

INSTRUCTION MANUAL FOR STICK WELDING MACHINE

IMPORTANT SAFETY INFORMATION!!!

READ THE FOLLOWING INSTRUCTIONS CAREFULLY BEFORE INSTALLATION, USE, OR SERVICING OF THIS UNIT. PAY CLOSE ATTENTION TO THE SAFETY RULES AND CONTACT YOUR DISTRIBUTOR IF YOU DO NOT UNDERSTAND SOME OR ALL OF THE POINTS COVERED IN THESE INSTRUCTIONS.








1 GENERAL INFORMATION

This manual has been prepared with the intent of instructing the operator on how to install, operate, and properly maintain this electric arc welding machine. This machine is a constant current power source which can weld coated electrodes and scratch start TIG weld.

This welding machine must be used only for the purposes described in the instruction manual. Upon receiving and unpacking the machine, make a careful inspection to ensure that there are no damaged parts. Should there be a claim for losses or damages it must be made by the purchaser directly to the shipper who handled the goods.

When requesting information about this welding machine please state the machine's part number and serial number to ensure receiving accurate information relating to your machine.

1.1 DESCRIPTION OF TECHNICAL SPECIFICATIONS

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3 ~   ---		EN 60974-1			
 		A / V - A / V			
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$V \div V$		I ₂	A	A	A
PEAK		U ₂	V	V	V
					
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IEC 974.1
EN 60974.1
Nº.





 U₀ PEAK
 X.

This machine is manufactured according to these international standards. Machine Serial Number which must appear on requests or inquiries relating to the machine. Three-phase transformer-rectifier.

Drooping characteristic.

Shielded Metal Arc Welding. (Stick Welding)
 Secondary no-load voltage. Peak value.
 Duty-Cycle Percentage.
 The duty-cycle is the number of minutes, expressed as a percentage, the machine can operate (arc on) within a ten minute period without overheating. The duty cycle

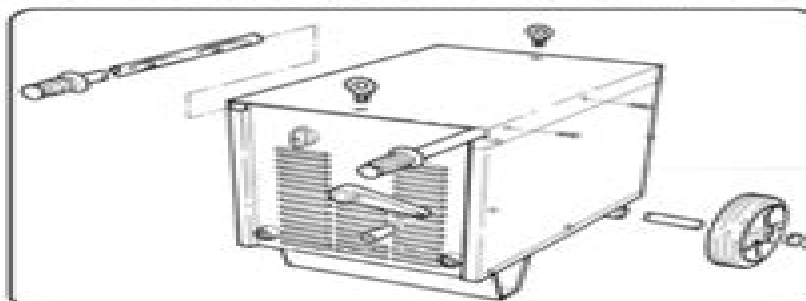
varies according to the output current.
 Output welding current.
 Secondary voltage, welding current = I₂.
 Nominal supply voltage.
 Three-phase input supply at 50 or 60 Hz.
 Input Amps absorbed corresponding to different output levels (I₂).
 Machine case protection class.
 The 1 in the singles digit place means that this unit is not fit to work outdoors in the rain. Fit to work in hazardous areas.
[S]
 NOTE: This machine has also been designed to work in class 3 pollution areas (see IEC 664).

2 INSTALLATION

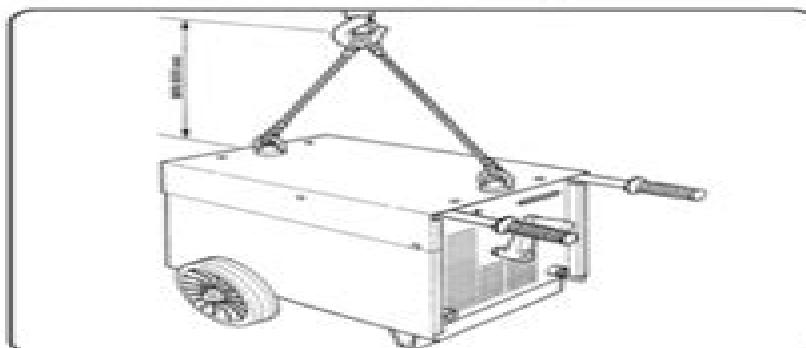
2.1 SETUP

All connections must be made in compliance with current regulations and in full respect of safety laws (see CENELEC HD 427 standard).

- Assemble the parts supplied with the welding machine.



- Remove the machine from its pallet following the instructions.
- To lift the machine use the two upper eyebolts, placing the ropes as shown in fig.
- The handles must not be used for lifting.



Welding Instructions Guide

**Steel Construction Institute (Great
Britain)**

A red circular graphic with a gradient, appearing as a partial circle or a thick arc, located to the right of the text box.

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Technical Manual United States. War Department,1949 **Operator, Organizational, and Direct Support Maintenance Manual, Including Repair Parts and Special Tools Lists** ,1992 Underwater Cutting and Welding Manual United States. Navy Department. Bureau of Ships,1954 Arc-welding Manual for the Design and Control of Welded Construction United States. Bureau of Reclamation,1950 **Vocational Education : State Instruction Materials for ...** Curriculum and Instructional Materials Center (Okla.),Texas Education Agency. Department of Occupational Education and Technology,1973 A Quick Guide to Welding and Weld Inspection S E Hughes,2009-10-20 A concise and accessible guide to the knowledge required to fulfil the role of a welding inspector In covering both European and US based codes the book gives those wishing to gain certification in welding inspection a basic all round understanding of the main subject matter A concise and accessible guide to the knowledge required to fulfil the role of a welding inspector Covers both European and US based codes Gives those wishing to gain certification in welding inspection a basic all round understanding of the main subject matter **Vocational Education : State Instruction Materials for ...** Oklahoma. State Department of Vocational and Technical Education. Curriculum and Instructional Materials Center,1974 **Marine safety manual** United States. Coast Guard,1985 **Marine Safety Manual: Technical** United States. Coast Guard,1985 **Bibliography of Scientific and Industrial Reports** ,1946 **Welding Equipment** United States. Bureau of Foreign and Domestic Commerce,1950 **Occupational Outlook Handbook** ,2000 Describes 250 occupations which cover approximately 107 million jobs *Welding Processes Handbook* Klas Weman,2003 Welding processes handbook is an introductory guide to all of the main welding processes It is specifically designed for students on EWF courses and newcomers to welding and is suitable as a textbook for European welding courses in accordance with guidelines from the European Welding Federation Welding processes and equipment necessary for each process are described so that they can be applied to all instruction levels required by the EWF and the important areas of welded joint design quality assurance and costing are also covered in detail *Steel Designers' Manual* Steel Construction Institute (Great Britain),2012-02-20 In 2010 the then current European national standards for building and construction were replaced by the EN Eurocodes a set of pan European model building codes developed by the European Committee for Standardization The Eurocodes are a series of 10 European Standards EN 1990 EN 1999 that provide a common approach for the design of buildings other civil engineering works and construction products The design standards embodied in these Eurocodes will be used for all European public works and are set to become the de facto standard for the private sector in Europe with probable adoption in many other countries This classic manual on structural steelwork design was first published in 1955 since when it has sold many tens of thousands of copies worldwide For the seventh edition of the Steel Designers Manual all chapters have been comprehensively reviewed revised to ensure they reflect current approaches and best practice and brought in to compliance with EN 1993 Design of Steel

Structures the so called Eurocode 3 The 1984 Guide to the Evaluation of Educational Experiences in the Armed Services,1984 *Manual of Engineering Drawing* Colin H. Simmons,Dennis E. Maguire,2009-03-24 The Manual of Engineering Drawing has long been the recognised as a guide for practicing and student engineers to producing engineering drawings and annotated 3D models that comply with the latest British and ISO Standards of Technical Product Specifications and Documentation This new edition has been updated to include the requirements of BS8888 2008 and the relevant ISO Standards and is ideal for International readership it includes a guide to the fundamental differences between the ISO and ASME Standards relating to Technical Product Specification and Documentation Equally applicable to CAD and manual drawing it includes the latest development in 3D annotation and the specification of surface texture The Duality Principle is introduced as this important concept is still very relevant in the new world of 3D Technical Product Specification Written by members of BSI and ISO committees and a former college lecturer the Manual of Engineering Drawing combines up to the minute technical information with clear readable explanations and numerous diagrams and traditional geometrical construction techniques rarely taught in schools and colleges This approach makes this manual an ideal companion for students studying vocational courses in Technical Product Specification undergraduates studying engineering or product design and any budding engineer beginning a career in design The comprehensive scope of this new edition encompasses topics such as orthographic and pictorial projections dimensional geometrical and surface tolerancing 3D annotation and the duality principle along with numerous examples of electrical and hydraulic diagrams with symbols and applications of cams bearings welding and adhesives The definitive guide to draughting to the latest ISO and ASME standards An essential reference for engineers and students involved in design engineering and product design Written by two ISO committee members and practising engineers *Resources in Education* ,1989 *Interim Guidelines* ,1995 Designer's Guide for Welded Construction Lincoln Electric Company,1954 **Steel Detailers' Manual** Alan Hayward, Frank Weare, A. C. Oakhill,2011-03-01 This highly illustrated manual provides practical guidance on structural steelwork detailing It describes the common structural shapes in use and how they are joined to form members and complete structures explains detailing practice and conventions provides detailing data for standard sections bolts and welds emphasises the importance of tolerances in order to achieve proper site fit up discusses the important link between good detailing and construction costs Examples of structures include single and multi storey buildings towers and bridges The detailing shown will be suitable in principle for fabrication and erection in many countries and the sizes shown will act as a guide to preliminary design The third edition has been revised to take account of the new Eurocodes on structural steel work together with their National Annexes The new edition also takes account of developments in 3 D modelling techniques and it includes more CAD standard library details

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