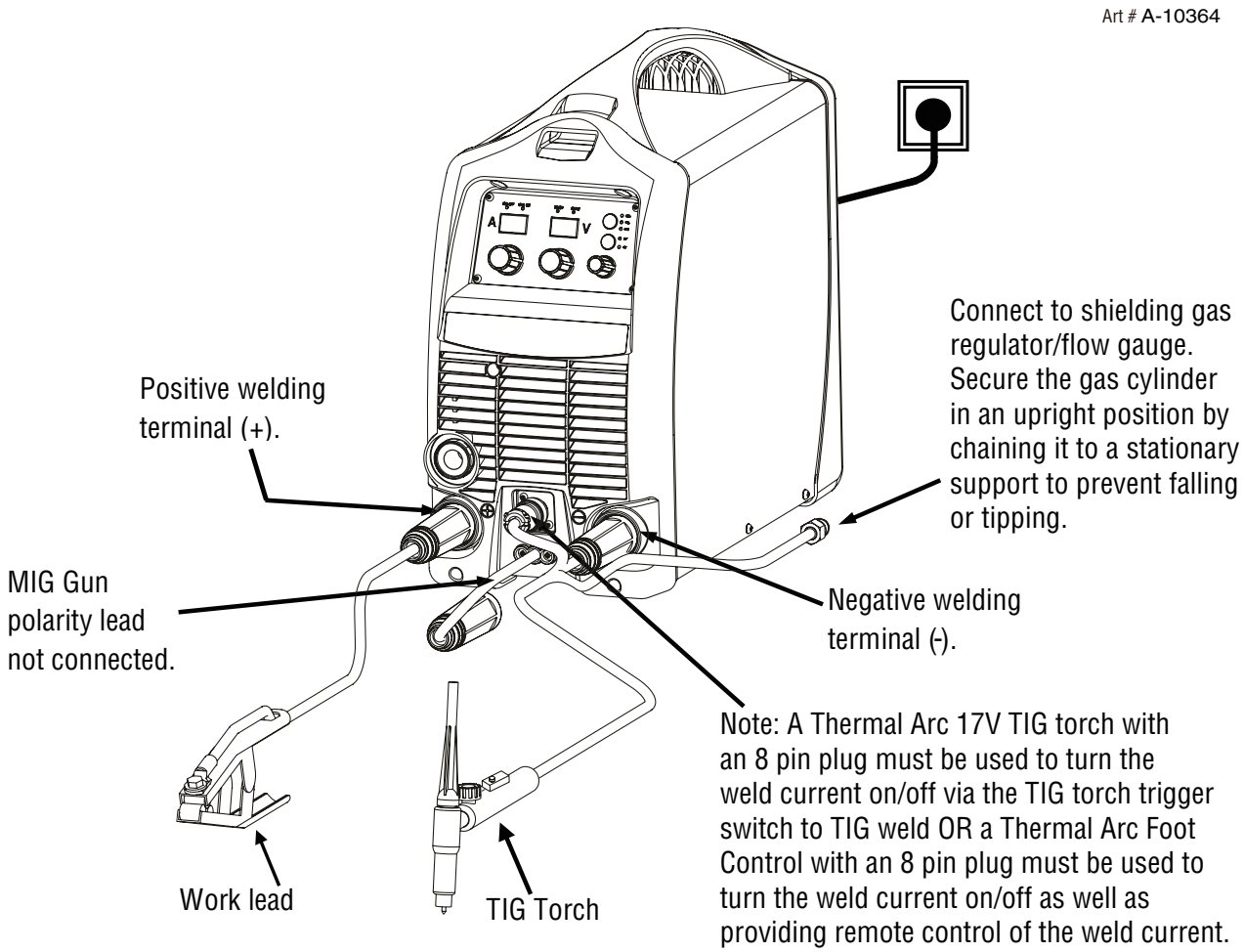


Figure 3-18: Setup for TIG Welding

3.23 Setup for STICK (SMAW) Welding

A. Connect the Electrode Holder lead to the positive welding terminal (+). If in doubt, consult the electrode manufacturer. Welding current flows from the Power Source via heavy duty bayonet type terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.

B. Connect the work lead to the negative welding terminal (-). If in doubt, consult the electrode manufacturer. Welding current flows from the Power Source via heavy duty bayonet type terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.

WARNING

Before connecting the work clamp to the work and inserting the electrode in the electrode holder make sure the Electricity Supply is switched off.

CAUSION

Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.

C. Switch the LOCAL/REMOTE switch inside the wire feed compartment to LOCAL to use the Power Sources Amperage control or REMOTE for remote amperage control using a Hand Pendant Control.

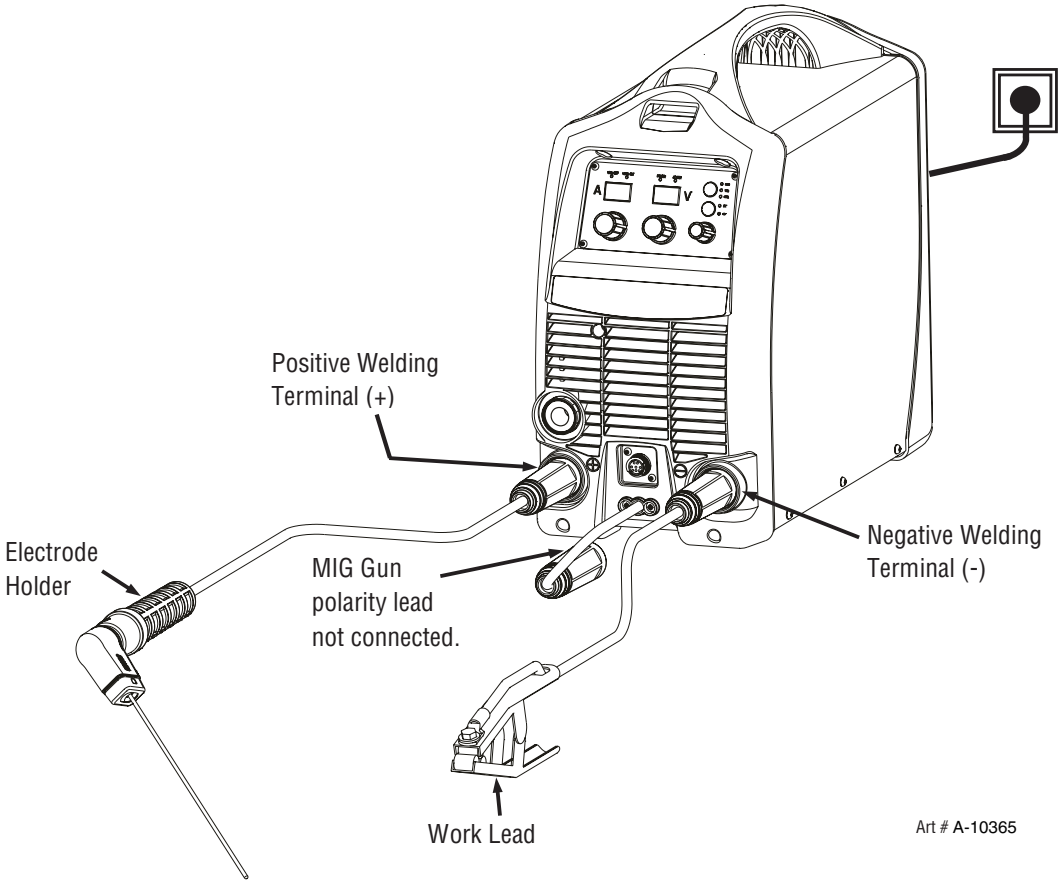


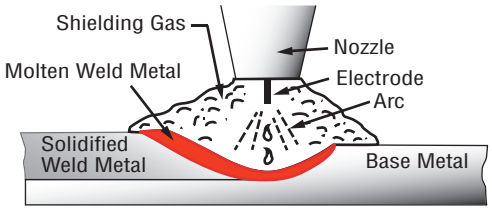
Figure 3-19: Setup for Manual Arc Welding.

SECTION 4:
BASIC WELDING GUIDE

4.01 MIG (GMAW/FCAW) Basic Welding Technique

Two different welding processes are covered in this section (GMAW and FCAW), with the intention of providing the very basic concepts in using the MIG mode of welding, where a welding MIG Gun is hand held, and the electrode (welding wire) is fed into a weld puddle, and the arc is shielded by an inert welding grade shielding gas or inert welding grade shielding gas mixture.

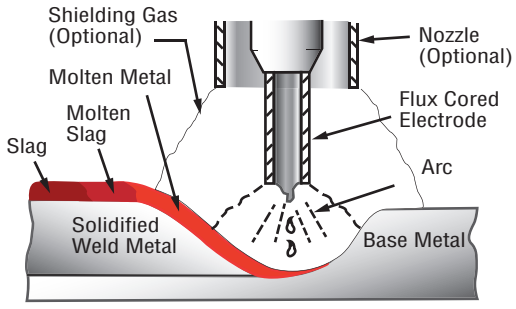
GAS METAL ARC WELDING (GMAW): This process, also known as MIG welding, CO_2 welding, Micro Wire Welding, short arc welding, dip transfer welding, wire welding etc., is an electric arc welding process which fuses together the parts to be welded by heating them with an arc between a solid continuous, consumable electrode and the work. Shielding is obtained from an externally supplied welding grade shielding gas or welding grade shielding gas mixture. The process is normally applied semi automatically; however the process may be operated automatically and can be machine operated. The process can be used to weld thin and fairly thick steels, and some non-ferrous metals in all positions.



GMAW Process Art # A-8991_AB

Figure 4-1

FLUX CORED ARC WELDING (FCAW): This is an electric arc welding process which fuses together the parts to be welded by heating them with an arc between a continuous flux filled electrode wire and the work. Shielding is obtained through decomposition of the flux within the tubular wire. Additional shielding may or may not be obtained from an externally supplied gas or gas mixture. The process is normally applied semi automatically; however the process may be applied automatically or by machine. It is commonly used to weld large diameter electrodes in the flat and horizontal position and small electrode diameters in all positions. The process is used to a lesser degree for welding stainless steel and for overlay work.



FCAW Process Art # A-08992_AB

Figure 4-2

Position of MIG Gun

The angle of MIG Gun to the weld has an effect on the width of the weld.

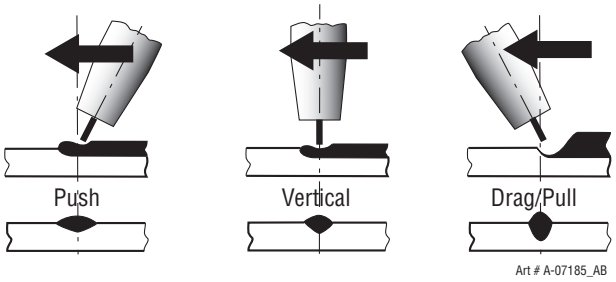


Figure 4-3

The welding Gun should be held at an angle to the weld joint. (see Secondary Adjustment Variables below)

Hold the MIG Gun so that the welding seam is viewed at all times. Always wear the welding helmet with proper filter lenses and use the proper safety equipment.

CAUTION

Do not pull the welding MIG Gun back when the arc is established. This will create excessive wire extension (stick-out) and make a very poor weld.

The electrode wire is not energized until the MIG Gun trigger switch is depressed. The wire may therefore be placed on the seam or joint prior to lowering the helmet.

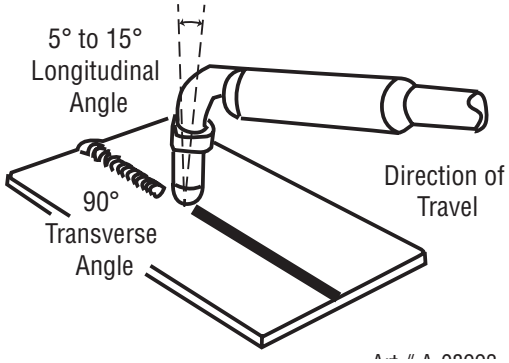


Figure 4-4

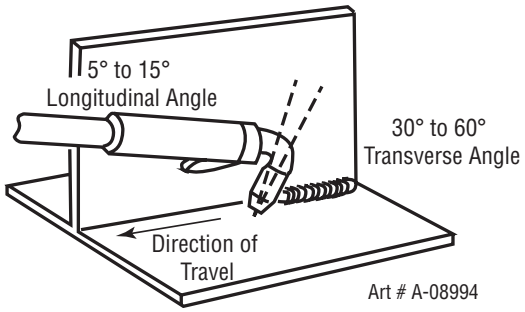
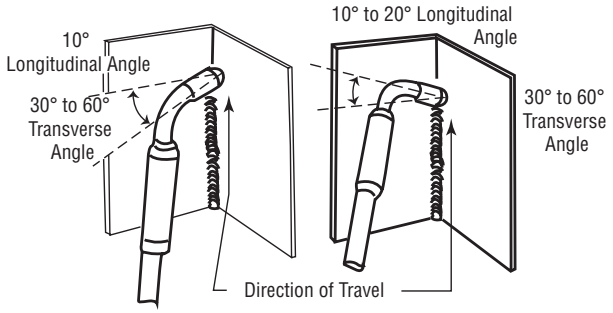


Figure 4-5



Vertical Fillet Welds Art # A-08995

Figure 4-6

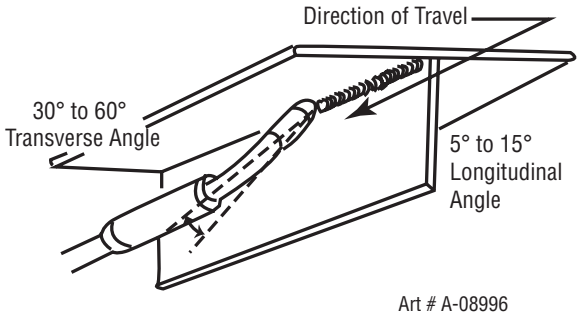


Figure 4-7

Distance from the MIG Gun Nozzle to the Work Piece

The electrode wire stick-out from the MIG Gun nozzle should be between 3/8" (10mm) to 3/4" (20.0mm). This distance may vary depending on the type of joint that is being welded.

Travel Speed

The speed at which the molten pool travels influences the width of the weld and penetration of the welding run.

MIG Welding Variables

Most of the welding done by all processes is on carbon steel. The items below describe the welding variables in short-arc welding of 24 ga. (0.6mm) to ¼" (6.4mm) mild sheet or plate. The applied techniques and end results in the MIG process are controlled by these variables.

Preselected Variables

Preselected variables depend upon the type of material being welded, the thickness of the material, the welding position, the deposition rate and the mechanical properties. These variables are:

- Type of electrode wire
- Size of electrode wire
- Type of gas (not applicable to self shielding wires FCAW)
- Gas flow rate (not applicable to self shielding wires FCAW)

Primary Adjustable Variables

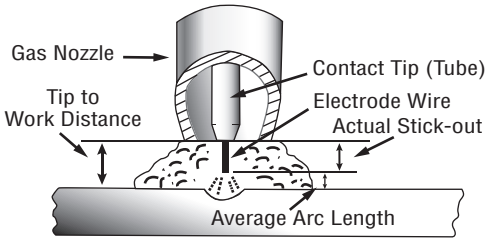
These control the process after preselected variables have been found. They control the penetration, bead width, bead height, arc stability, deposition rate and weld soundness. They are:

- Arc Voltage
- Welding current (wire feed speed)
- Travel speed

Secondary Adjustable Variables

These variables cause changes in primary adjustable variables which in turn cause the desired change in the bead formation. They are:

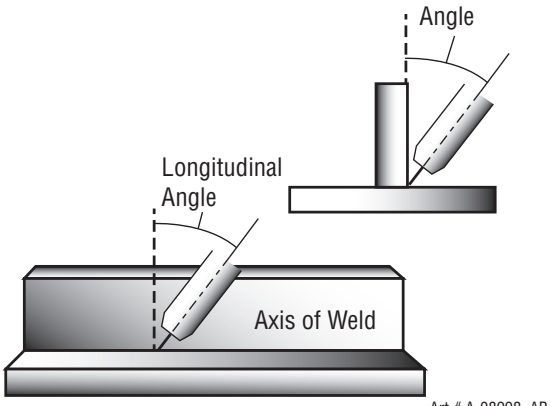
1. Stick-out (distance between the end of the contact tube (tip) and the end of the electrode wire). Maintain at about 3/8" (10mm) stick-out
2. Wire Feed Speed. Increase in wire feed speed increases weld current, Decrease in wire feed speed decreases weld current.



Electrode Stick-Out

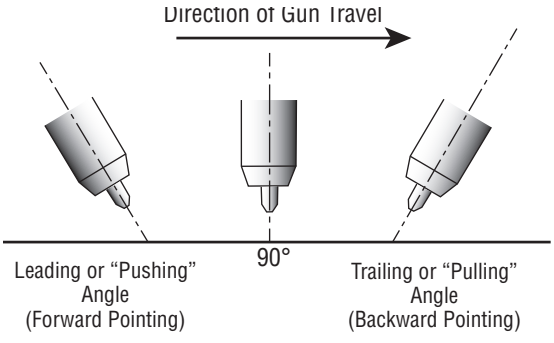
Figure 4-8

3. Nozzle Angle. This refers to the position of the welding MIG Gun in relation to the joint. The transverse angle is usually one half the included angle between plates forming the joint. The longitudinal angle is the angle between the centre line of the welding MIG Gun and a line perpendicular to the axis of the weld. The longitudinal angle is generally called the Nozzle Angle and can be either trailing (pulling) or leading (pushing). Whether the operator is left handed or right handed has to be considered to realize the effects of each angle in relation to the direction of travel.



Transverse and Longitudinal
Nozzle Axes

Figure 4-9



ozzle Angle, Right Handed Operator

Figure 4-10

Establishing the Arc and Making Weld Beads

Before attempting to weld on a finished piece of work, it is recommended that practice welds be made on a sample metal of the same material as that of the finished piece.

The easiest welding procedure for the beginner to experiment with MIG welding is the flat position. The equipment is capable of flat, vertical and overhead positions.

For practicing MIG welding, secure some pieces of 16 ga. (1.6mm) or 1/8" (3.2mm) mild steel plate 6” (150mm) x 6” (150mm). Use 0.035” (0.9mm) gas shielded steel or gasless flux cored wire.

Setting of the Power Source

Power source and Wirefeeder setting requires some practice by the operator, as the welding plant has two control settings that have to balance. These are the Wirespeed control (refer to section 3.06.3) and the welding Voltage Control (refer to section 3.06.9). The welding current is determined by the Wirespeed control, the current will increase with increased Wirespeed, resulting in a shorter arc. Less wire speed will reduce the current and lengthen the arc. Increasing the welding voltage hardly alters the current level, but lengthens the arc. By decreasing the voltage, a shorter arc is obtained with a little change in current level.

When changing to a different electrode wire diameter, different control settings are required. A thinner electrode wire needs more Wirespeed to achieve the same current level.

A satisfactory weld cannot be obtained if the Wirespeed and Voltage settings are not adjusted to suit the electrode wire diameter and the dimensions of the work piece.

If the Wirespeed is too high for the welding voltage, “stubbing” will occur as the wire dips into the molten pool and does not melt. Welding in these conditions normally produces a poor weld due to lack of fusion. If, however, the welding voltage is too high, large drops will form on the end of the wire, causing spatter. The correct setting of voltage and Wirespeed can be seen in the shape of the weld deposit and heard by a smooth regular arc sound. Refer to the Weld Guide located on the inside of the wirefeed compartment door for setup information.

Electrode Wire Size Selection

The choice of Electrode wire size and shielding gas used depends on the following

- Thickness of the metal to be welded
- Type of joint
- Capacity of the wire feed unit and Power Source
- The amount of penetration required
- The deposition rate required
- The bead profile desired
- The position of welding
- Cost of the wire

Thermal Arc MIG, Lift TIG, Stick Wire Selection Chart

Fabricator 181i MULTI PROCESS WELDING SYSTEM — THERMAL ARC

MIG Set-Up Guide

1 SELECT PROCESS	a MATERIAL SELECTION	b WELDING WIRE TYPE	c SHIELD GAS TO BE USED	d MATERIAL THICKNESS	24 ga. (0.6 mm)	22 ga. (0.8 mm)	18 ga. (1.2 mm)	16 ga. (1.6 mm)	1/8" (3.2 mm)	3/16" (4.7 mm)	1/4" (6.4 mm)
MIG	Mild Steel (Gas Shielded)	E70S-6 .023" (0.6 mm)	75% Ar, 25% CO_2	2 Wirespeed Display	150	260	300	320	430	650	650
				3 Voltage Display	11.4	14.3	17	18	21.5	25	25
				4 Inductance Knob	10	10	8	7	6	6	6
				5 Polarity Selection	DC Reverse Polarity (Positive)						
	Mild Steel (Gas Shielded)	E70S-6 .030" (0.8 mm)	75% Ar, 25% CO_2	2 Wirespeed Display	134	213	250	300	460	600	650
				3 Voltage Display	11.2	13	15.8	16.5	22	24.6	25
				4 Inductance Knob	10	10	10	10	8	6	4
				5 Polarity Selection	DC Reverse Polarity (Positive)						
	Mild Steel (Gas Shielded)	E70S-6 .035" (0.9 mm)	75% Ar, 25% CO_2	2 Wirespeed Display	-	-	150	170	230	325	325
				3 Voltage Display	-	-	16.9	18	20.3	25	25
				4 Inductance Knob	-	-	8	8	7	5	5
				5 Polarity Selection	DC Reverse Polarity (Positive)						
	Mild Steel (Gas Shielded)	E70S-6 .035" (0.9 mm)	100% CO_2	2 Wirespeed Display	-	-	150	170	230	310	310
				3 Voltage Display	-	-	17	18	20.5	25	25
				4 Inductance Knob	-	-	10	10	10	9	10
				5 Polarity Selection	DC Reverse Polarity (Positive)						
	Mild Steel (Gasless)	E71T-11 .035" (0.9 mm)	Not Required	2 Wirespeed Display	-	-	-	160	430	650	650
				3 Voltage Display	-	-	-	15	20.8	25	25
				4 Inductance Knob	-	-	-	10	10	5	5
				5 Polarity Selection	DC Straight Polarity (Negative)						
	Aluminum (Gas Shielded) Use Spool Gun	AL4043 AL5356 .035" (0.9 mm)	100% Argon	2 Wirespeed Display	-	-	270	270	430	630	650
				3 Voltage Display	-	-	13	14	20	24.5	24.9
				4 Inductance Knob	-	-	8	8	8	8	1
				5 Polarity Selection	DC Reverse Polarity (Positive) Use Spool Gun						

LIFT TIG Set-Up Guide

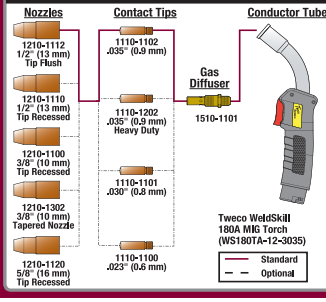
NOTE: Shield gas pure Argon. Polarity setting should be set to DC Straight Polarity (NEGATIVE) for all materials.
MS = Mild Steel SS= Stainless Steel

1 SELECT PROCESS	a MATERIAL SELECTION	b TUNGSTEN DIAMETER	c FILLER ROD (If Required)	d BASE METAL THICKNESS		24 ga. (0.6 mm)	22 ga. (0.8 mm)	18 ga. (1.2 mm)	16 ga. (1.6 mm)	1/8" (3.2 mm)	3/16" (4.7 mm)	1/4" (6.4 mm)
LIFT TIG	Mild Steel & Stainless Steel	.040" (1.0 mm)	1/16" (1.6 mm)	2 Amperage Display	(MS)	-	35-50	45-60	-	-	-	-
					(SS)	-	20-35	30-55	-	-	-	-
		1/16" (1.6 mm)	1/16" (1.6 mm)	2 Amperage Display	(MS)	-	-	-	60-90	80-115	-	-
					(SS)	-	-	-	40-70	65-110	-	-
		3/32" (2.4 mm)	3/32" (2.4 mm)	2 Amperage Display	(MS)	-	-	-	-	-	115-165	-
					(SS)	-	-	-	-	-	100-150	-
		1/8" (3.2 mm)	5/32" (4.0 mm)	2 Amperage Display	(MS)	-	-	-	-	-	-	160-200
					(SS)	-	-	-	-	-	-	135-180

STICK Set-Up Guide

1 SELECT PROCESS	a MATERIAL SELECTION	b ELECTRODE SELECTION	c ELECTRODE DIAMETER		3/32" (2.4 mm)	1/8" (3.2 mm)	5/32" (4.0 mm)
STICK	Mild Steel	6013		2 Amperage Display (Range)	70-95	100-135	145-175
				3 Arc Force Knob	3	4	5
				4 Polarity Selection	DC Reverse Polarity (Electrode Positive)		
		7018		2 Amperage Display (Range)	70-110	90-160	130-175
				3 Arc Force Knob	2	3	4
				4 Polarity Selection	DC Reverse Polarity (Electrode Positive)		
	Stainless Steel	316		2 Amperage Display (Range)	40-80	60-110	90-150
				3 Arc Force Knob	2	4	6
				4 Polarity Selection	DC Reverse Polarity (Electrode Positive)		

Consumable Parts - Tweco WeldSkill 180A



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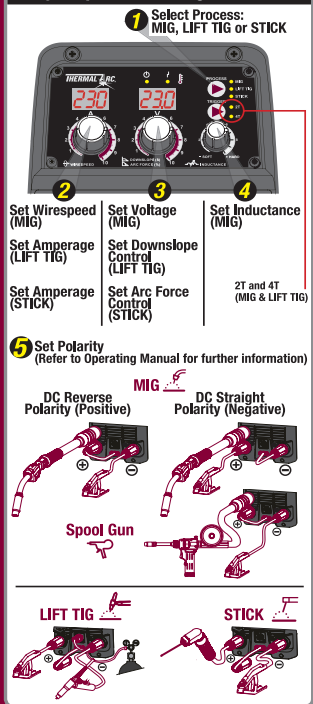
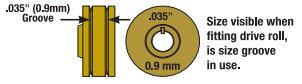
Easy Steps For Welding



Drive Rolls



Part No.	Drive Roll Description
W6000700	.023" - .035" Hard Wire (0.6 mm - 0.9 mm)
7977036	.023"-.030" Hard Wire (0.6 mm - 0.8 mm)
7977732	.030"/.035" Cored Wire (0.8 mm/0.9 mm)

Art # A-10366_AB

Table 4-1: MIG, Lift TIG, Stick Welding Set up Chart

4.02 MIG (GMAW/FCAW) Welding Troubleshooting

Solving Problems Beyond the Welding Terminals

The general approach to fix Gas Metal Arc Welding (GMAW) problems is to start at the wire spool then work through to the MIG Gun. There are two main areas where problems occur with MIG, Porosity and Inconsistent wire feed

Solving Problems Beyond the Welding Terminals - Porosity

When there is a gas problem the result is usually porosity within the weld metal. Porosity always stems from some contaminant within the molten weld pool which is in the process of escaping during solidification of the molten metal. Contaminants range from no gas around the welding arc to dirt on the work piece surface. Porosity can be reduced by checking the following points.

	FAULT	CAUSE
1	Limited or no shielding gas flows out of the MIG Gun nozzle.	Check that the MIG Gun connection is fully engaged into the MIG Gun Adapter. The o-rings in the MIG Gun connection must seal the shielding gas within the MIG Gun Adapter so the shielding gas flows into the MIG Gun and out thru the MIG Gun nozzle.
2	Shielding gas cylinder contents and flow gauge.	Ensure that the shielding gas cylinder is not empty and the flow meter is correctly adjusted to workshop welding: 28-35 CFH or outdoors welding: 35-46 CFH.
3	Gas leaks.	Check for gas leaks between the regulator/cylinder connection and in the gas hose to the Power Source.
4	Internal gas hose in the Power Source.	Ensure the hose from the solenoid valve to the MIG Gun adaptor has not fractured and that it is connected to the MIG Gun adaptor.
5	Welding in a windy environment.	Shield the weld area from the wind or increase the gas flow.
6	Welding dirty, oily, painted, oxidized or greasy plate.	Clean contaminates off the work piece.
7	Distance between the MIG Gun nozzle and the work piece.	Keep the distance between the MIG Gun nozzle and the work piece to a minimum. Refer to section 2.03
8	Maintain the MIG Gun in good working order.	A Ensure that the gas holes are not blocked and gas is exiting out of the MIG Gun nozzle. B Do not restrict gas flow by allowing spatter to build up inside the MIG Gun nozzle. C Check that the MIG Gun O-rings are not damaged.

Table 4-2: Solving Problems beyond the Welding Terminals-Porosity

WARNING

Disengage the feed roll when testing for gas flow by ear.

Solving Problems Beyond the Welding Terminals - Inconsistent Wire Feed

Wire feeding problems can be reduced by checking the following points.

FAULT	CAUSE
1 Feed roller driven by motor in the cabinet slipped.	Wire spool brake is too tight.
2 Wire spool unwinds and tangles..	Wire spool brake is too loose.
3 Worn or incorrect feed roller size	A Use a feed roller matched to the size you are welding. B Replace feed roller if worn.
4 Wire rubbed against the mis-aligned guides and reduced wire feedability.	Mis-alignment of inlet/outlet guides
5 Liner blocked with swarf	A Increased amounts of swarf are produced by the wire passing through the feed roller when excessive pressure is applied to the pressure roller adjuster. B Swarf can also be produced by the wire passing through an incorrect feed roller groove shape or size. C Swarf is fed into the conduit liner where it accumulates thus reducing wire feedability.
6 Incorrect or worn contact tip	A The contact tip transfers the weld current to the electrode wire. If the hole in the contact tip is too large then arcing may occur inside the contact tip resulting in the wire jamming in the contact tip B When using soft wire such as aluminum it may become jammed in the contact tip due to expansion of the wire when heated. A contact tip designed for soft wires should be used.
7 Poor work lead contact to work piece	If the work lead has a poor electrical contact to the work piece then the connection point will heat up and result in a reduction of power at the arc.
8 Bent liner	This will cause friction between the wire and the liner thus reducing wire feedability

Table 4-3: Wire Feeding Problems

Basic MIG Welding Troubleshooting

FAULT	CAUSE	REMEDY
1 Undercut	A Welding arc voltage too high.	A Decrease voltage or increase the wire feed speed.
	B Incorrect MIG Gun angle	B Adjust angle.
	C Excessive heat input	C Increase the MIG Gun travel speed and/or decrease welding current by decreasing the voltage or decreasing the wire feed speed.

2 Lack of penetration	A Welding current too low	A Increase welding current by increasing wire feed speed and increasing voltage.
	B Joint preparation too narrow or gap too tight	B Increase joint angle or gap.
	C Shielding gas incorrect	C Change to a gas which gives higher penetration.
3 Lack of fusion	Voltage too low	Increase voltage.
4 Excessive spatter	A Voltage too high	A Decrease voltage or increase the wirespeed control.
	B Voltage too low	B Increase the voltage or decrease wirespeed.
5 Irregular weld shape	A Incorrect voltage and current settings. Convex, voltage too low. Concave, voltage too high.	A Adjust voltage and current by adjusting the voltage control and the wirespeed control.
	B Wire is wandering.	B Replace contact tip.
	C Incorrect shielding gas	C Check shielding gas.
	D Insufficient or excessive heat input	D Adjust the wirespeed control or the voltage control.
6 Weld cracking	A Weld beads too small	A Decrease travel speed
	B Weld penetration narrow and deep	B Reduce current and voltage and increase MIG Gun travel speed or select a lower penetration shielding gas.
	C Excessive weld stresses	C Increase weld metal strength or revise design
	D Excessive voltage	D Decrease voltage.
	E Cooling rate too fast	E Slow the cooling rate by preheating part to be welded or cool slowly.
7 Cold weld puddle	A Loose welding cable connection.	A Check all welding cable connections.
	B Low primary voltage	B Contact supply authority.
	C Fault in power source	C Have an Accredited Thermal Arc Service Provider to test then replace the faulty component.
8 Arc does not have a crisp sound that short arc exhibits when the wirefeed speed and voltage are adjusted correctly.	The MIG Gun has been connected to the wrong voltage polarity on the front panel.	Connect the MIG Gun to the positive (+) welding terminal for solid wires and gas shielded flux cored wires. Refer to the electrode wire manufacturer for the correct polarity.
9 Poor weld result from setup chart parameters	Contact tip has arc marks in the bore causing excessive drag on the wire	Replace the contact tip with only a Genuine Tweco contact tip.

Table 4-4: MIG Welding Problems

4.03 Stick (SMAW) Basic Welding Technique

Size of Electrode

The electrode size is determined by the thickness of metals being joined and can also be governed by the type of welding machine available. Small welding machines will only provide sufficient current (amperage) to run the smaller size electrodes.

For thin sections, it is necessary to use smaller electrodes otherwise the arc may burn holes through the job. A little practice will soon establish the most suitable electrode for a given application.

Storage of Electrodes

Always store electrodes in a dry place and in their original containers.

Electrode Polarity

Electrodes are generally connected to the ELECTRODE HOLDER with the Electrode Holder connected positive polarity. The WORK LEAD is connected negative polarity and is connected to the work piece. If in doubt consult the electrode data sheet or your nearest Accredited Thermal Arc Distributor.

4.04 Effects of Stick Welding Various Materials

High Tensile and Alloy Steels

The two most prominent effects of welding these steels are the formation of a hardened zone in the weld area, and, if suitable precautions are not taken, the occurrence in this zone of under-bead cracks. Hardened zone and under-bead cracks in the weld area may be reduced by using the correct electrodes, preheating, using higher current settings, using larger electrodes sizes, short runs for larger electrode deposits or tempering in a furnace.

Manganese Steels

The effect on manganese steel of slow cooling from high temperatures is to embrittle it. For this reason it is absolutely essential to keep manganese steel cool during welding by quenching after each weld or skip welding to distribute the heat.

Cast Iron

Most types of cast iron, except white iron, are weldable. White iron, because of its extreme brittleness, generally cracks when attempts are made to weld it. Trouble may also be experienced when welding white-heart malleable, due to the porosity caused by gas held in this type of iron.

Copper and Alloys

The most important factor is the high rate of heat conductivity of copper, making pre-heating of heavy sections necessary to give proper fusion of weld and base metal.

Types of Electrodes

Arc Welding electrodes are classified into a number of groups depending on their applications. There are a great number of electrodes used for specialized industrial purposes which are not of particular interest for everyday general work. These include some low hydrogen types for high tensile steel, cellulose types for welding large diameter pipes, etc The range of electrodes dealt with in this publication will cover the vast majority of applications likely to be encountered; are all easy to use.

Arc Welding Practice

The techniques used for arc welding are almost identical regardless of what types of metals are being joined. Naturally enough, different types of electrodes would be used for different metals as described in the preceding section.

Welding Position

The electrodes dealt with in this publication can be used in most positions, i.e. they are suitable for welding in flat, horizontal, vertical and overhead positions. Numerous applications call for welds to be made in positions intermediate between these. Some of the common types of welds are shown in Figures 4-15 through 4-22.

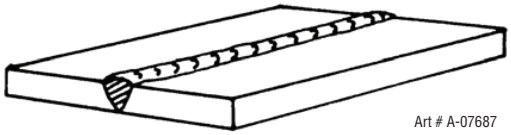


Figure 4-11: Flat Position, Down Hand Butt Weld

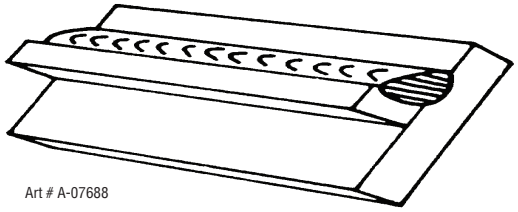


Figure 4-12: Flat Position, Gravity Fillet Weld

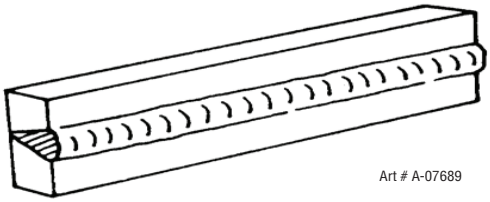


Figure 4-13: Horizontal Position, Butt Weld

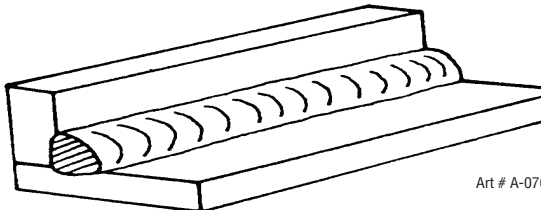


Figure 4-14: Horizontal-Vertical (HV) Position

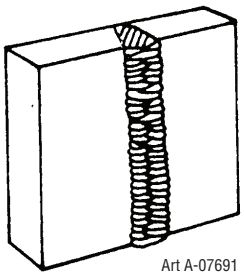


Figure 4-15: Vertical Position, Butt Weld

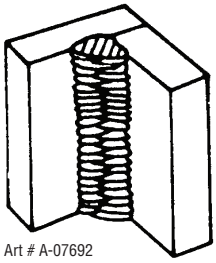


Figure 4-16: Vertical Position, Fillet Weld

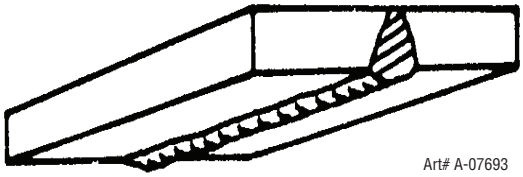


Figure 4-17: Overhead Position, Butt Weld

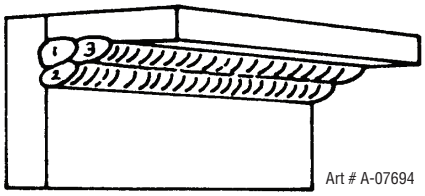


Figure 4-18: Overhead Position, Fillet Weld

Joint Preparations

In many cases, it will be possible to weld steel sections without any special preparation. For heavier sections and for repair work on castings, etc., it will be necessary to cut or grind an angle between the pieces being joined to ensure proper penetration of the weld metal and to produce sound joints.

In general, surfaces being welded should be clean and free of rust, scale, dirt, grease, etc. Slag should be removed from oxy-cut surfaces. Typical joint designs are shown in Figure 4-19.

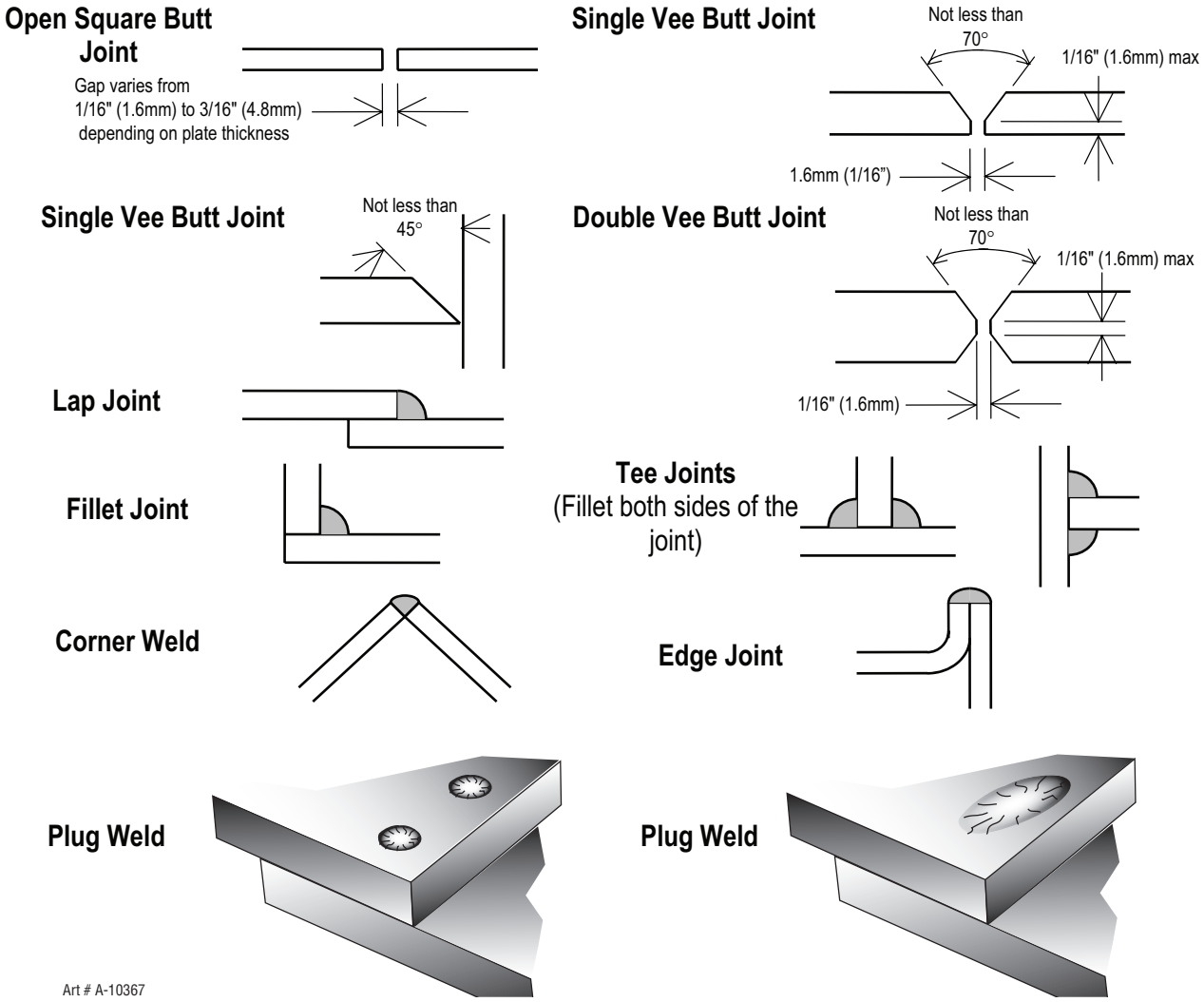


Figure 4-19: Typical Joint Designs for Arc Welding

Arc Welding Technique - A Word to Beginners

For those who have not yet done any welding, the simplest way to commence is to run beads on a piece of scrap plate. Use mild steel plate about 1/4" (6.4mm) thick and a 1/8"(3.2mm) electrode. Clean any paint, loose scale or grease off the plate and set it firmly on the work bench so that welding can be carried out in the downhand position. Make sure that the work clamp is making good electrical contact with the work, either directly or through the work table. For light gauge material, always clamp the work lead directly to the job, otherwise a poor circuit will probably result.

The Welder

Place yourself in a comfortable position before beginning to weld. Get a seat of suitable height and do as much work as possible sitting down. Don't hold your body tense. A taut attitude of mind and a tensed body will soon make you feel tired. Relax and you will find that the job becomes much easier. You can add much to your peace of mind by wearing a leather apron and gauntlets. You won't be worrying then about being burnt or sparks setting alight to your clothes.

Place the work so that the direction of welding is across, rather than to or from, your body. The electrode holder lead should be clear of any obstruction so that you can move your arm freely along as the electrode burns down. If the lead is slung over your shoulder, it allows greater freedom of movement and takes a lot of weight off your hand. Be sure the insulation on your cable and electrode holder is not faulty, otherwise you are risking an electric shock.

Striking the Arc

Practice this on a piece of scrap plate before going on to more exacting work. You may at first experience difficulty due to the tip of the electrode "sticking" to the work piece. This is caused by making too heavy a contact with the work and failing to withdraw the electrode quickly enough. A low amperage will accentuate it. This freezing-on of the tip may be overcome by scratching the electrode along the plate surface in the same way as a match is struck. As soon as the arc is established, maintain a 1/16"(1.6mm) to 1/8"(3.2mm) gap between the burning electrode end and the parent metal. Draw the electrode slowly along as it melts down.

Another difficulty you may meet is the tendency, after the arc is struck, to withdraw the electrode so far that the arc is broken again. A little practice will soon remedy both of these faults.

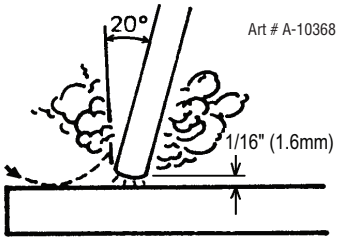


Figure 4-20: Striking an Arc

Arc Length

The securing of an arc length necessary to produce a neat weld soon becomes almost automatic. You will find that a long arc produces more heat. A very long arc produces a crackling or spluttering noise and the weld metal comes across in large, irregular blobs. The weld bead is flattened and spatter increases. A short arc is essential if a high quality weld is to be obtained although if it is too short there is the danger of it being blanketed by slag and the electrode tip being solidified in. If this should happen, give the electrode a quick twist back over the weld to detach it. Contact or "touch-weld" electrodes such as E7014 Stick electrodes do not stick in this way, and make welding much easier.

Rate of Travel

After the arc is struck, your next concern is to maintain it, and this requires moving the electrode tip towards the molten pool at the same rate as it is melting away. At the same time, the electrode has to move along the plate to form a bead. The electrode is directed at the weld pool at about 20^{o} from the vertical. The rate of travel has to be adjusted so that a well-formed bead is produced.

If the travel is too fast, the bead will be narrow and strung out and may even be broken up into individual globules. If the travel is too slow, the weld metal piles up and the bead will be too large.

Making Welded Joints

Having attained some skill in the handling of an electrode, you will be ready to go on to make up welded joints.

A. Butt Welds

Set up two plates with their edges parallel, as shown in Figure 4-21, allowing 1/16"(1.6mm) to 3/32"(2.4mm) gap between them and tack weld at both ends. This is to prevent contraction stresses from the cooling weld metal pulling the plates out of alignment. Plates thicker than 1/4" (6.4mm) should have their mating edges beveled to form a 70º to 90º included angle. This allows full penetration of the weld metal to the root. Using a 1/8"(3.2mm) E7014 Stick electrode at 100 amps, deposit a run of weld metal on the bottom of the joint.

Do not weave the electrode, but maintain a steady rate of travel along the joint sufficient to produce a well-formed bead. At first you may notice a tendency for undercut to form, but keeping the arc length short, the angle of the electrode at about 20º from vertical, and the rate of travel not too fast, will help eliminate this. The electrode needs to be moved along fast enough to prevent the slag pool from getting ahead of the arc. To complete the joint in thin plate, turn the job over, clean the slag out of the back and deposit a similar weld.

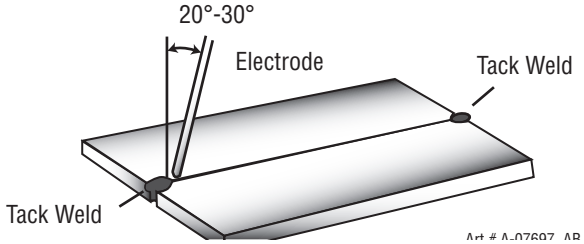


Figure 4-21: Butt Weld

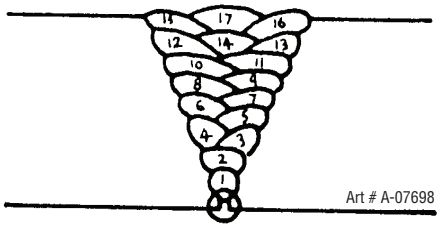


Figure 4-22: Weld Build up Sequence

Heavy plate will require several runs to complete the joint. After completing the first run, chip the slag out and clean the weld with a wire brush. It is important to do this to prevent slag being trapped by the second run. Subsequent runs are then deposited using either a weave technique or single beads laid down in the sequence shown in Figure 4-22. The width of weave should not be more than three times the core wire diameter of the electrode. When the joint is completely filled, the back is either machined, ground or gouged out to remove slag which may be trapped in the root, and to prepare a suitable joint for depositing the backing run. If a backing bar is used, it is not usually necessary to remove this, since it serves a similar purpose to the backing run in securing proper fusion at the root of the weld.

B. Fillet Welds

These are welds of approximately triangular cross-section made by depositing metal in the corner of two faces meeting at right angles. Refer to Figure 4-14.

A piece of angle iron is a suitable specimen with which to begin, or two lengths of strip steel may be tacked together at right angles. Using a 1/8"(3.2mm) E7014 Stick electrode at 100 amps, position angle iron with one leg horizontal and the other vertical. This is known as a horizontal-vertical (HV) fillet. Strike the arc and immediately bring the electrode to a position perpendicular to the line of the fillet and about 45º from the vertical. Some electrodes require to be sloped about 20º away from the perpendicular position to prevent slag from running ahead of the weld. Refer to Figure 4-23. Do not attempt to build up much larger than 1/4"(6.4mm)width with a 1/8"(3.2mm) electrode, otherwise the weld metal tends to sag towards the base, and undercut forms on the vertical leg. Multi-runs can be made as shown in Figure 4-24. Weaving in HV fillet welds is undesirable.

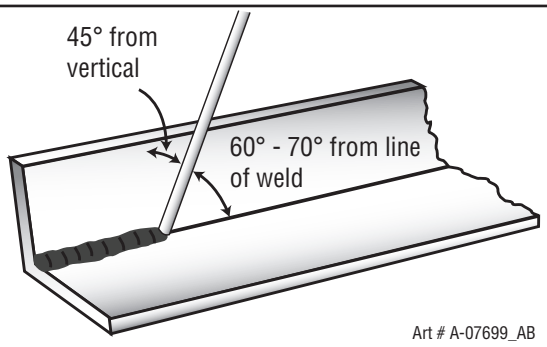


Figure 4-23: Electrode Position for HV Fillet Weld

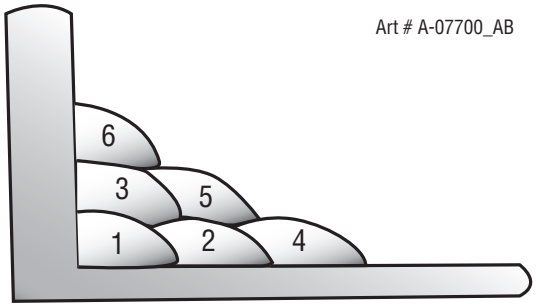


Figure 4-24: Multi-runs in HV Fillet Weld

C. Vertical Welds

1. Vertical Up

Tack weld a three feet length of angle iron to your work bench in an upright position. Use a 1/8"(3.2mm) E7014 Stick electrode and set the current at 100 amps. Make yourself comfortable on a seat in front of the job and strike the arc in the corner of the fillet. The electrode needs to be about 10º from the horizontal to enable a good bead to be deposited. Refer Figure 4-25. Use a short arc, and do not attempt to weave on the first run. When the first run has been completed de-slag the weld deposit and begin the second run at the bottom. This time a slight weaving motion is necessary to cover the first run and obtain good fusion at the edges. At the completion of each side motion, pause for a moment to allow weld metal to build up at the edges, otherwise undercut will form and too much metal will accumulate in the centre of the weld. Figure 4-26 illustrates multi-run technique and Figure 4-27 shows the effects of pausing at the edge of weave and of weaving too rapidly.

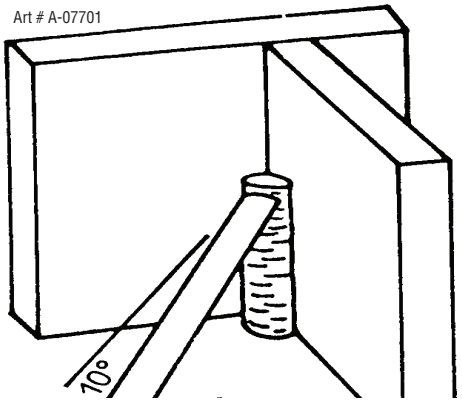


Figure 4-25: Single Run Vertical Fillet Weld

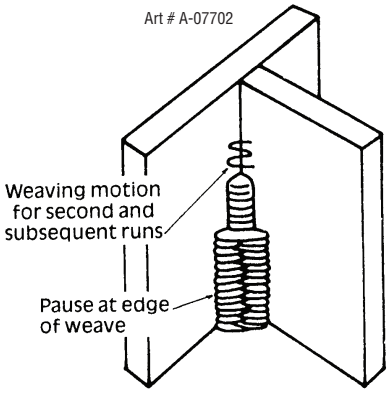


Figure 4-26: Multi Run Vertical Fillet Weld

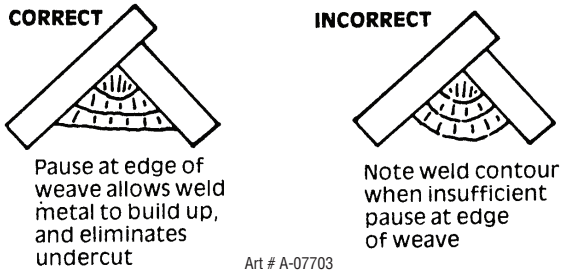


Figure 4-27: Examples of Vertical Fillet Welds

2. Vertical Down

The E7014 Stick electrode makes welding in this position particularly easy. Use a 1/8"(3.2mm) electrode at 100 amps. The tip of the electrode is held in light contact with the work and the speed of downward travel is regulated so that the tip of the electrode just keeps ahead of the slag. The electrode should point upwards at an angle of about 45º.

3. Overhead Welds

Apart from the rather awkward position necessary, overhead welding is not much more difficult that downhand welding. Set up a specimen for overhead welding by first tacking a length of angle iron at right angles to another piece of angle iron or a length of waste pipe. Then tack this to the work bench or hold in a vice so that the specimen is positioned in the overhead position as shown in the sketch. The electrode is held at 45º to the horizontal and tilted 10º in the line of travel (Figure 4-28). The tip of the electrode may be touched lightly on the metal, which helps to give a steady run. A weave technique is not advisable for overhead fillet welds. Use a 1/8"(3.2mm) E6013 Stick electrode at 100 amps, and deposit the first run by simply drawing the electrode along at a steady rate. You will notice that the weld deposit is rather convex, due to the effect of gravity before the metal freezes.

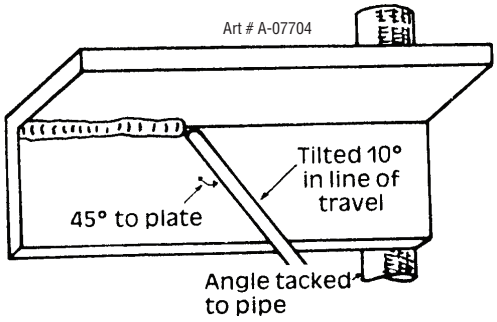


Figure 4-28: Overhead Fillet Weld

Distortion

Distortion in some degree is present in all forms of welding. In many cases it is so small that it is barely perceptible, but in other cases allowance has to be made before welding commences for the distortion that will subsequently occur. The study of distortion is so complex that only a brief outline can be attempted hear.

The Cause of Distortion

Distortion is caused by:

A. Contraction of Weld Metal:

Molten steel shrinks approximately 11 per cent in volume on cooling to room temperature. This means that a cube of molten metal would contract approximately 2.2 per cent in each of its three dimensions. In a welded joint, the metal becomes attached to the side of the joint and cannot contract freely. Therefore, cooling causes the weld metal to flow plastically, that is, the weld itself has to stretch if it is to overcome the effect of shrinking volume and still be attached to the edge of the joint. If the restraint is very great, as, for example, in a heavy section of plate, the weld metal may crack. Even in cases where the weld metal does not crack, there will still remain stresses "Locked-up" in the structure. If the joint material is relatively weak, for example, a butt joint in 5/64" (2.0mm) sheet, the contracting weld metal may cause the sheet to become distorted.

B. Expansion and Contraction of Parent Metal in the Fusion Zone:

While welding is proceeding, a relatively small volume of the adjacent plate material is heated to a very high temperature and attempts to expand in all directions. It is able to do this freely at right angles to the surface of the plate (i.e., "through the weld", but when it attempts to expand "across the weld" or "along the weld", it meets considerable resistance, and to fulfill the desire for continued expansion, it has to deform plastically, that is, the metal adjacent to the weld is at a high temperature and hence rather soft, and, by expanding, pushes against the cooler, harder metal further away, and tends to bulge (or is "upset". When the weld area begins to cool, the "upset" metal attempts to contract as much as it expanded, but, because it has been "upset" it does not resume its former shape, and the contraction of the new shape exerts a strong pull on adjacent metal. Several things can then happen.

The metal in the weld area is stretched (plastic deformation), the job may be pulled out of shape by the powerful contraction stresses (distortion), or the weld may crack, in any case, there will remain "locked-up" stresses in the job. Figures 4-29 and 4- 30 illustrate how distortion is created.

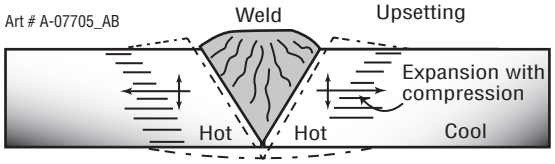


Figure 4-29: Parent Metal Expansion

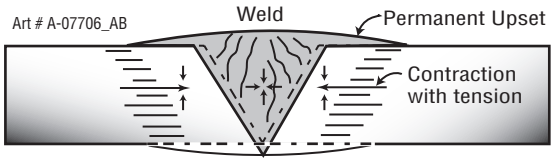


Figure 4-30: Parent Metal Contraction

Overcoming Distortion Effects

There are several methods of minimizing distortion effects.

A. Peening

This is done by hammering the weld while it is still hot. The weld metal is flattened slightly and because of this the tensile stresses are reduced a little. The effect of peening is relatively shallow, and is not advisable on the last layer.

B. Distribution of Stresses

Distortion may be reduced by selecting a welding sequence which will distribute the stresses suitably so that they tend to cancel each other out. See Figures 4-30 through 4-33 for various weld sequences. Choice of a suitable weld sequence is probably the most effective method of overcoming distortion, although an unsuitable sequence may exaggerate it. Simultaneous welding of both sides of a joint by two welders is often successful in eliminating distortion.

C. Restraint of Parts

Forcible restraint of the components being welded is often used to prevent distortion. Jigs, positions, and tack welds are methods employed with this in view.

D. Presetting

It is possible in some cases to tell from past experience or to find by trial and error (or less frequently, to calculate) how much distortion will take place in a given welded structure. By correct pre-setting of the components to be welded, constructional stresses can be made to pull the parts into correct alignment. A simple example is shown in Figure 4-31.

E. Preheating

Suitable preheating of parts of the structure other than the area to be welded can be sometimes used to reduce distortion. Figure 4-32 shows a simple application. By removing the heating source from b and c as soon as welding is completed, the sections b and c will contract at a similar rate, thus reducing distortion.

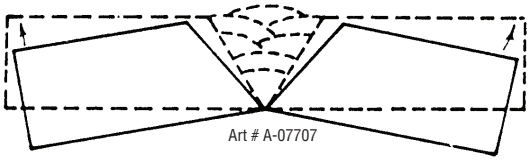
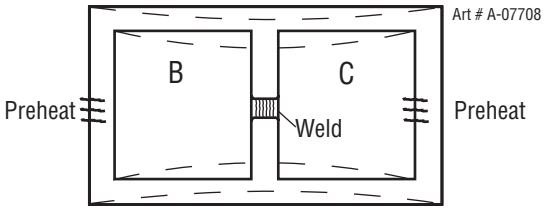


Figure 4-31: Principle of Presetting



Dotted lines show effect if no preheat is used

Figure 4-32: Reduction of Distortion by Preheating

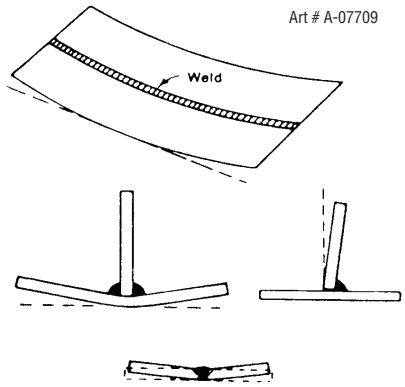
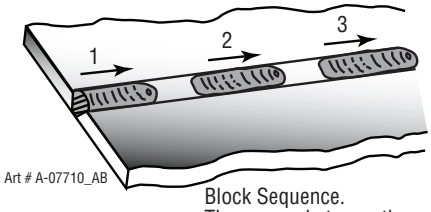


Figure 4-33: Examples of Distortion



Block Sequence.
The spaces between the welds are filled in when the welds are cool.

Figure 4-34: Welding Sequence

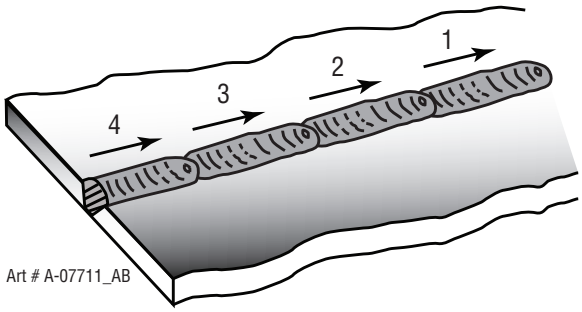


Figure 4-35: Step back Sequence

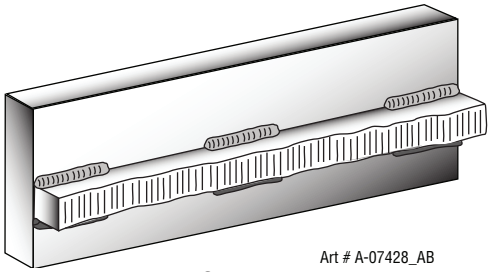


Figure 4-36: Chain Intermittent Welding

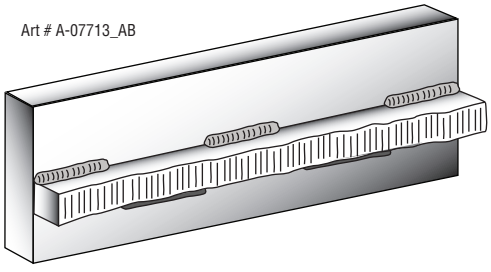
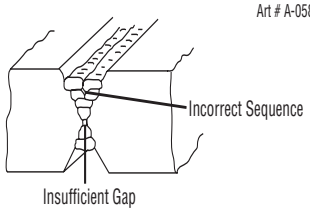


Figure 4-37: Staggered Intermittent Welding

4.05 Stick (SMAW) Welding Troubleshooting

FAULT	CAUSE	REMEDY
1 Welding current varying	ARC FORCE control knob is set at a value that causes the welding current to vary excessively with the arc length.	Reduce the ARC FORCE control knob until welding current is reasonably constant while prohibiting the electrode from sticking to the work piece when you "dig" the electrode into the workpiece.
2 A gap is left by failure of the weld metal to fill the root of the weld.	A Welding current too low	A Increase welding current.
	B Electrode too large for joint.	B Use smaller diameter electrode.
	C Insufficient gap.	C Allow wider gap.
3 Non-metallic particles are trapped in the weld metal.	A Non-metallic particles may be trapped in undercut from previous run.	A If a bad undercut is present clean slag bout and cover with a run from a smaller gauge electrode.
	B Joint preparation too restricted.	B Allow for adequate penetration and room for cleaning out the slag.
	C Irregular deposits allow slag to be trapped.	C If very bad, chip or grind out irregularities.
	D Lack of penetration with slag trapped beneath weld bead.	D Use smaller electrode with sufficient current to give adequate penetration. Use suitable tools to remove all slag from comers.
	E Rust or mill scale is preventing full fusion.	E Clean joint before welding.
	F Wrong electrode for position in which welding is done.	F Use electrodes designed for position in which welding is done, otherwise proper control of slag is difficult.
	Figure 1-Example of insufficient gap or incorrect sequence	
4 A groove has been formed in the base metal adjacent to the toe of a weld and has not been filled by the weld metal (undercut).	A Welding current is too high.	A Reduce welding current.
	B Welding arc is too long.	B Reduce the length of the welding arc.
	C Angle of the electrode is incorrect.	C Electrode should not be inclined less than 45° to the vertical face.
	D Joint preparation does not allow correct electrode angle.	D Allow more room in joint for manipulation of the electrode.
	E Electrode too large for joint.	E Use smaller gauge electrode.
	F Insufficient deposit time at edge of weave.	F Pause for a moment at edge of weave to allow weld metal buildup.
	G Power Source is set for MIG (GMAW) welding.	G Set Power Source to STICK (SMAW) mode.

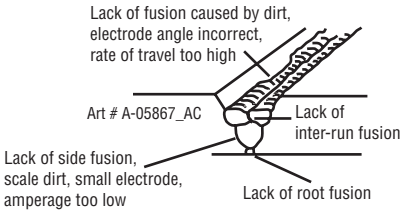
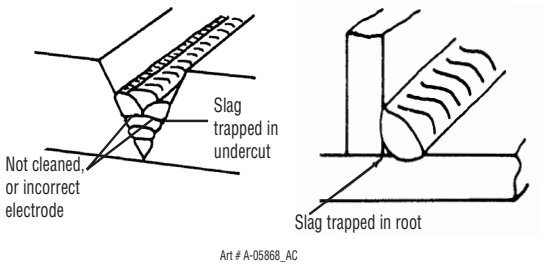
5 Portions of the weld run do not fuse to the surface of the metal or edge of the joint.	A Small electrodes used on heavy cold plate.	A Use larger electrodes and preheat the plate.
	B Welding current is too low.	B Increase welding current.
	C Wrong electrode angle.	C Adjust angle so the welding arc is directed more into the base metal.
	D Travel speed of electrode is too high.	D Reduce travel speed of electrode.
	E Scale or dirt on joint surface.	E Clean surface before welding.
 Figure 2: Example of Lack of Fusion		
6 Gas pockets or voids in weld metal (porosity)	A High levels of sulfur in steel.	A Use an electrode that is designed for high sulfur steels.
	B Electrodes are damp.	B Dry electrodes before use.
	C Welding current is too high.	C Reduce welding current.
	D Surface impurities such as oil, grease, paint, etc.	D Clean joint before welding.
	E Welding in a windy environment.	E Shield the weld area from the wind.
	F Electrode damaged ie flux coating incomplete.	F Discard damaged electrodes and only use electrodes with a complete flux coating.
7 Crack occurring in weld metal soon after solidification commences	A Rigidity of joint.	A Redesign to relieve weld joint of severe stresses or use crack resistance electrodes.
	B Insufficient throat thickness.	B Travel slightly slower to allow greater build up in throat.
	C Weld current is too high.	C Decrease welding current.
 Figure 3: Example of Slag Inclusion		
8 The Stick electrode is difficult to run with multiple arc-outs when welding	The Stick electrode being used is not suitable for use with this machine.	Use E6013 or E7018 Stick electrodes for steel or 300 series stainless steel Stick electrodes for 300 series stainless steel.

Table 4-6: Welding Problems - Stick (SMAW)

4.06 TIG (GTAW) Basic Welding Technique

Gas Tungsten Arc Welding (GTAW) or TIG (Tungsten Inert Gas) as it is commonly referred to, is a welding process in which fusion is produced by an electric arc that is established between a single tungsten (non-consumable) electrode and the work piece. Shielding is obtained from a welding grade shielding gas or welding grade shielding gas mixture which is generally Argon based. A filler metal may also be added manually in some circumstances depending on the welding application.

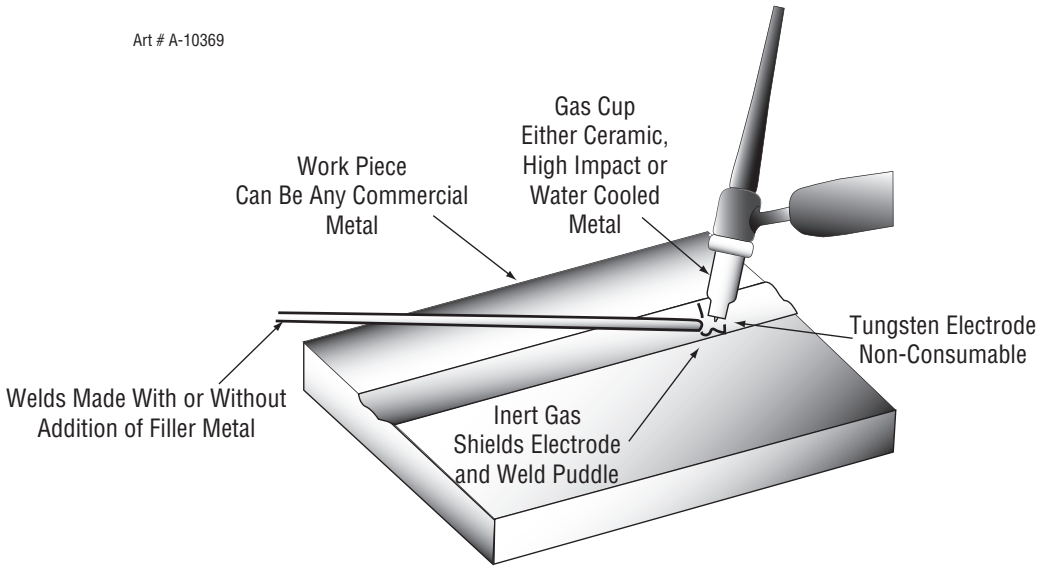


Figure 4-38: TIG Welding Application Shot

Tungsten Electrode Current Ranges

Electrode Diameter	DC Current (Amps)
0.040” (1.0mm)	30-60
1/16” (1.6mm)	60-115
3/32” (2.4mm)	100-165
1/8” (3.2mm)	135-200
5/32” (4.0mm)	190-280
3/16” (4.8mm)	250-340

Table 4-7: Current Ranges for Various Tungsten Electrode Sizes

Guide for Selecting Filler Wire Diameter

Filler Wire Diameter	DC Current Range (Amps)
1/16” (1.6mm)	20-90
3/32” (2.4mm)	65-115
1/8” (3.2mm)	100-165
3/16” (4.8mm)	200-350

Table 4-8: Filler Wire Selection Guide

Tungsten Electrode Types

Electrode Type (Ground Finish)	Welding Application	Features	Color Code
Thoriated 2%	DC welding of mild steel, stainless steel and copper	Excellent arc starting, Long life, High current carrying capacity	Red
Zirconated 1%	High quality AC welding of aluminum, magnesium and their alloys.	Self cleaning, Long life, Maintains balled end, High current carrying capacity.	White
Ceriated 2%	AC & DC welding of mild steel, stainless steel, copper, aluminum, magnesium and their alloys	Longer life, More stable arc, Easier starting, Wider current range, Narrower more concentrated arc.	Grey

Table 4-9

NOTE

The Fabricator 181i is not suited for AC TIG welding.

Base Metal Thickness	DC Current for Mild Steel	DC Current for Stainless Steel	Tungsten Electrode Diameter	Filler Rod Diameter (if required)	Argon Gas Flow Rate CFH	Joint Type
0.040” 1.0mm	35-45 40-50	20-30 25-35	0.040” 1.0mm	1/16” 1.6mm	10-15	Butt/Corner Lap/Fillet
0.045” 1.2mm	45-55 50-60	30-45 35-50	0.040” 1.0mm	1/16” 1.6mm	10-15	Butt/Corner Lap/Fillet
1/16” 1.6mm	60-70 70-90	40-60 50-70	1/16” 1.6mm	1/16” 1.6mm	15	Butt/Corner Lap/Fillet
1/8” 3.2mm	80-100 90-115	65-85 90-110	1/16” 1.6mm	3/32” 2.4mm	15	Butt/Corner Lap/Fillet
3/16” 4.8mm	115-135 140-165	100-125 125-150	3/32” 2.4mm	1/8” 3.2mm	20	Butt/Corner Lap/Fillet
1/4” 6.4mm	160-175 170-200	135-160 160-180	1/8” 3.2mm	5/32” 4.0mm	20	Butt/Corner Lap/Fillet

Table 4-10

TIG Welding is generally regarded as a specialized process that requires operator competency. While many of the principles outlined in the previous Arc Welding section are applicable a comprehensive outline of the TIG Welding process is outside the scope of this Operating Manual. For further information please refer to www.thermadyne.com or contact Thermal Arc.

4.07 TIG (GTAW) Welding Problems

FAULT	CAUSE	REMEDY
1 Excessive bead build up or poor penetration or poor fusion at edges of weld.	Welding current is too low	Increase weld current and/or faulty joint preparation.
2 Weld bead too wide and flat or undercut at edges of weld or excessive burn through.	Welding current is too high	Decrease weld current.
3 Weld bead too small or insufficient penetration or ripples in bead are widely spaced apart.	Travel speed too fast	Reduce travel speed.
4 Weld bead too wide or excessive bead build up or excessive penetration in butt joint.	Travel speed too slow	Increase travel speed.
5 Uneven leg length in fillet joint	Wrong placement of filler rod	Re-position filler rod.
6 Electrode melts or oxidizes when an arc is struck.	A TIG Torch lead connected to positive welding terminal.	A Connect TIG Torch lead to negative welding terminal.
	B No gas flowing to welding region.	B Turn TIG Torch gas valve ON. Check the gas lines for kinks or breaks and gas cylinder contents.
	C TIG Torch is clogged with dust or dirt.	C Clean TIG Torch.
	D Gas hose is cut.	D Replace gas hose.
	E Gas passage contains impurities.	E Disconnect gas hose from the rear of Power Source then raise gas pressure and blow out impurities.
	F Gas regulator turned off.	F Turn on.
	G TIG Torch valve is turned off.	G Turn on.
	H The electrode is too small for the welding current.	H Increase electrode diameter or reduce the welding current.
	I Power Source is set for MIG welding.	I Set Power Source to LIFT TIG mode.

7	Dirty weld pool	A	Electrode contaminated by contact with work piece or filler rod material.	A Clean the electrode by grinding off the contaminates.
		B	Work piece surface has foreign material on it.	B Clean surface.
		C	Gas contaminated with air.	C Check gas lines for cuts and loose fitting or change gas cylinder.
8	Poor weld finish		Inadequate shielding gas.	Increase gas flow or check gas line for gas flow problems.
9	Arc start is not smooth.	A	Tungsten electrode is too large for the welding current.	A Select the right size electrode. Refer to Table 4-7 Current Ranges for Various Tungsten Electrode Size.
		B	The wrong electrode is being used for the welding job.	B Select the right electrode type. Refer to Table 4-9 Tungsten Electrode Types.
		C	Gas flow rate is too high.	C Select the right rate for the welding job. Refer to Table 4-10.
		D	Incorrect shielding gas is being used.	D Select the right shielding gas.
		E	Poor work clamp connection to work piece.	E Improve connection to work piece.
10	Arc flutters during TIG welding.		Tungsten electrode is too large for the welding current.	Select the right size electrode. Refer to Table 4-7 Current Ranges for Various Electrode Size.
11	Tungsten blackens due to lack of shielding gas	A	Gas valve on the TIG Torch has not be turned on.	A Turn on TIG Torch gas valve before you commence welding.
		B	Gas cylinder valve off or TIG Torch hose not connected to regulator	B Turn on gas cylinder valve or connect TIG Torch hose to regulator.

Table 4-11: TIG (GTAW) Welding Problems

SECTION 5:
POWER SOURCE PROBLEMS AND ROUTINE SERVICE REQUIREMENTS

5.01 Power Source Problems

	FAULT		CAUSE		REMEDY
1	Electricity Supply is ON, power indicator is illuminated however the Power Source will not commence welding when the torch trigger switch is depressed.	A	Power Source is not in the correct mode of operation.	A	Set the Power Source to the correct mode of operation with the process selection switch.
		B	Faulty torch trigger.	B	Repair or replace torch trigger switch/lead.
2	Fault Indicator is illuminated and the Power Source will not commence welding when the torch trigger switch is depressed.		Duty cycle of Power Source has been exceeded.		Leave the Power Source switched ON and allow it to cool. Note that fault indicator must be extinguished prior to commencement of welding.
3	The Power Source will not feed wire in MIG mode.	A	Electrode wire stuck in conduit liner or contact tip (burn-back jam).	A	Check for clogged / kinked MIG Gun conduit liner or worn contact tip. Replace faulty components.
		B	MIG GUN/SPOOL GUN switch is switched to SPOOL GUN.	B	Switch the MIG GUN/SPOOL GUN switch to MIG GUN.
4	Welding wire continues to feed when torch trigger is released.	A	Trigger mode selection switch is in 4T latch mode.	A	Change the trigger mode selection switch from 4T latch mode to 2T normal mode.
		B	Torch trigger leads shorted.	B	Repair or replace torch trigger switch/lead.
5	Welding arc cannot be established in MIG mode.	A	MIG Gun polarity lead is not connected into a welding output terminal.	A	Connect the MIG Gun polarity lead to either the positive welding output terminal or the negative welding output terminal as required.
		B	Poor or no work lead contact.	B	Clean work clamp area and ensure good electrical contact.
6	Inconsistent wire feed.	A	Worn or dirty contact tip.	A	Replace if necessary.
		B	Worn feed roll.	B	Replace.
		C	Excessive brake tension on wire reel hub.	C	Reduce brake tension on spool hub
		D	Worn, kinked or dirty conduit liner	D	Clean or replace conduit liner
7	No gas flow in MIG mode.	A	Gas hose is damaged.	A	Replace or repair.
		B	Gas passage contains impurities.	B	Disconnect gas hose from the rear of Power Source and blow out impurities.
		C	Gas regulator turned off.	C	Turn on regulator.
		D	Empty gas cylinder.	D	Replace gas cylinder.

8	Gas flow continues after the torch trigger switch has been released (MIG mode).	Gas valve has jammed open due to impurities in the gas or the gas line.	Have an accredited Thermal Arc service provider repair or replace gas valve.
9	Power indicator will not illuminate and welding arc cannot be established.	The Electricity Supply voltage has exceeded voltage limits of the Power Source.	Ensure that the Electricity Supply voltage is within 208-265 VAC..
10	TIG electrode melts when arc is struck.	TIG Torch is connected to the (+) VE terminal.	Connect the TIG Torch to the (-) VE terminal.
11	Arc flutters during TIG welding.	Tungsten electrode is too large for the welding current.	Select the correct size of tungsten electrode. Refer to Table 4-7.

Table 5-1

5.02 Routine Service and Calibration Requirements

WARNING

There are extremely dangerous voltage and power levels present inside this Power Source. Do not attempt to open or repair unless you are an accredited Thermal Arc Service Provider. Disconnect the Welding Power Source from the Electricity Supply Voltage before disassembling.

Routine Inspection, Testing & Maintenance

The inspection and testing of the Power Source and associated accessories shall be carried out in accordance with Section 5 of EN 60974-1: Safety in Welding and Allied Processes-Part 2 Electrical. This includes an insulation resistance test and an earthing test to ensure the integrity of the Power Source is compliant with Thermal Arc's original specifications.

If equipment is to be used in a hazardous location or environments with a high risk of electrocution as outlined in EN 60974-1, then the above tests should be carried out prior to entering this location.

A. Testing Schedule

1. For transportable equipment, at least once every 3 months; and
2. For fixed equipment, at least once every 12 months.

The owners of the equipment shall keep a suitable record of the periodic tests and a system of tagging, including the date of the most recent inspection.

A transportable Power Source is deemed to be any equipment that is not permanently connected and fixed in the position in which it is operated.

NOTE

Please refer to local guidelines for further information.

B. Insulation Resistance

Minimum insulation resistance for in-service Thermal Arc Power Sources shall be measured at a voltage of 500V between the parts referred to in Table 6-1below. Power Sources that do not meet the insulation resistance requirements set out below shall be withdrawn from service and not returned until repairs have been performed such that the requirements outlined below are met.

Components to be Tested	Minimum Insulation Resistance (M Ω)
Input circuit (including any connected control circuits) to welding circuit (including any connected control circuits)	5
All circuits to exposed conductive parts	2.5
Welding circuit (including any connected control circuits) to any auxiliary circuit which operates at a voltage exceeding extra low voltage	10
Welding circuit (including any connected control circuits) to any auxiliary circuit which operates at a voltage not exceeding extra low voltage	1
Separate welding circuit to separate welding circuit	1

Table 5-2: Minimum Insulation Resistance Requirements: Thermal Arc Power Sources

C. Earthing

The resistance shall not exceed 1Ω between any metal of a Power Source where such metal is required to be earthed, and -

1. The earth terminal of a fixed Power Source; or
2. The earth terminal of the associated plug of a transportable Power Source

Note that due to the dangers of stray output currents damaging fixed wiring, the integrity of fixed wiring supplying Thermal Arc welding Power Sources should be inspected by a licensed electrical worker in accordance with the requirements below -

1. For outlets/wiring and associated accessories supplying transportable equipment - at least once every 3 months; and
2. For outlets/wiring and associated accessories supplying fixed equipment - at least once every 12 months.

D. General Maintenance Checks

Welding equipment should be regularly checked by an accredited Thermal Arc Service Provider to ensure that:

1. Flexible cord is of the multi-core tough rubber or plastic sheathed type of adequate rating, correctly connected and in good condition.
2. Welding terminals are in suitable condition and are shrouded to prevent inadvertent contact or short circuit.
3. The Welding System is clean internally, especially from metal filing, slag, and loose material.

E. Accessories

Accessory equipment, including output leads, electrode holders, torches, wire feeders and the like shall be inspected at least monthly by a competent person to ensure that the equipment is in a safe and serviceable condition. All unsafe accessories shall not be used.

F. Repairs

If any parts are damaged for any reason, it is recommended that replacement be performed by an accredited Thermal Arc Service Provider.

Power Source Calibration

A. Schedule

Output testing of all Thermal Arc Power Sources and applicable accessories shall be conducted at regular intervals to ensure they fall within specified levels. Calibration intervals shall be as outlined below -

1. For transportable equipment, at least once every 3 months; and
2. For fixed equipment, at least once every 12 months.

If equipment is to be used in a hazardous location or environments with a high risk of electrocution as outlined in EN 60974-1, then the above tests should be carried out prior to entering this location.

B. Calibration Requirements

Where applicable, the tests outlined in Table 6-3 below shall be conducted by an accredited Thermal Arc service agent.

Testing Requirements
Output current (A) to be checked to ensure it falls within applicable Thermal Arc Power Source specifications
Output Voltage (V) to be checked to ensure it falls within applicable Thermal Arc Power Source specifications
Motor Speed (RPM) of wire drive motors to be checked to ensure it falls within required Thermal Arc Power Source / wire feeder specifications
Accuracy of digital meters to be checked to ensure it falls within applicable Thermal Arc Power Source specifications

Table 5-3: Calibration Parameters

Periodic calibration of other parameters such as timing functions are not required unless a specific fault has been identified.

C. Calibration Equipment

All equipment used for Power Source calibration shall be in proper working condition and be suitable for conducting the measurement in question. Only test equipment with valid calibration certificates (NATA certified laboratories) shall be utilized.

5.03 Cleaning the Welding Power Source

WARNING

There are dangerous voltage and power levels present inside this product. Do not attempt to open or repair unless you are a qualified electrical tradesperson. Disconnect the Welding Power Source from the Electricity Supply Voltage before disassembling.

To clean the Welding Power Source, open the enclosure and use a vacuum cleaner to remove any accumulated dirt, metal filings, slag and loose material. Keep the shunt and lead screw surfaces clean as accumulated foreign material may reduce the welders output welding current.

5.04 Cleaning the Feed Rolls

Clean the grooves in the drive rolls frequently. This can be done by using a small wire brush. Also wipe off, or clean the grooves on the upper feed roll. After cleaning, tighten the feed roll retaining knobs.

CAUTION

Do not use compressed air to clean the Welding Power Source. Compressed air can force metal particles to lodge between live electrical parts and earthed metal parts within the Welding Power Source. This may result in arcing between this parts and their eventual failure.

5.05 Volt-Ampere Curves

Voltage-Amperage Curves shows maximum voltage and amperage output capabilities of welding power source. Curves of other settings fall between curves shown.

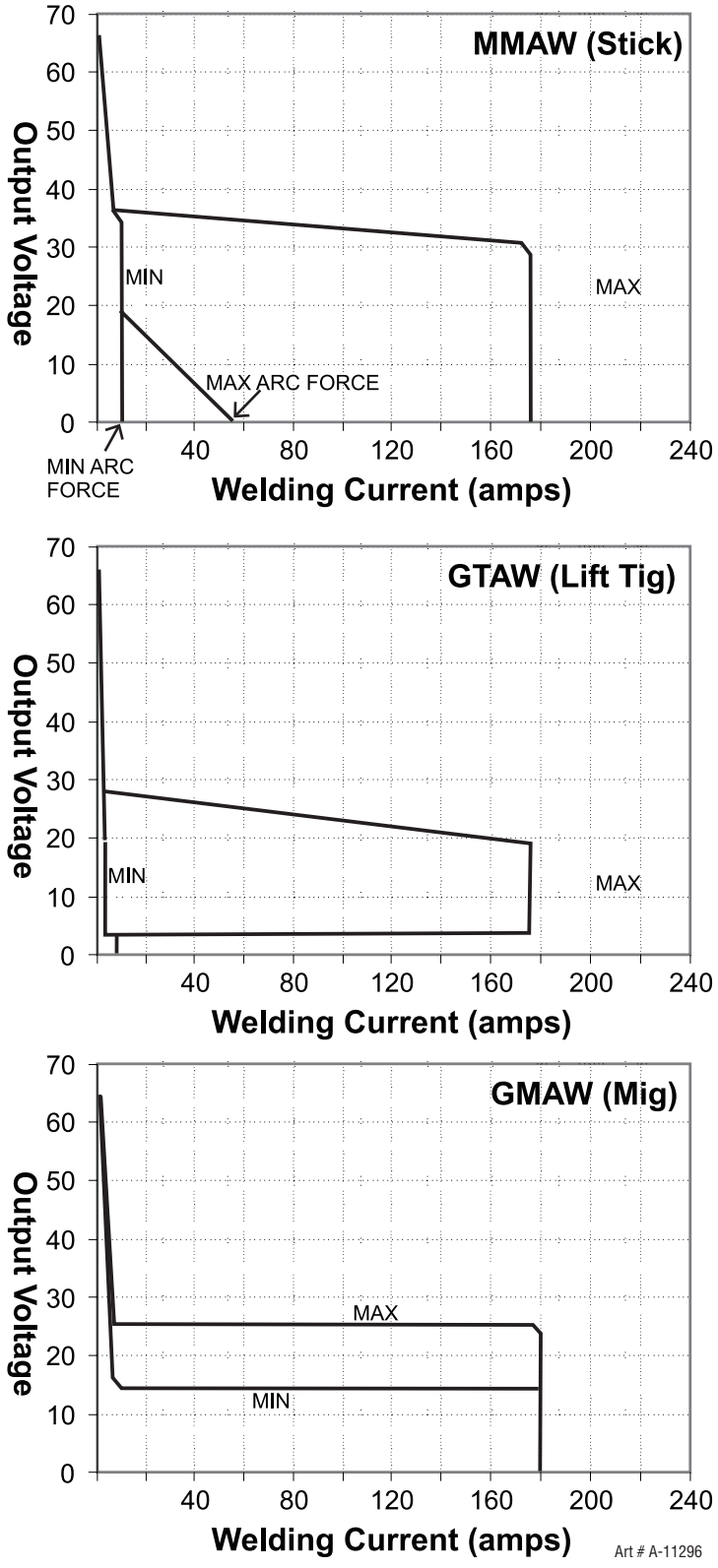


Figure 5-1: Fabricator 181i Volt-Ampere Curves

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SECTION 6:
KEY SPARE PARTS

6.01 Tweco WeldSkill 180A MIG Gun

MIG Gun Part No: WS180TA-12-3035

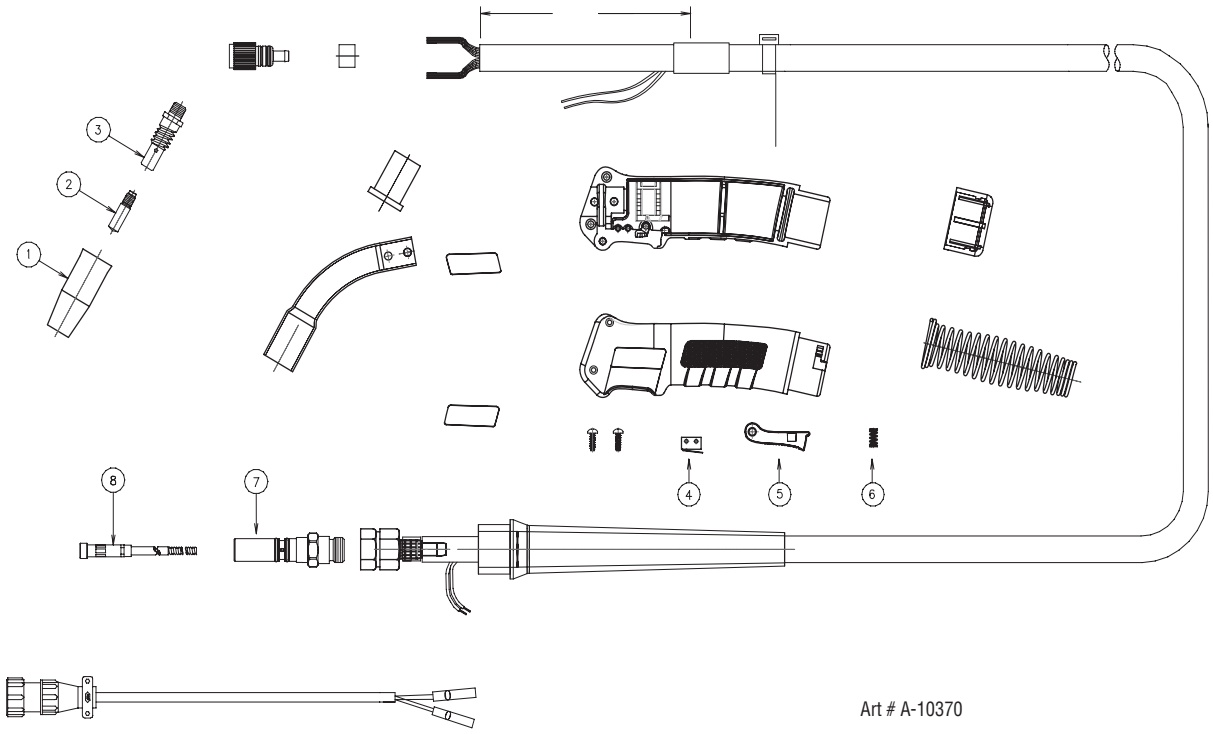

Figure 6-1

TWECO WELDSKILL 180A MIG GUN PARTS		
ITEM	**PART NO.**	**DESCRIPTION**
1	1210-1112	Nozzle
2	1110-1101	Contact Tip
3	1510-1101	Gas Diffuser
4	2042-2053	Microswitch
5	2042-2054	Trigger Lever
6	2042-2055	Trigger Lever Spring
7	2035-2110	Tweco Rear Connector Plug
8	1420-1113	Conduit Assembly

Table 6-2

6.02 Power Source

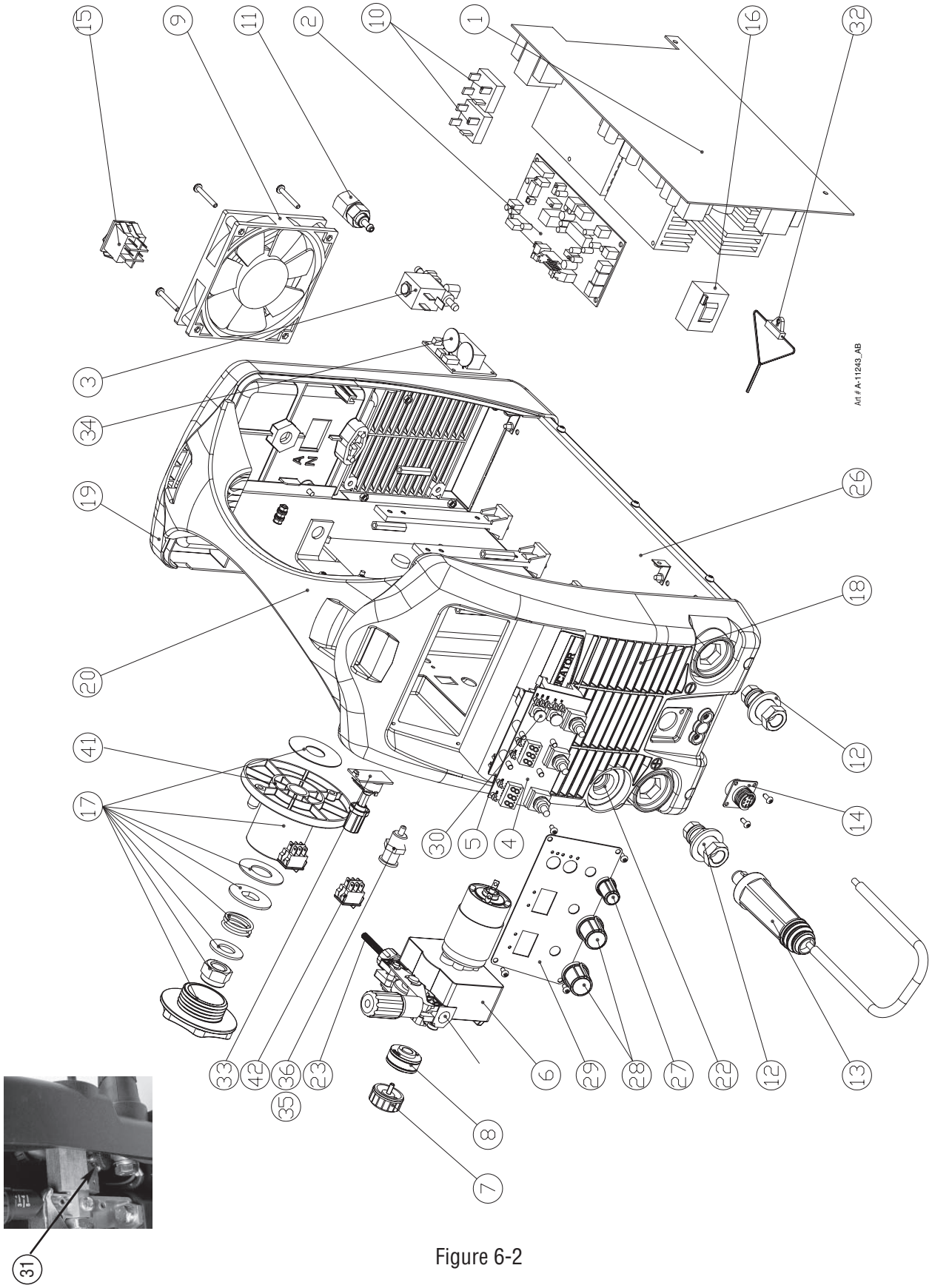

Figure 6-2

FABRICATOR 181i POWER SOURCE SPARE PARTS		
ITEM	**PART NUMBER**	**DESCRIPTION**
1	W7004962	PCB,Power,181i
2	W7004963	PCB,Control,181i
3	W7003033	Solenoid,Valve,24VDC
4	W7004970	PCB,Display,181i
5	W7004969	PCB,Remote Interface,181i
6	W7004905	Wiredrive Assy,w/ Motor,181i
7	W7004906	Feedroll retaining thumb screw
8	7977036	Feed Roll .024(0.6mm)-.030"(0.8mm) V groove Installed
9	W7004947	Fan,24VDC,4.75"x4.75"x1",181i
10	W7003010	Rectifier Bridge,1000V,50A
11	W7003215	Connector,Gas Inlet,5/8"-18UNF
12	W7004909	Dinse,Socket,181i
13	W7004955	Connector,Dinse,181i
14	W7004942	Socket,8 Pin,w/ Harness
15	W7003053	Switch,On/Off,250V
16	W7004911	CT Sensor,Output,181i
17	W7004912	Wire Hub Assy,181i
18	W7004975	Panel, Front
19	W7004976	Panel, Rear
20	W7004922	Handle,181i
21	W7004977	Side and Top Panels (not shown)
22	W7004966	Adapter,Tweco 4,181i
23	W7004925	Guide,Inlet,.023-.045,181i
24	W7004967	Guide,Inlet,.023-.045,181i
25	W7004978	Panel,Door (not shown)
26	W7004928	Panel,Base,181i
27	870734	Knob,1/4" IDx.72" ODx.9" H
28	W7004972	Knob,1/4" IDx1" ODx0.9" H
29	W7004957	Panel,Front Control,181i
30	W7004953	Push Button Actuator
31	OTWAK/1S	Screw,Locking,MIG Gun
32	W7004961	Thermistor,NTC,K45 47K,181i
33	W7004940	PCB Burnback Potentiometer
34	W7004968	PCB,Spool Gun,181i
35	W7004979	Fuse Holder,181i
36	W7004982	Fuse,10 Amp
37	9-0025	Power Cord,12AWG,NEMA 6-50P (not shown)
38	W7004973	Label,Setup Chart,181i,English (not shown)
39	W7004974	Label,Setup Chart,181i,French (not shown)
40	W7004960	Inductor,181i (not shown)
41	W7004951	Spool Hub,181i
42	W7004943	Switch,250V/2A,181i
43	W7004983	Shoulder strap, 181i (not shown)

Table 6-2

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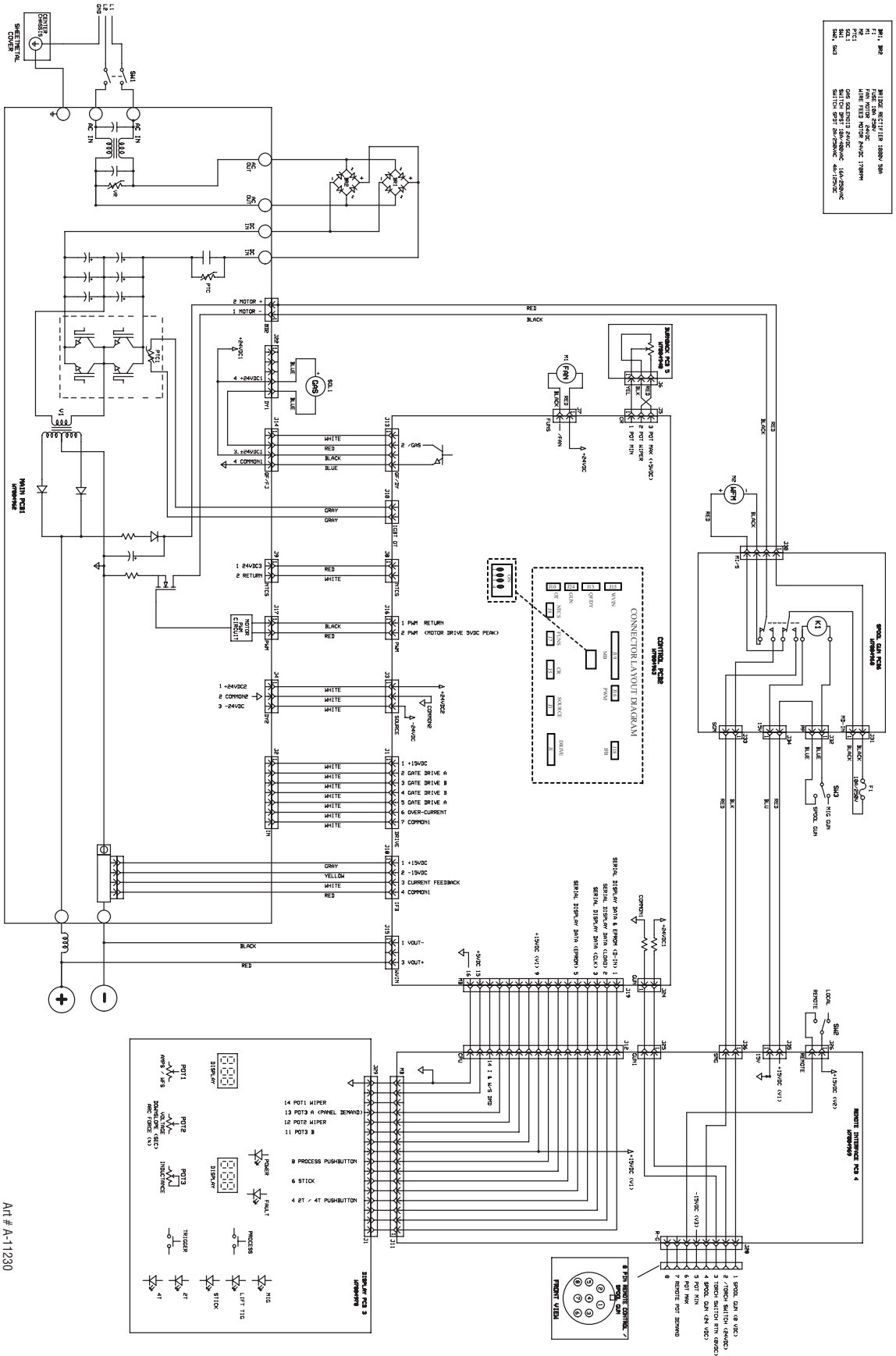
APPENDIX: FABRICATOR 181i CIRCUIT DIAGRAM



Art # A-11230

THERMAL ARC - LIMITED WARRANTY TERMS

LIMITED WARRANTY: Thermal Arc ®, Inc, A Thermadyne Company, hereafter, “Thermal Arc” warrants to customers of its authorized distributors hereafter “Purchaser” that its products will be free of defects in workmanship or material. Should any failure to conform to this warranty appear within the time period applicable to the Thermal Arc products as stated below, Thermal Arc shall, upon notification thereof and substantiation that the product has been stored, installed, operated, and maintained in accordance with Thermal Arc’s specifications, instructions, recommendations and recognized standard industry practice, and not subject to misuse, repair, neglect, alteration, or accident, correct such defects by suitable repair or replacement, at Thermal Arc’s sole option, of any components or parts of the product determined by Thermal Arc to be defective.

THERMAL ARC MAKES NO OTHER WARRANTY, EXPRESS OR IMPLIED. THIS WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHERS, INCLUDING, BUT NOT LIMITED TO ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE.

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PURCHASER’S RIGHTS UNDER THIS WARRANTY ARE VOID IF REPLACEMENT PARTS OR ACCESSORIES ARE USED WHICH IN THERMAL ARC’S SOLE JUDGMENT MAY IMPAIR THE SAFETY OR PERFORMANCE OF ANY THERMAL ARC PRODUCT. PURCHASER’S RIGHTS UNDER THIS WARRANTY ARE VOID IF THE PRODUCT IS SOLD TO PURCHASER BY NON-AUTHORIZED PERSONS.

The warranty is effective for the time stated below beginning on the date that the authorized distributor delivers the products to the Purchaser. Notwithstanding the foregoing, in no event shall the warranty period extend more than the time stated plus one year from the date Thermal Arc delivered the product to the authorized distributor.

WARRANTY SCHEDULE

THERMAL ARC

5 Years Parts* / 3 Years Labor

ArcMaster, Excelarc, Fabricator, Fabstar, PowerMaster

Portafeed, Ultrafeed, Ultima 150, WC 100B

* 5 years on the Original Main Power Transformer and Inductors not mounted on PCBoards.

* 3 years on Power Supply Components

2 Years Parts and Labor Unless specified

Auto-Darkening Welding Helmet (electronic Lens), ** 1 Month Harness Assy

Victor Regulator for Fabricator 181i (No labor)

1 Years Parts and Labor Unless specified

95S, Water recirculators

All Plasma Welding consols (i.e WC-1 Controller, WT Timer,

WF-100 Capstain Feeder, etc)

180 days parts and Labor Unless specified

Plasma Welding Torch and leads packages

Gas Regulators "Supplied with power sources" (No Labor)

90 days parts / No Labor

Remote Controls

MIG and TIG Torches (Supplied with power sources)

Replacement repair parts

30 days parts / No Labor

MIG Torch for Fabricator 181i

5-2-1 years Parts / No Labor

FirePower® Welders

VICTOR

5 Years Parts / No Labor

Victor® Professional

Thermadyne limited warranty shall not apply to:

Consumable Parts for MIG, TIG, Plasma welding, Plasma cutting and Oxy fuel torches, O-rings, fuses, filters or other parts that fail due normal wear

* Warranty repairs or replacement claims under this limited warranty must be submitted by an authorized THERMADYNE® repair facility within thirty (30) days of the repair.

* No employee, agent, or representative of THERMADYNE® is authorized to change this warranty in any way or grant any other warranty, and THERMADYNE® shall not be bound by any such attempt. Correction of non-conformities, in the manner and time provided herein, constitutes fulfillment of THERMADYNE®'s obligations to purchaser with respect to the product.

* This warranty is void, and seller bears no liability hereunder, if purchaser used replacement parts or accessories which, in THERMADYNE®'s sole judgment, impaired the safety or performance of any THERMADYNE® product. Purchaser's rights under this warranty are void if the product is sold to purchaser by unauthorized persons.

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