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June 2003

**Processes**



MIG (GMAW) Welding

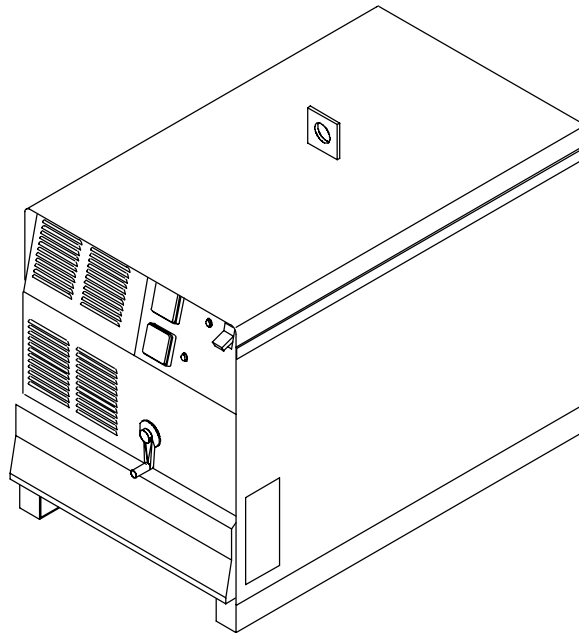
Flux Cored (FCAW) Welding

**Description**



Arc Welding Power Source

# CP-302 and CP-252TS



## OWNER'S MANUAL



Visit our website at  
[www.MillerWelds.com](http://www.MillerWelds.com)

# From Miller to You

*Thank you and congratulations* on choosing Miller. Now you can get the job done and get it done right. We know you don't have time to do it any other way.

That's why when Niels Miller first started building arc welders in 1929, he made sure his products offered long-lasting value and superior quality. Like you, his customers couldn't afford anything less. Miller products had to be more than the best they could be. They had to be the best you could buy.

Today, the people that build and sell Miller products continue the tradition. They're just as committed to providing equipment and service that meets the high standards of quality and value established in 1929.

This Owner's Manual is designed to help you get the most out of your Miller products. Please take time to read the Safety precautions. They will help you protect yourself against potential hazards on the worksite.

We've made installation and operation quick and easy. With Miller you can count on years of reliable service with proper maintenance. And if for some reason the unit needs repair, there's a Troubleshooting section that will help you figure out what the problem is. The parts list will then help you to decide the exact part you may need to fix the problem. Warranty and service information for your particular model are also provided.



Miller is the first welding equipment manufacturer in the U.S.A. to be registered to the ISO 9001:2000 Quality System Standard.

Miller Electric manufactures a full line of welders and welding related equipment. For information on other quality Miller products, contact your local Miller distributor to receive the latest full line catalog or individual catalog sheets. **To locate your nearest distributor or service agency call 1-800-4-A-Miller, or visit us at [www.MillerWelds.com](http://www.MillerWelds.com) on the web.**



Working as hard as you do – every power source from Miller is backed by the most hassle-free warranty in the business.

*Miller offers a Technical Manual which provides more detailed service and parts information for your unit. To obtain a Technical Manual, contact your local distributor. Your distributor can also supply you with Welding Process Manuals such as SMAW, GTAW, GMAW, and GMAW-P.*



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## WARNING

This product, when used for welding or cutting, produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code Section 25249.5 et seq.)

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The following term is used interchangeably throughout this manual:  
MIG = GMAW



# SECTION 1 – SAFETY PRECAUTIONS - READ BEFORE USING

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## 1-1. Symbol Usage



Means Warning! Watch Out! There are possible hazards with this procedure! The possible hazards are shown in the adjoining symbols.

▲ Marks a special safety message.

☞ Means "Note"; not safety related.



This group of symbols means Warning! Watch Out! possible ELECTRIC SHOCK, MOVING PARTS, and HOT PARTS hazards. Consult symbols and related instructions below for necessary actions to avoid the hazards.

## 1-2. Arc Welding Hazards

▲ The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard. The safety information given below is only a summary of the more complete safety information found in the Safety Standards listed in Section 1-4. Read and follow all Safety Standards.

▲ Only qualified persons should install, operate, maintain, and repair this unit.

▲ During operation, keep everybody, especially children, away.



### 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

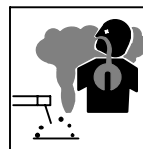
live when power is on. In semiautomatic or automatic wire welding, the wire, wire reel, drive roll housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is a hazard.

- Do not touch live electrical parts.
- Wear dry, hole-free insulating gloves and body protection.
- Insulate yourself from work and ground using dry insulating mats or covers big enough to prevent any physical contact with the work or ground.
- Do not use AC output in damp areas, if movement is confined, or if there is a danger of falling.
- Use AC output ONLY if required for the welding process.
- If AC output is required, use remote output control if present on unit.
- Disconnect input power or stop engine before installing or servicing this equipment. Lockout/tagout input power according to OSHA 29 CFR 1910.147 (see Safety Standards).
- Properly install and ground this equipment according to its Owner's Manual and national, state, and local codes.
- Always verify the supply ground – check and be sure that input power cord ground wire is properly connected to ground terminal in disconnect box or that cord plug is connected to a properly grounded receptacle outlet.
- When making input connections, attach proper grounding conductor first – double-check connections.
- Frequently inspect input power cord for damage or bare wiring – replace cord immediately if damaged – bare wiring can kill.
- Turn off all equipment when not in use.
- Do not use worn, damaged, undersized, or poorly spliced cables.
- Do not drape cables over your body.

- If earth grounding of the workpiece is required, ground it directly with a separate cable.
- Do not touch electrode if you are in contact with the work, ground, or another electrode from a different machine.
- Use only well-maintained equipment. Repair or replace damaged parts at once. Maintain unit according to manual.
- Wear a safety harness if working above floor level.
- Keep all panels and covers securely in place.
- Clamp work cable with good metal-to-metal contact to workpiece or worktable as near the weld as practical.
- Insulate work clamp when not connected to workpiece to prevent contact with any metal object.
- Do not connect more than one electrode or work cable to any single weld output terminal.

### SIGNIFICANT DC VOLTAGE exists after removal of input power on inverters.

- Turn Off inverter, disconnect input power, and discharge input capacitors according to instructions in Maintenance Section before touching any parts.



### FUMES AND GASES can be hazardous.

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

- Keep your head out of the fumes. Do not breathe the fumes.
- If inside, ventilate the area and/or use exhaust at the arc to remove welding fumes and gases.
- If ventilation is poor, use an approved air-supplied respirator.
- Read the Material Safety Data Sheets (MSDSs) and the manufacturer's instructions for metals, consumables, coatings, cleaners, and degreasers.
- Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Always have a trained watch-person nearby. Welding fumes and gases can displace air and lower the oxygen level causing injury or death. Be sure the breathing air is safe.
- 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.
- 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.



### ARC RAYS can burn eyes and skin.

Arc rays from the welding process produce intense visible and invisible (ultraviolet and infrared) rays that can burn eyes and skin. Sparks fly off from the weld.

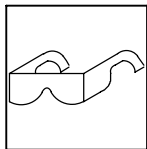
- Wear a welding helmet fitted with a proper shade of filter to protect your face and eyes when welding or watching (see ANSI Z49.1 and Z87.1 listed in Safety Standards).
- Wear approved safety glasses with side shields under your helmet.
- Use protective screens or barriers to protect others from flash and glare; warn others not to watch the arc.
- Wear protective clothing made from durable, flame-resistant material (leather and wool) and foot protection.



### WELDING can cause fire or explosion.

Welding on closed containers, such as tanks, drums, or pipes, can cause them to blow up. Sparks can fly off from the welding arc. The flying sparks, hot workpiece, and hot equipment can cause fires and burns. Accidental contact of electrode to metal objects can cause sparks, explosion, overheating, or fire. Check and be sure the area is safe before doing any welding.

- Protect yourself and others from flying sparks and hot metal.
- Do not weld where flying sparks can strike flammable material.
- Remove all flammables within 35 ft (10.7 m) of the welding arc. If this is not possible, tightly cover them with approved covers.
- Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas.
- Watch for fire, and keep a fire extinguisher nearby.
- Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.
- Do not weld on closed containers such as tanks, drums, or pipes, unless they are properly prepared according to AWS F4.1 (see Safety Standards).
- 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.
- Do not use welder to thaw frozen pipes.
- Remove stick electrode from holder or cut off welding wire at contact tip when not in use.
- Wear oil-free protective garments such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap.
- Remove any combustibles, such as a butane lighter or matches, from your person before doing any welding.



### FLYING METAL can injure eyes.

- Welding, chipping, wire brushing, and grinding cause sparks and flying metal. As welds cool, they can throw off slag.
- Wear approved safety glasses with side shields even under your welding helmet.



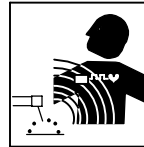
### BUILDUP OF GAS can injure or kill.

- Shut off shielding gas supply when not in use.
- Always ventilate confined spaces or use approved air-supplied respirator.



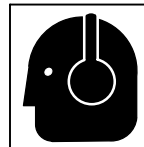
### HOT PARTS can cause severe burns.

- Do not touch hot parts bare handed.
- Allow cooling period before working on gun or torch.



### MAGNETIC FIELDS can affect pacemakers.

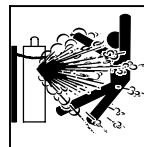
- Pacemaker wearers keep away.
- Wearers should consult their doctor before going near arc welding, gouging, or spot welding operations.



### NOISE can damage hearing.

Noise from some processes or equipment can damage hearing.

- Wear approved ear protection if noise level is high.



### 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.

- Protect compressed gas cylinders from excessive heat, mechanical shocks, slag, open flames, sparks, and arcs.
- Install cylinders in an upright position by securing to a stationary support or cylinder rack to prevent falling or tipping.
- Keep cylinders away from any welding or other electrical circuits.
- Never drape a welding torch over a gas cylinder.
- Never allow a welding electrode to touch any cylinder.
- Never weld on a pressurized cylinder – explosion will result.
- Use only correct shielding gas cylinders, regulators, hoses, and fittings designed for the specific application; maintain them and associated parts in good condition.
- Turn face away from valve outlet when opening cylinder valve.
- Keep protective cap in place over valve except when cylinder is in use or connected for use.
- Read and follow instructions on compressed gas cylinders, associated equipment, and CGA publication P-1 listed in Safety Standards.

## 1-3. Additional Symbols For Installation, Operation, And Maintenance



### FIRE OR EXPLOSION hazard.

- Do not install or place unit on, over, or near combustible surfaces.
- Do not install unit near flammables.
- Do not overload building wiring – be sure power supply system is properly sized, rated, and protected to handle this unit.



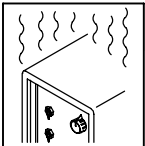
### MOVING PARTS can cause injury.

- Keep away from moving parts such as fans.
- Keep all doors, panels, covers, and guards closed and securely in place.



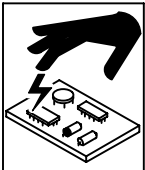
### FALLING UNIT can cause injury.

- Use lifting eye to lift unit only, NOT running gear, gas cylinders, or any other accessories.
- Use equipment of adequate capacity to lift and support unit.
- If using lift forks to move unit, be sure forks are long enough to extend beyond opposite side of unit.



### OVERUSE can cause OVERHEATING

- Allow cooling period; follow rated duty cycle.
- Reduce current or reduce duty cycle before starting to weld again.
- Do not block or filter airflow to unit.



### STATIC (ESD) can damage PC boards.

- Put on grounded wrist strap BEFORE handling boards or parts.
- Use proper static-proof bags and boxes to store, move, or ship PC boards.



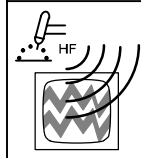
### MOVING PARTS can cause injury.

- Keep away from moving parts.
- Keep away from pinch points such as drive rolls.



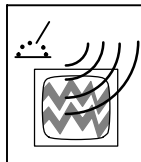
### WELDING WIRE can cause injury.

- Do not press gun trigger until instructed to do so.
- Do not point gun toward any part of the body, other people, or any metal when threading welding wire.



### H.F. RADIATION can cause interference.

- High-frequency (H.F.) can interfere with radio navigation, safety services, computers, and communications equipment.
- Have only qualified persons familiar with electronic equipment perform this installation.
- The user is responsible for having a qualified electrician promptly correct any interference problem resulting from the installation.
- If notified by the FCC about interference, stop using the equipment at once.
- Have the installation regularly checked and maintained.
- Keep high-frequency source doors and panels tightly shut, keep spark gaps at correct setting, and use grounding and shielding to minimize the possibility of interference.



### ARC WELDING can cause interference.

- Electromagnetic energy can interfere with sensitive electronic equipment such as computers and computer-driven equipment such as robots.
- Be sure all equipment in the welding area is electromagnetically compatible.
- To reduce possible interference, keep weld cables as short as possible, close together, and down low, such as on the floor.
- Locate welding operation 100 meters from any sensitive electronic equipment.
- Be sure this welding machine is installed and grounded according to this manual.
- If interference still occurs, the user must take extra measures such as moving the welding machine, using shielded cables, using line filters, or shielding the work area.

## 1-4. Principal Safety Standards

*Safety in Welding, Cutting, and Allied Processes*, ANSI Standard Z49.1, from American Welding Society, 550 N.W. LeJeune Rd, Miami FL 33126 (phone: 305-443-9353, website: [www.aws.org](http://www.aws.org)).

*Recommended Safe Practices for the Preparation for Welding and Cutting of Containers and Piping*, American Welding Society Standard AWS F4.1, from American Welding Society, 550 N.W. LeJeune Rd, Miami, FL 33126 (phone: 305-443-9353, website: [www.aws.org](http://www.aws.org)).

*National Electrical Code*, NFPA Standard 70, from National Fire Protection Association, P.O. Box 9101, 1 Battery March Park, Quincy, MA 02269-9101 (phone: 617-770-3000, website: [www.nfpa.org](http://www.nfpa.org) and [www.sparky.org](http://www.sparky.org)).

*Safe Handling of Compressed Gases in Cylinders*, CGA Pamphlet P-1, from Compressed Gas Association, 1735 Jefferson Davis Highway, Suite 1004, Arlington, VA 22202-4102 (phone: 703-412-0900, website: [www.cganet.com](http://www.cganet.com)).

*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 (phone: 800-463-6727 or in Toronto 416-747-4044, website: [www.csa-international.org](http://www.csa-international.org)).

*Practice For Occupational And Educational Eye And Face Protection*, ANSI Standard Z87.1, from American National Standards Institute, 11 West 42nd Street, New York, NY 10036-8002 (phone: 212-642-4900, website: [www.ansi.org](http://www.ansi.org)).

*Standard for Fire Prevention During Welding, Cutting, and Other Hot Work*, NFPA Standard 51B, from National Fire Protection Association, P.O. Box 9101, 1 Battery March Park, Quincy, MA 02269-9101 (phone: 617-770-3000, website: [www.nfpa.org](http://www.nfpa.org) and [www.sparky.org](http://www.sparky.org)).

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910, Subpart Q, and Part 1926, Subpart J, from U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250 (there are 10 Regional Offices--phone for Region 5, Chicago, is 312-353-2220, website: [www.osha.gov](http://www.osha.gov)).

## 1-5. EMF Information

Considerations About Welding And The Effects Of Low Frequency Electric And Magnetic Fields

Welding current, as it flows through welding cables, will cause electromagnetic fields. There has been and still is some concern about such fields. However, after examining more than 500 studies spanning 17 years of research, a special blue ribbon committee of the National Research Council concluded that: "The body of evidence, in the committee's judgment, has not demonstrated that exposure to power-frequency electric and magnetic fields is a human-health hazard." However, studies are still going forth and evidence continues to be examined. Until the final conclusions of the research are reached, you may wish to minimize your exposure to electromagnetic fields when welding or cutting.

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 cables around your body.
4. Keep welding power source and cables as far away from operator as practical.
5. Connect work clamp to workpiece as close to the weld as possible.

### About Pacemakers:

Pacemaker wearers consult your doctor first. If cleared by your doctor, then following the above procedures is recommended.



# SECTION 1 – CONSIGNES DE SÉCURITÉ – À LIRE AVANT UTILISATION

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## 1-1. Signification des symboles



Signifie « Mise en garde. Faire preuve de vigilance. » Cette procédure présente des risques identifiés par les symboles adjacents aux directives.

### ▲ Identifie un message de sécurité particulier.

☞ Signifie « NOTA » ; n'est pas relatif à la sécurité.



Ce groupe de symboles signifie « Mise en garde, Faire preuve de vigilance. » Il y a des dangers liés aux CHOCS ÉLECTRIQUES, aux PIÈCES EN MOUVEMENT et aux PIÈCES CHAUDES. Se reporter aux symboles et aux directives ci-dessous afin de connaître les mesures à prendre pour éviter tout danger.

## 1-2. Dangers relatifs au soudage à l'arc

▲ Les symboles ci-après sont utilisés tout au long du présent manuel pour attirer l'attention sur les dangers potentiels et les identifier. Lorsqu'on voit un symbole, faire preuve de vigilance et suivre les directives mentionnées afin d'éviter tout danger. Les consignes de sécurité énoncées ci-après ne font que résumer le contenu des normes de sécurité mentionnées à la section 1-4. Lire et respecter toutes ces normes.

▲ L'installation, l'utilisation, l'entretien et les réparations ne doivent être confiés qu'à des personnes qualifiées.

▲ Pendant l'utilisation de l'appareil, tenir à l'écart toute personne, en particulier les enfants.



### LES DÉCHARGES ÉLECTRIQUES peuvent être mortelles.

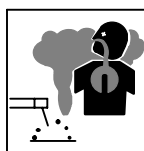
Un simple contact avec des pièces sous tension peut causer une électrocution ou des blessures graves. L'électrode et le circuit de soudage sont sous tension dès que l'appareil est en fonctionnement. Le circuit d'entrée et les circuits internes de l'appareil sont également sous tension. En soudage semi-automatique ou automatique, le fil, le dévidoir, le logement des galets d'entraînement et les pièces métalliques en contact avec le fil de soudage sont sous tension. Tout matériel mal installé ou mal mis à la terre présente un danger.

- Ne jamais toucher aux pièces électriques sous tension.
- Porter des gants et des vêtements de protection secs et exempts de trous.
- S'isoler de la pièce et de la terre au moyen de tapis ou autres dispositifs isolants suffisamment grands pour empêcher tout contact physique avec la pièce ou la terre.
- Ne pas se servir d'une source de courant alternatif dans les zones humides, les endroits confinés ou là où on risque de tomber.
- Ne se servir d'une source de courant alternatif QUE si le procédé de soudage l'exige.
- Si l'utilisation d'une source de courant alternatif s'avère nécessaire, se servir de la fonction de télécommande si l'appareil en est équipé.
- Couper l'alimentation ou arrêter le moteur avant de procéder à l'installation, à la réparation ou à l'entretien de l'appareil. Couper/étiqueter l'alimentation selon la norme OSHA 29 CFR 1910.147 (voir les normes de sécurité).
- Installer et mettre à la terre correctement l'appareil conformément à son manuel d'utilisation et aux codes nationaux, provinciaux et municipaux.
- Toujours vérifier la terre du cordon d'alimentation – Vérifier et s'assurer que le fil de terre du cordon d'alimentation est bien raccordé à la borne de terre du sectionneur ou que la fiche du cordon est raccordée à une prise correctement mise à la terre.
- Pour exécuter les branchements d'entrée, fixer d'abord le conducteur de mise à la terre adéquat et contre-vérifier les connexions.
- Vérifier fréquemment le cordon d'alimentation et s'assurer qu'il n'est ni endommagé ni dénudé ; le remplacer immédiatement s'il est endommagé – tout câble dénudé peut causer une électrocution.
- Mettre l'appareil hors tension quand on ne l'utilise pas.
- Ne pas utiliser de câbles usés, endommagés, de calibre insuffisant ou mal épissés.
- Ne pas s'enrouler les câbles autour du corps.
- Si la pièce soudée doit être mise à la terre, le faire directement avec un câble distinct.
- Ne pas toucher l'électrode quand on est en contact avec la pièce, la terre ou une électrode d'une autre machine.

- N'utiliser que du matériel en bon état. Réparer ou remplacer sur-le-champ les pièces endommagées. Entretien l'appareil conformément au présent manuel.
- Porter un harnais de sécurité quand on travaille en hauteur.
- Maintenir solidement en place tous les panneaux et capots.
- Fixer le câble de retour de façon à obtenir un bon contact métal sur métal avec la pièce à souder ou la table de travail, le plus près possible de la soudure.
- Ne pas connecter plus d'une électrode ou plus d'un câble de masse à un même terminal de sortie.

### Il subsiste un COURANT CONTINU IMPORTANT dans les convertisseurs après la suppression de l'alimentation électrique.

- Arrêter les convertisseurs, débrancher le courant électrique et décharger les condensateurs d'alimentation selon les instructions énoncées à la section Entretien avant de toucher les pièces.



### LES FUMÉES ET LES GAZ peuvent être dangereux.

Le soudage génère des fumées et des gaz dont l'inhalation peut être dangereuse pour la santé.

- Se tenir à distance des fumées et ne pas les inhaler.
- À l'intérieur, ventiler la zone et/ou utiliser un dispositif d'aspiration au niveau de l'arc pour l'évacuation des fumées et des gaz de soudage.
- Si la ventilation est insuffisante, utiliser un respirateur à adduction d'air agréé.
- Lire les fiches techniques de santé-sécurité (FTSS) et les instructions du fabricant concernant les métaux, les consommables, les revêtements, les nettoyeurs et les dégraissants.
- Ne travailler dans un espace clos que s'il est bien ventilé ou porter un respirateur à adduction d'air. Demander toujours à un surveillant dûment formé de se tenir à proximité. Des fumées et des gaz de soudage peuvent se substituer à l'air, abaisser la teneur en oxygène et causer des lésions ou des accidents mortels. S'assurer que l'air est respirable.
- Ne pas souder à proximité d'opérations de dégraissage, de nettoyage ou de pulvérisation. La chaleur et les rayons de l'arc peuvent réagir en présence de vapeurs et former des gaz hautement toxiques et irritants.
- Ne pas souder de métaux munis d'un revêtement, tels que la tôle d'acier galvanisée, plombée ou cadmiée, à moins que le revêtement n'ait été enlevé dans la zone de soudage, que l'endroit soit bien ventilé, et si nécessaire, porter un respirateur à adduction d'air. Les revêtements et tous les métaux renfermant ces éléments peuvent dégager des fumées toxiques lorsqu'on les soude.



### LES RAYONS DE L'ARC peuvent causer des brûlures oculaires et cutanées.

Le rayonnement de l'arc génère des rayons visibles et invisibles intenses (ultraviolets et infrarouges) susceptibles de causer des brûlures oculaires et cutanées. Des étincelles sont projetées pendant le soudage.

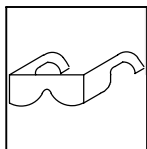
- Porter un masque de soudage muni d'un filtre de la nuance adéquate pour se protéger le visage et les yeux pendant le soudage ou pour regarder (voir les normes de sécurité ANSI Z49.1 et Z87.1).
- Porter des lunettes de sécurité à écrans latéraux sous le masque.
- Utiliser des écrans ou des barrières pour protéger les tiers de l'éclat éblouissant ou aveuglant de l'arc ; leur demander de ne pas regarder l'arc.
- Porter des vêtements de protection en matière durable et ignifuge (cuir ou laine) et des chaussures de sécurité.



### LE SOUDAGE peut causer un incendie ou une explosion.

Le soudage effectué sur des récipients fermés tels que des réservoirs, des fûts ou des conduites peut causer leur éclatement. Des étincelles peuvent être projetées de l'arc de soudure. La projection d'étincelles, les pièces chaudes et les équipements chauds peuvent causer des incendies et des brûlures. Le contact accidentel de l'électrode avec tout objet métallique peut causer des étincelles, une explosion, un surchauffement ou un incendie. Avant de commencer le soudage, vérifier et s'assurer que l'endroit ne présente pas de danger.

- Se protéger et protéger les tiers de la projection d'étincelles et de métal chaud.
- Ne pas souder à un endroit où des étincelles peuvent tomber sur des substances inflammables.
- Placer toutes les substances inflammables à une distance de 10,7 m de l'arc de soudage. En cas d'impossibilité, les recouvrir soigneusement avec des protections agréées.
- Des étincelles et des matières en fusion peuvent facilement passer même par des fissures et des ouvertures de petites dimensions.
- Surveiller tout déclenchement d'incendie et tenir un extincteur à proximité.
- Le soudage effectué sur un plafond, un plancher, une paroi ou une cloison peut déclencher un incendie de l'autre côté.
- Ne pas souder des récipients fermés tels que des réservoirs, des fûts ou des conduites, à moins qu'ils n'aient été préparés conformément à l'AWS F4.1 (voir les normes de sécurité).
- Brancher le câble sur la pièce la plus près possible de la zone de soudage pour éviter que le courant ne circule sur une longue distance, par des chemins inconnus, et ne cause des risques d'électrocution et d'incendie.
- Ne pas utiliser le poste de soudage pour dégeler des conduites gelées.
- En cas de non utilisation, enlever la baguette d'électrode du porte-électrode ou couper le fil au raz du tube-contact.
- Porter des vêtements de protection exempts d'huile tels que des gants en cuir, une chemise en tissu épais, des pantalons sans revers, des chaussures montantes et un masque.
- Avant de souder, retirer tout produit combustible de ses poches, tel qu'un briquet au butane ou des allumettes.



### LES PARTICULES PROJETÉES peuvent blesser les yeux.

- Le soudage, le burinage, le passage de la pièce à la brosse métallique et le meulage provoquent l'émission d'étincelles et de particules métalliques. Pendant leur refroidissement, les soudures risquent de projeter du laitier.
  - Porter des lunettes de sécurité à écrans latéraux agréés, même sous le masque de soudage.



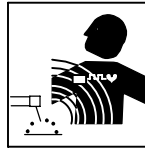
### LES ACCUMULATIONS DE GAZ peuvent causer des blessures ou même la mort.

- Couper l'alimentation en gaz protecteur en cas de non utilisation.
- Veiller toujours à bien ventiler les espaces confinés ou porter un respirateur à adduction d'air agréé.



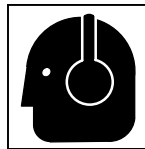
### LES PIÈCES CHAUDES peuvent causer des brûlures graves.

- Ne pas toucher les pièces chaudes à main nue.
- Prévoir une période de refroidissement avant d'utiliser le pistolet ou la torche.



### LES CHAMPS MAGNÉTIQUES peuvent perturber le fonctionnement des stimulateurs cardiaques.

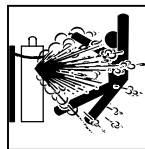
- Les personnes qui portent un stimulateur cardiaque doivent se tenir à distance.
- Ils doivent consulter leur médecin avant de s'approcher d'un lieu où on exécute des opérations de soudage à l'arc, de gougeage ou de soudage par points.



### LE BRUIT peut affecter l'ouïe.

Le bruit de certains processus et équipements peut affecter l'ouïe.

- Porter des protecteurs d'oreille agréés si le niveau sonore est trop élevé.



### Les BOUTEILLES endommagées peuvent exploser.

Les bouteilles de gaz protecteur contiennent du gaz sous haute pression. Toute bouteille endommagée peut exploser. Comme les bouteilles de gaz font normalement partie du procédé de soudage, les manipuler avec précaution.

- Protéger les bouteilles de gaz comprimé de la chaleur excessive, des chocs mécaniques, du laitier, des flammes nues, des étincelles et des arcs.
- Placer les bouteilles debout en les fixant dans un support stationnaire ou dans un porte-bouteilles pour les empêcher de tomber ou de se renverser.
- Tenir les bouteilles éloignées des circuits de soudage ou autres circuits électriques.
- Ne jamais poser une torche de soudage sur une bouteille de gaz.
- Ne jamais mettre une électrode de soudage en contact avec une bouteille de gaz.
- Ne jamais souder une bouteille contenant du gaz sous pression – elle risquerait d'exploser.
- N'utiliser que les bouteilles de gaz protecteur, régulateurs, tuyaux et raccords adéquats pour l'application envisagée ; les maintenir en bon état, ainsi que les pièces connexes.
- Détourner la tête lorsqu'on ouvre la soupape d'une bouteille.
- Laisser le capuchon protecteur sur la soupape, sauf en cas d'utilisation ou de branchement de la bouteille
- Lire et suivre les instructions concernant les bouteilles de gaz comprimé, les équipements associés et les publications P-1 de la CGA, mentionnées dans les normes de sécurité.

### 1-3. Autres symboles relatifs à l'installation, au fonctionnement et à l'entretien de l'appareil.



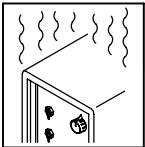
#### Risque D'INCENDIE OU D'EXPLOSION

- Ne pas placer l'appareil sur une surface inflammable, ni au-dessus ou à proximité d'elle.
- Ne pas installer l'appareil à proximité de produits inflammables.
- Ne pas surcharger l'installation électrique – s'assurer que l'alimentation est correctement dimensionnée et protégée avant de mettre l'appareil en service.



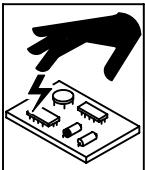
#### LA CHUTE DE L'APPAREIL peut blesser.

- N'utiliser que l'anneau de levage pour lever l'appareil. NE PAS utiliser le chariot, les bouteilles de gaz ou tout autre accessoire.
- Utiliser un engin de capacité adéquate pour lever l'appareil.
- Si on utilise un chariot élévateur pour déplacer l'unité, s'assurer que les fourches sont suffisamment longues pour dépasser du côté opposé de l'appareil.



#### L'EMPLOI EXCESSIF peut FAIRE SURCHAUFFER L'ÉQUIPEMENT.

- Prévoir une période de refroidissement ; respecter le cycle opératoire nominal.
- Réduire le courant ou le cycle opératoire avant de reprendre le soudage.
- Ne pas obstruer les orifices ou filtrer l'alimentation en air du poste.



#### LES CHARGES ÉLECTROSTATIQUES peuvent endommager les circuits imprimés.

- Mettre un bracelet antistatique AVANT de manipuler des cartes ou des pièces.
- Utiliser des pochettes et des boîtes antistatiques pour stocker, déplacer ou expédier des cartes de circuits imprimés.



#### LES PIÈCES MOBILES peuvent causer des blessures.

- Se tenir à l'écart des pièces mobiles.
- Se tenir à l'écart des points de coincement tels que les dévidoirs.



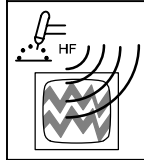
#### LES FILS DE SOUDAGE peuvent causer des blessures.

- Ne pas appuyer sur la gâchette avant d'en avoir reçu l'instruction.
- Ne pas diriger le pistolet vers soi, vers d'autres personnes ou vers toute pièce mécanique en engageant le fil de soudage.



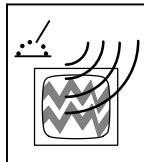
#### LES ORGANES MOBILES peuvent causer des blessures.

- Se tenir à l'écart des organes mobiles comme les ventilateurs.
- Maintenir fermés et bien fixés les portes, panneaux, recouvrements et dispositifs de protection.



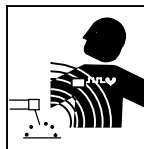
#### LE RAYONNEMENT HAUTE FRÉQUENCE (H. F.) risque de causer des interférences.

- Le rayonnement haute fréquence peut causer des interférences avec les équipements de radio-navigation et de communication, les services de sécurité et les ordinateurs.
- Ne demander qu'à des personnes qualifiées familiarisées avec les équipements électroniques de faire fonctionner l'installation.
- L'utilisateur est tenu de faire corriger rapidement par un électricien qualifié les interférences causées par l'installation.
- Si la Federal Communications Commission signale des interférences, arrêter immédiatement l'appareil.
- Faire régulièrement contrôler et entretenir l'installation.
- Maintenir soigneusement fermés les panneaux et les portes des sources de haute fréquence, maintenir le jeu d'éclatement au réglage adéquat et utiliser une terre et un blindage pour réduire les interférences éventuelles.



#### LE SOUDAGE À L'ARC peut causer des interférences.

- L'énergie électromagnétique peut causer des interférences avec l'équipement électronique sensible tel que les ordinateurs et l'équipement commandé par ordinateur tel que les robots.
- Veiller à ce que tout l'équipement de la zone de soudage soit compatible au point de vue électromagnétique.
- Pour réduire la possibilité d'interférence, maintenir les câbles de soudage aussi courts que possible, les grouper, et les poser aussi bas que possible (par ex. : à terre).
- Veiller à souder à une distance de 100 mètres de tout équipement électronique sensible.
- Veiller à ce que le poste de soudage soit posé et mis à la terre conformément au présent manuel.
- En cas d'interférences après exécution des directives précédentes, il incombe à l'utilisateur de prendre des mesures supplémentaires telles que le déplacement du poste, l'utilisation de câbles blindés, l'utilisation de filtres de ligne ou la pose de protecteurs dans la zone de travail.



#### LES CHAMPS MAGNÉTIQUES peuvent affecter les stimulateurs cardiaques.

- Porteurs de stimulateur cardiaque, restez à distance.
- Les porteurs d'un stimulateur cardiaque doivent d'abord consulter leur médecin avant de s'approcher des opérations de soudage à l'arc, de gougeage ou de soudage par points.

## 1-4. Principales normes de sécurité

Safety in Welding, Cutting, and Allied Processes, norme ANSI Z49.1, de l'American Welding Society, 550 N.W. LeJeune Rd, Miami FL 33126 (téléphone : (305) 443-9353, site Web : [www.aws.org](http://www.aws.org)).

Recommended Safe Practices for the Preparation for Welding and Cutting of Containers and Piping, norme American Welding Society AWS F4.1, de l'American Welding Society, 550 N.W. LeJeune Rd, Miami, FL 33126 (téléphone : (305) 443-9353, site Web : [www.aws.org](http://www.aws.org)).

National Electrical Code, norme NFPA 70, de la National Fire Protection Association, P.O. Box 9101, 1 Battery March Park, Quincy, MA 02269-9101 (téléphone : (617) 770-3000, sites Web : [www.nfpa.org](http://www.nfpa.org) et [www.sparky.org](http://www.sparky.org)).

Safe Handling of Compressed Gases in Cylinders, brochure CGA P-1, de la Compressed Gas Association, 1735 Jefferson Davis Highway, Suite 1004, Arlington, VA 22202-4102 (téléphone : (703) 412-0900, site Web : [www.cganet.com](http://www.cganet.com)).

Code for Safety in Welding and Cutting, norme CSA W117.2, de la Canadian Standards Association, Standards Sales, 178 boulevard

Rexdale, Rexdale (Ontario) Canada M9W 1R3 (téléphone : (800) 463-6727 ou à Toronto : (416) 747-4044, site Web : [www.csa-international.org](http://www.csa-international.org)).

Practice For Occupational And Educational Eye And Face Protection, norme ANSI Z87.1, de l'American National Standards Institute, 11 West 42nd Street, New York, NY 10036-8002 (téléphone : (212) 642-4900, site Web : [www.ansi.org](http://www.ansi.org)).

Standard for Fire Prevention During Welding, Cutting, and Other Hot Work, norme NFPA 51B, de la National Fire Protection Association, P.O. Box 9101, 1 Battery March Park, Quincy, MA 02269-9101 (téléphone : (617) 770-3000, site Web : [www.nfpa.org](http://www.nfpa.org) et [www.sparky.org](http://www.sparky.org)).

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910, Subpart Q, and Part 1926, Subpart J, de l'U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250 (il y a 10 bureaux régionaux - Téléphone pour la Région 5, Chicago : (312) 353-2220, site Web : [www.osha.gov](http://www.osha.gov)).

## 1-5. Information sur les champs électromagnétiques

Données sur le soudage électrique et les effets des champs magnétiques basse fréquence sur l'organisme

En parcourant les câbles de soudage, le courant crée des champs électromagnétiques. Les effets potentiels de tels champs restent préoccupants. Cependant, après avoir examiné plus de 500 études qui ont été faites pendant une période de recherche de 17 ans, un comité de spécialistes du National Research Council a conclu : « L'accumulation de preuves n'a pas démontré que l'exposition aux champs magnétiques et aux champs électriques à haute fréquence constitue un risque pour la santé humaine ». Toutefois, les études et l'examen des preuves se poursuivent. En attendant les conclusions finales de la recherche, il serait souhaitable de réduire l'exposition aux champs électromagnétiques pendant le soudage ou le coupage.

Afin de réduire les champs électromagnétiques en milieu de travail, respecter les consignes suivantes :

1. Garder les câbles ensemble en les torsadant ou en les fixant avec du ruban adhésif.
2. Mettre tous les câbles du côté opposé à l'opérateur.
3. Ne pas s'enrouler les câbles autour du corps.
4. Garder le poste de soudage et les câbles le plus loin possible de soi.
5. Placer la pince de masse le plus près possible de la zone de soudage.

### Consignes relatives aux stimulateurs cardiaques :

Les personnes qui portent un stimulateur cardiaque doivent avant tout consulter leur médecin. Si ce dernier les déclare aptes, il leur est recommandé de respecter les consignes ci-dessus.

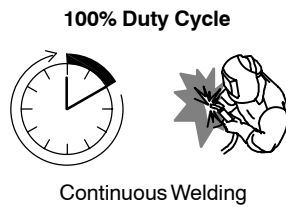
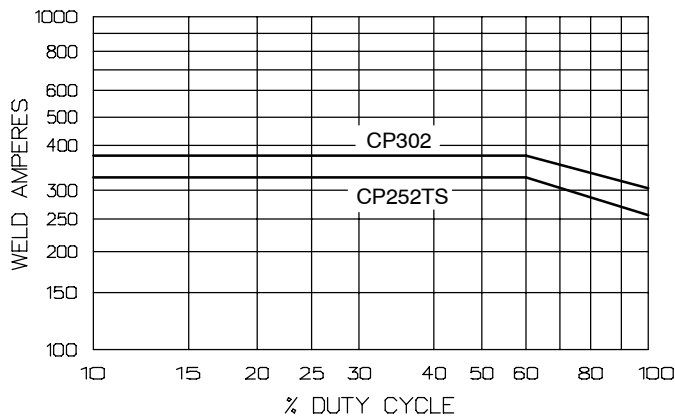
# SECTION 2 – INSTALLATION

## 2-1. Specifications

| Model   | Rated Welding Output                 | Open-Circuit Voltage Range DC | Amperes Input at Rated Load Output, 50 or 60 Hz, Three-Phase |              |            |            |            |              |              |              |              | KVA           | KW            |
|---------|--------------------------------------|-------------------------------|--|--------------|------------|------------|------------|--------------|--------------|--------------|--------------|---------------|---------------|
|         |                                      |                               | 200 V  | 220 V        | 230 V      | 380 V      | 400 V      | 440 V        | 460 V        | 520 V        | 575 V        |               |               |
| 250 Amp | 250 A @ 35 Volts DC, 100% Duty Cycle | 14-44                         | 34.5<br>1.7*   | --           | 30<br>1.4* | --         | --         | --           | 15<br>0.7*   | --           | --           | 11.9<br>0.57* | 11.2<br>0.42* |
| 300 Amp | 300 A @ 32 Volts DC, 100% Duty Cycle | 14-44                         | 38<br>3*   | 34.5<br>2.8* | 33<br>2.7* | 20<br>1.9* | 19<br>1.6* | 17.3<br>1.5* | 16.5<br>1.4* | 14.6<br>1.1* | 13.0<br>0.7* | 13.1<br>0.97* | 12.3<br>0.68* |

\*While idling

## 2-2. Duty Cycle And Overheating

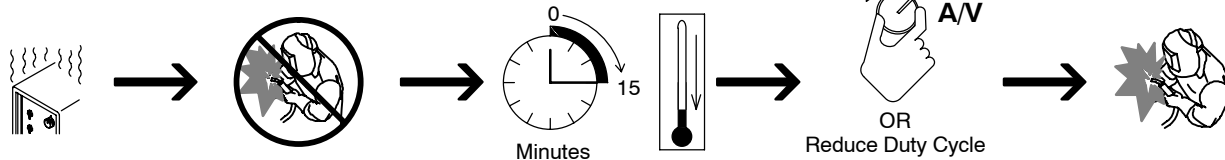


Duty Cycle is percentage of 10 minutes that unit can weld at rated load without overheating.

If unit overheats, thermostat(s) opens, output stops, and cooling fan runs. Wait fifteen minutes for unit to cool. Reduce amperage or duty cycle before welding.

**▲ Exceeding duty cycle can damage unit and void warranty.**

### Overheating

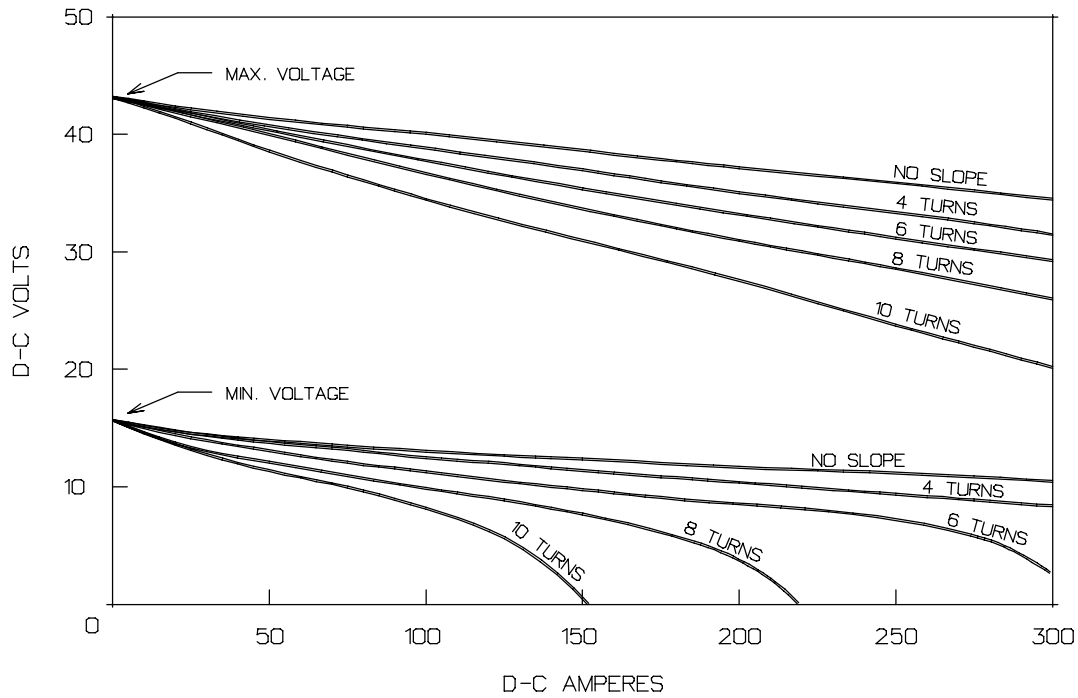


duty1 4/95 / Ref. SA-177 714-B

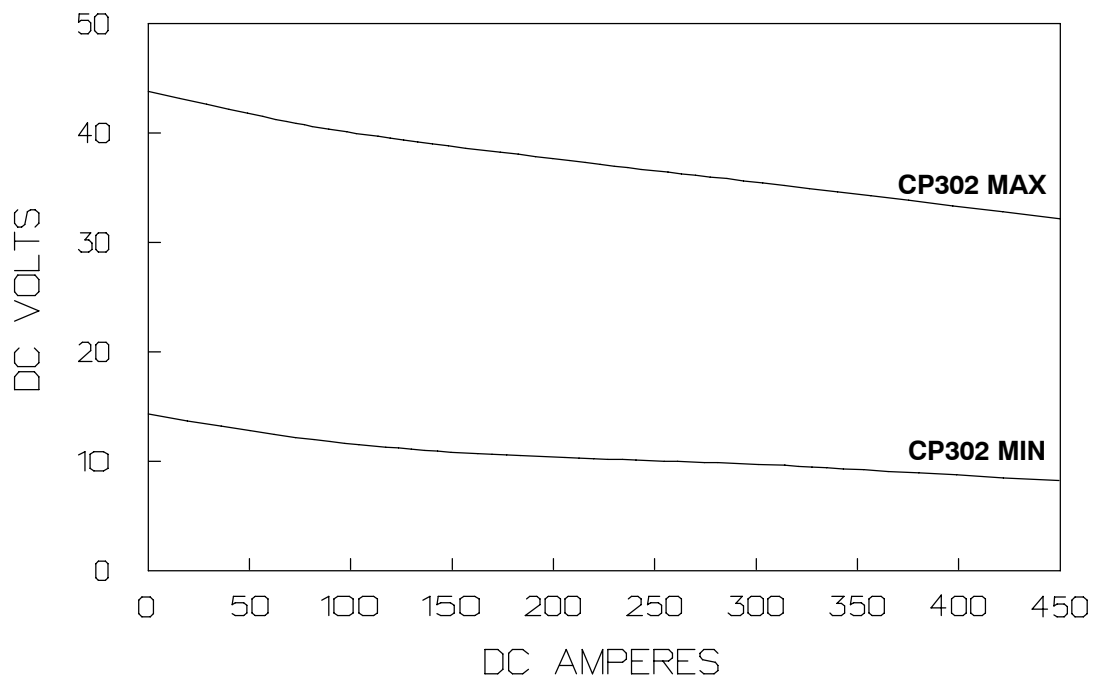
## 2-3. Volt-Ampere Curves

Volt-ampere curves show minimum and maximum voltage and amperage output capabilities of unit. Curves of other settings fall between curves shown.

### A. 250 Ampere Models

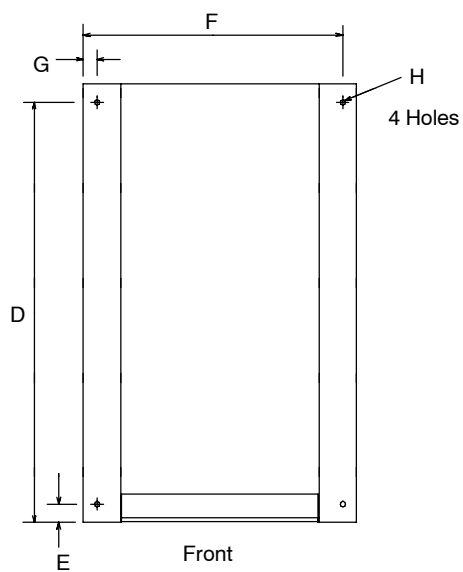
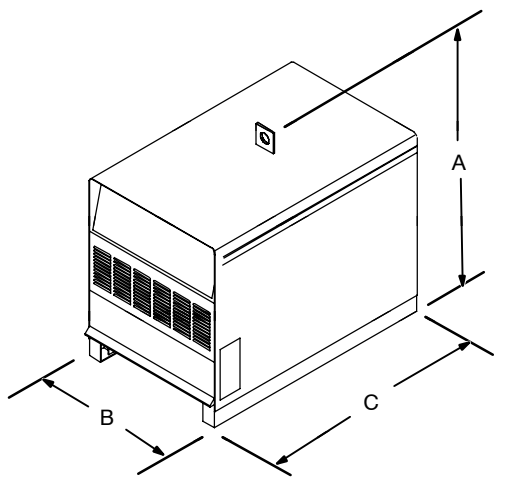


### B. 300 Ampere Models



va\_curve1 4/95 - SA-180 902 / SA-180 901-B

## 2-4. Dimensions And Weights



800 453-A / 801 530


### Dimensions

|   |  |
|---|--|
| A | 30 in (762 mm) Including lift eye      |
| B | 23 in (584 mm)                         |
| C | 31 in (787 mm) Including strain relief |
| D | 27-1/2 in (699 mm)                     |
| E | 3/4 in (19 mm)                         |
| F | 21-1/8 in (537 mm)                     |
| G | 1-1/8 in (29 mm)                       |
| H | 7/16 in (11 mm) Dia                    |

### Weight

320 lb (145 kg)

## 2-5. Selecting A Location

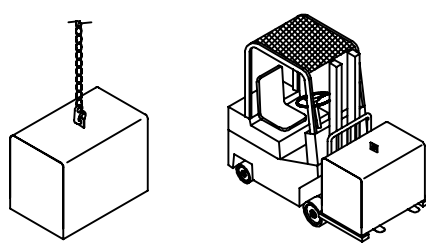


1 Rating Label  
Use rating label to determine input power needs. Label located under front access door.

2 Line Disconnect Device  
Locate unit near correct input power supply.

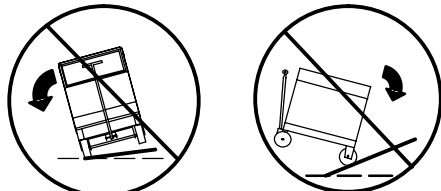
▲ **Special installation may be required where gasoline or volatile liquids are present – see NEC Article 511 or CEC Section 20.**

**Movement**



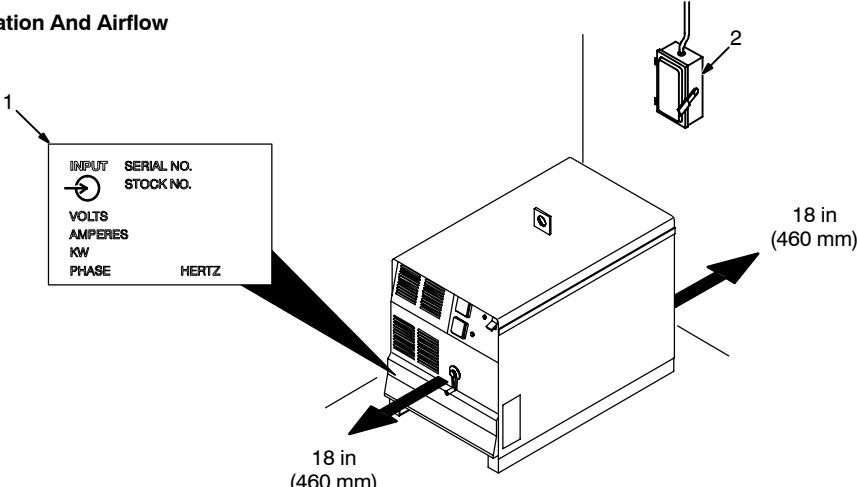
**Tipping**

▲ Do not move or operate unit where it could tip.



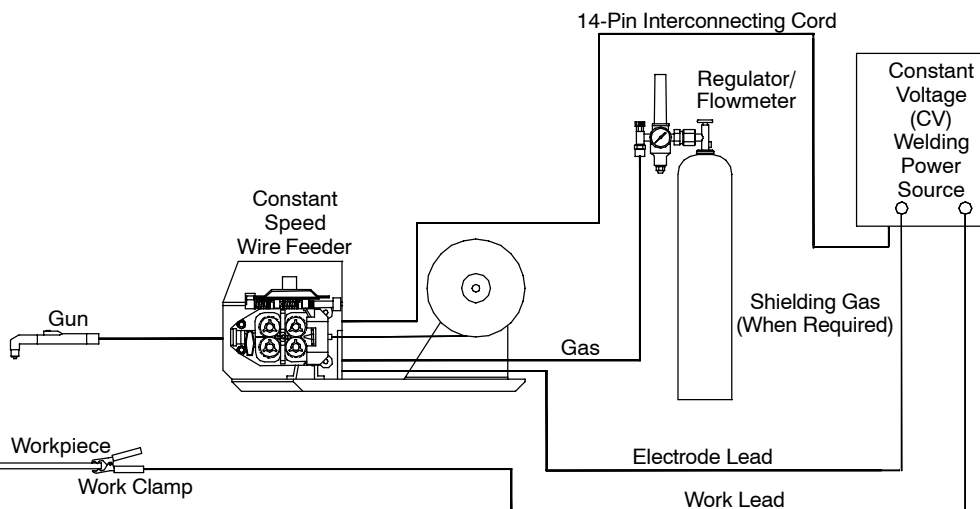
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**Location And Airflow**



Ref. ST-801 378-B

## 2-6. Typical MIG Process Connections Using A Constant Speed Wire Feeder



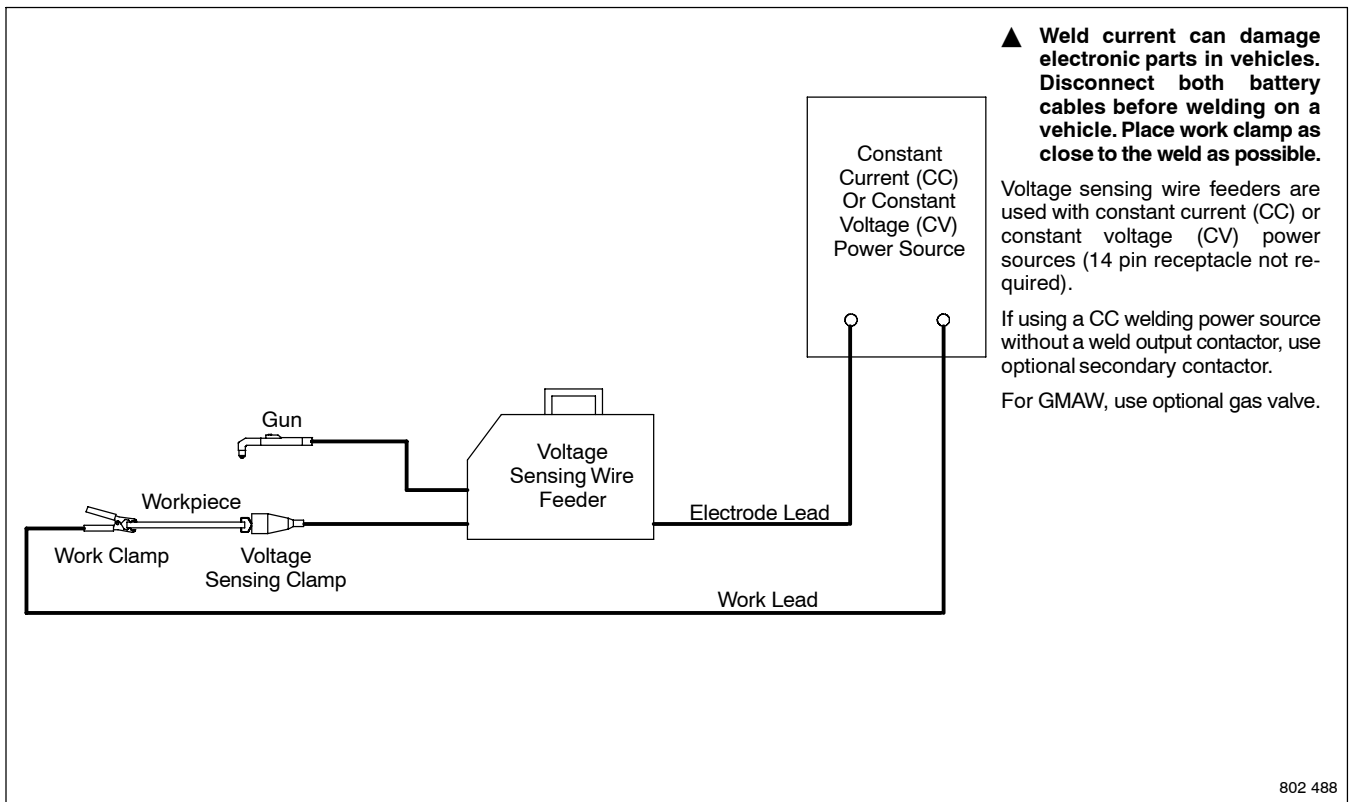
▲ **Weld current can damage electronic parts in vehicles. Disconnect both battery cables before welding on a vehicle. Place work clamp as close to the weld as possible.**

Constant speed wire feeders are used with constant voltage (CV) power sources having a 14-pin receptacle.

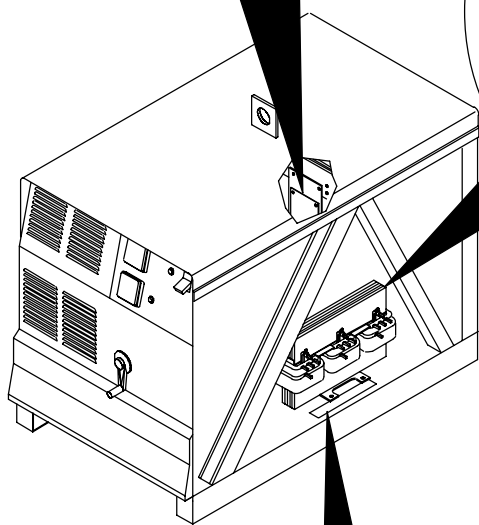
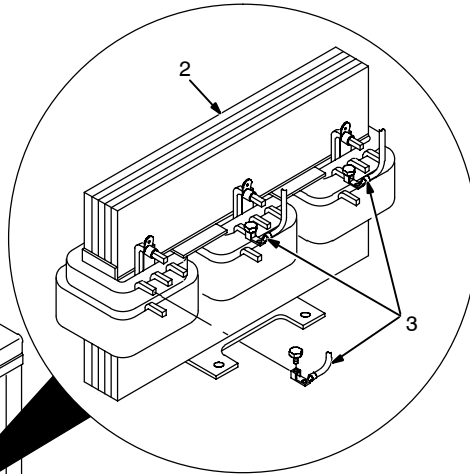
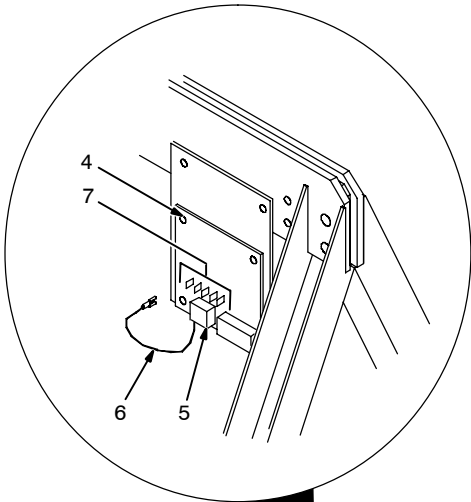
*For flux cored welding (FCAW), contact welding wire manufacture for polarity recommendations.*



## 2-7. Typical MIG Process Connections Using A Voltage-Sensing Wire Feeder



## 2-8. Slope Selection (250 Ampere Model)



- ▲ **Disconnect and lockout/tag-out input power before removing side panel.**

Lockout/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.

- 1 Slope Connection Label
- 2 Tapped Reactor AC-Z And Slope Coils

Tapped reactor AC-Z is factory connected to slope tap 8 which is suitable for most GMAW applications.

AC-Z controls the inductance applied to the weld current. To increase inductance and wet out the weld puddle, connect to a higher tap number. To stiffen the weld puddle, connect to a lower tap number.

- 3 Leads 70, 71 and 72 With Pressure Connectors

Slide pressure connectors onto the same tap of each coil, and secure them.

- ▲ **An unbalanced secondary current can damage the main transformer and cause erratic weld conditions. Be sure leads 70, 71 and 72 are connected to the same numbered slope turn tap on each coil. See slope connection label .**

- 4 Firing Board PC1
- 5 Receptacle RC2
- 6 Lead 36
- 7 Receptacles RC3 Through RC6

Connect lead 36 from RC2 to correct receptacle RC4, RC5, RC6 or RC7 to match tap slope connections made in Section A as follows:

RC3 – 300A (Used With 300A Models Only)

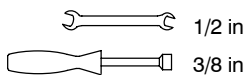
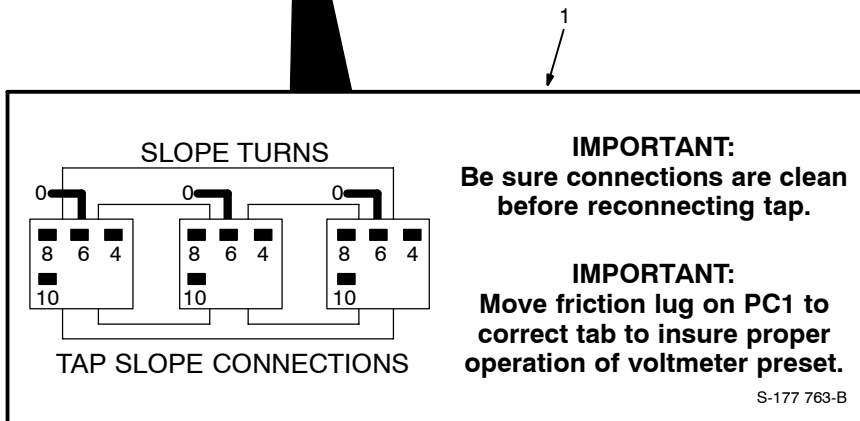
RC4 for 4 turns

RC5 for 6 turns

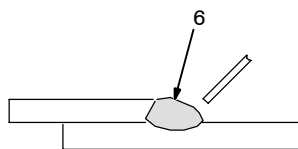
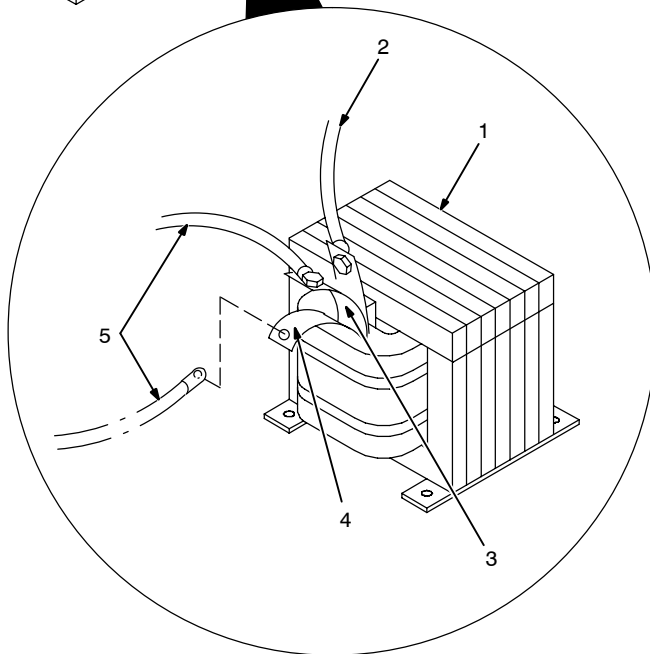
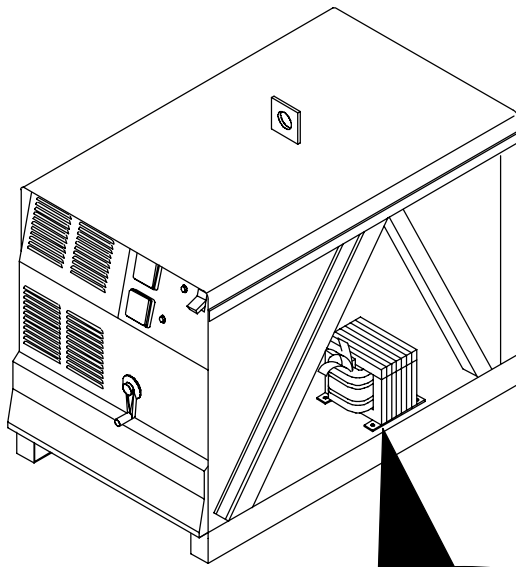
RC6 for 8 turns

RC7 for 10 turns.

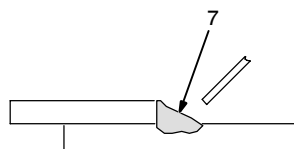
Reinstall right side panel.



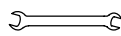
## 2-9. Inductance Selection (300 Ampere Models)



Weld Bead Using The Tap Stabilizer Connection With 17 Volts, 100 Amps



Weld Bead Using The End Stabilizer Connection With 17 Volts, 100 Amps

 3/8, 7/16 in

 3/8 in

▲ **Disconnect and lockout/tag-out input power before removing side panel.**

Lockout/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.

### 1 Stabilizer Z

Tapped stabilizer Z is factory connected to the stabilizer tap which suits most GMAW applications.

Stabilizer Z controls the inductance applied to the weld current. To increase inductance and wet out the weld puddle, connect to stabilizer Z ending.

To change inductance proceed as follows:

- 2 Lead 25
- 3 Stabilizer Z Tap
- 4 Stabilizer Z Ending
- 5 Lead 26

To increase inductance, connect lead 26 to stabilizer ending and secure.

Reinstall side panel.

### 6 Typical Weld Bead Using The Tap Stabilizer Connection

Use the tap Stabilizer connection to obtain arc type and weld bead suitable for some mild steel applications.

### 7 Typical Weld Bead Using The End High Stabilizer Connection

Use the end Stabilizer connection to reduce weld bead crowning, and spread the weld puddle.

## 2-10. Weld Output Terminals And Selecting Cable Sizes



### ▲ ARC WELDING can cause Electromagnetic Interference.

To reduce possible interference, keep weld cables as short as possible, close together, and down low, such as on the floor. Locate welding operation 100 meters from any sensitive electronic equipment. Be sure this welding machine is installed and grounded according to this manual. If interference still occurs, the user must take extra measures such as moving the welding machine, using shielded cables, using line filters, or shielding the work area.

| <br>Connecting to weld output terminals | Welding Amperes | Total Cable (Copper) Length In Weld Circuit Not Exceeding |                      |                      |               |               |               |                |                |
|---|-----------------|---|----------------------|----------------------|---------------|---------------|---------------|----------------|----------------|
|   |                 | 100 ft (30 m) Or Less                                     |                      | 150 ft (45 m)        | 200 ft (60 m) | 250 ft (70 m) | 300 ft (90 m) | 350 ft (105 m) | 400 ft (120 m) |
|   |                 | 10 – 60% Duty Cycle                                       | 60 – 100% Duty Cycle | 10 – 100% Duty Cycle |               |               |               |                |                |
|   | 100             | 4   | 4                    | 4                    | 3             | 2             | 1             | 1/0            | 1/0            |
|   | 150             | 3   | 3                    | 2                    | 1             | 1/0           | 2/0           | 3/0            | 3/0            |
|   | 200             | 3   | 2                    | 1                    | 1/0           | 2/0           | 3/0           | 4/0            | 4/0            |
|   | 250             | 2   | 1                    | 1/0                  | 2/0           | 3/0           | 4/0           | 2-2/0          | 2-2/0          |
|   | 300             | 1   | 1/0                  | 2/0                  | 3/0           | 4/0           | 2-2/0         | 2-3/0          | 2-3/0          |
|   | 350             | 1/0   | 2/0                  | 3/0                  | 4/0           | 2-2/0         | 2-3/0         | 2-3/0          | 2-4/0          |
|   | 400             | 1/0   | 2/0                  | 3/0                  | 4/0           | 2-2/0         | 2-3/0         | 2-4/0          | 2-4/0          |
|   | 500             | 2/0   | 3/0                  | 4/0                  | 2-2/0         | 2-3/0         | 2-4/0         | 3-3/0          | 3-3/0          |

\*Weld cable size (AWG) is based on either a 4 volts or less drop or a current density of at least 300 circular mils per ampere. Contact your distributor for the mm<sup>2</sup> equivalent weld cable sizes.



S-0007-E

## 2-11. Remote 14 Receptacle Information

| <br> | REMOTE 14 | Socket*                      | Socket Information   |
|------|-----------|------------------------------|--|
|      |           | OUTPUT (CONTACTOR)<br>FEEDER | A  |
| B    |           |                              | Contact closure to A completes 24 volts ac contactor control circuit.  |
| I    |           |                              | 115 volts, 15 amperes, 60 Hz ac. Protected by circuit breaker CB1.     |
| J    |           |                              | Contact closure to I completes 115 volts ac contactor control circuit. |
| G    |           |                              | Circuit common for 24 and 115 volts ac circuits.                       |
| K    |           |                              | Chassis common.  |

\*The remaining sockets are not used.

## 2-12. Connecting To 115 Volts AC Duplex Receptacle

1 115 V 15 A AC Receptacle RC9  
Power is shared between RC9 and remote 14 receptacle RC8.

2 Circuit Breaker CB1  
CB1 protects 115 volts ac portion of RC8 and RC9 from overload.

3 Circuit Breaker CB2  
CB2 protects 24 volts ac portion of RC8 from overload.

Press button to reset breaker.

Ref. ST-801 380-B

## 2-13. Electrical Service Guide

| 60 Hertz Models   | 250 Amp Model                  |                                      |          | 300 Amp Model |          |          |          |    |
|---|--------------------------------|--------------------------------------|----------|---------------|----------|----------|----------|----|
| <b>Input Voltage</b>  | 200                            | 230                                  | 460      | 200           | 230      | 460      | 575      |    |
| <b>Input Amperes At Rated Output</b>                                | 34.5                           | 30                                   | 15       | 38            | 33       | 16.5     | 13       |    |
| <b>Max Recommended Standard Fuse Rating In Amperes <sup>1</sup></b> | <b>Time-Delay <sup>2</sup></b> | 40                                   | 35       | 15            | 45       | 40       | 20       | 15 |
|   |                                | <b>Normal Operating <sup>3</sup></b> | 50       | 45            | 20       | 60       | 50       | 25 |
| <b>Min Input Conductor Size In AWG/Kcmil</b>                        | 8                              | 10                                   | 14       | 8             | 8        | 12       | 14       |    |
| <b>Max Recommended Input Conductor Length In Feet (Meters)</b>      | 116 (35)                       | 100 (31)                             | 157 (48) | 105 (32)      | 139 (42) | 221 (67) | 223 (68) |    |
| <b>Min Grounding Conductor Size In AWG/Kcmil</b>                    | 10                             | 10                                   | 14       | 10            | 10       | 12       | 14       |    |

Reference: 1999 National Electrical Code (NEC)

1 Consult factory for circuit breaker applications.

2 "Time-Delay" fuses are UL class "RK5".

3 "Normal Operating" (general purpose - no intentional delay) fuses are UL class "K5" (up to and including 60 amp), and UL class "H" (65 amp and above).

| 50 Hertz Models   | 300 Amp Model                  |                                      |          |          |          |    |
|---|--------------------------------|--------------------------------------|----------|----------|----------|----|
| <b>Input Voltage</b>  | 220                            | 380                                  | 400      | 440      | 520      |    |
| <b>Input Amperes At Rated Output</b>                                | 34.5                           | 20                                   | 19       | 17.3     | 14.6     |    |
| <b>Max Recommended Standard Fuse Rating In Amperes <sup>1</sup></b> | <b>Time-Delay <sup>2</sup></b> | 40                                   | 25       | 20       | 20       | 15 |
|   |                                | <b>Normal Operating <sup>3</sup></b> | 50       | 30       | 30       | 25 |
| <b>Min Input Conductor Size In AWG/Kcmil</b>                        | 8                              | 12                                   | 12       | 12       | 14       |    |
| <b>Max Recommended Input Conductor Length In Feet (Meters)</b>      | 127 (39)                       | 151 (46)                             | 167 (51) | 202 (62) | 183 (56) |    |
| <b>Min Grounding Conductor Size In AWG/Kcmil</b>                    | 10                             | 12                                   | 12       | 12       | 14       |    |

Reference: 1999 National Electrical Code (NEC)

1 Consult factory for circuit breaker applications.

2 "Time-Delay" fuses are UL class "RK5".

3 "Normal Operating" (general purpose - no intentional delay) fuses are UL class "K5" (up to and including 60 amp), and UL class "H" (65 amp and above).

## 2-14. Placing Jumper Links



Check input voltage available at site.

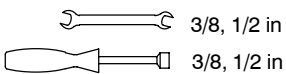
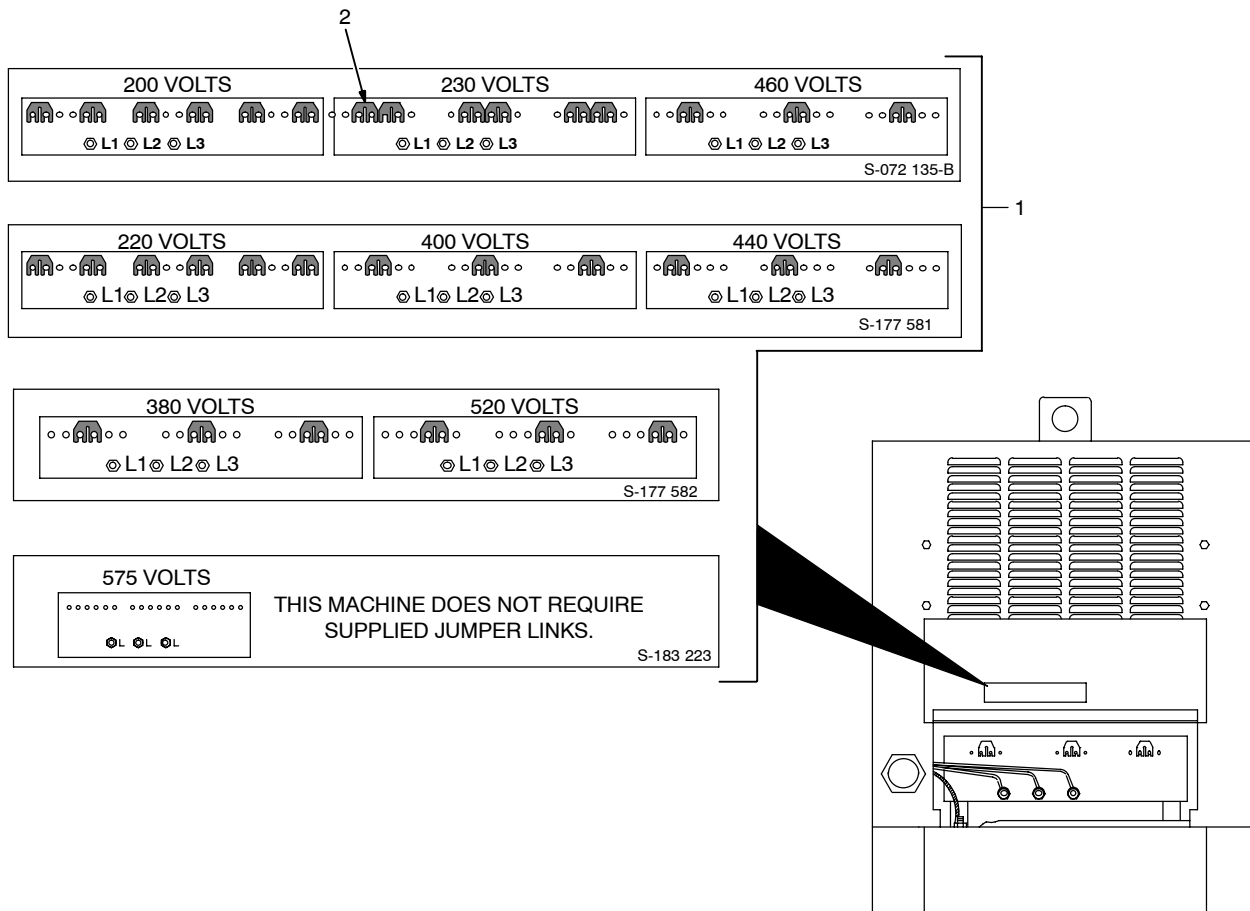
1 Jumper Link Label

Check label – only one is on unit.

2 Jumper Link

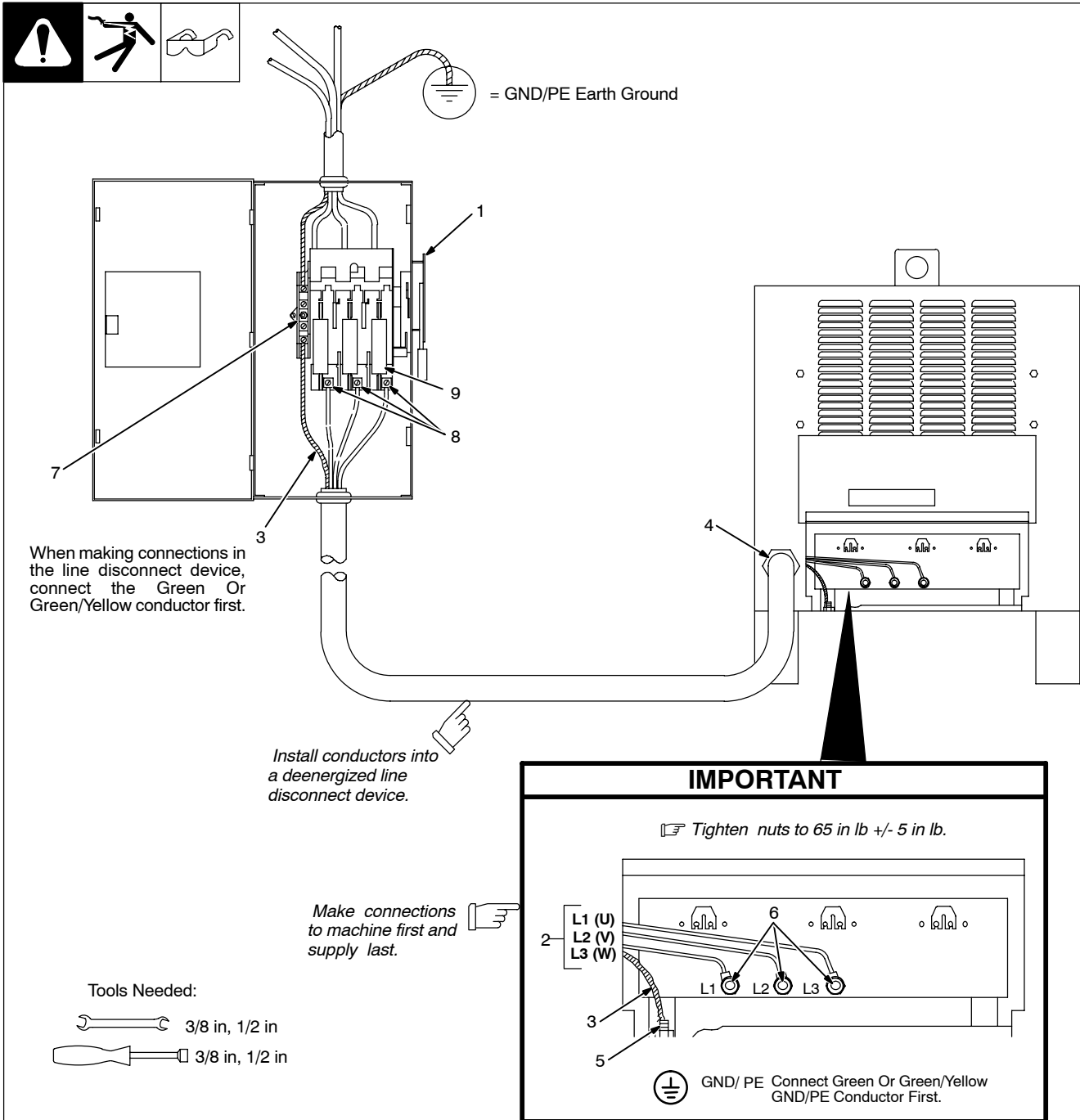
Move jumper links to match input voltage, and label on unit.

Tighten jumper link nuts to 25 in lb +/- 5 in lb.



Ref. ST-801 382

## 2-15. Connecting Input Power

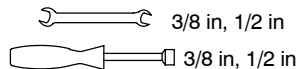


When making connections in the line disconnect device, connect the Green Or Green/Yellow conductor first.

Install conductors into a deenergized line disconnect device.

Make connections to machine first and supply last.

Tools Needed:



▲ **Disconnect and lockout/tagout input power before connecting input conductors from unit.**

▲ **Have only qualified persons make this installation.**

See rating label on unit and check input voltage available at site.

- 1 Line Disconnect Device
- 2 Input Conductors
- 3 Grounding Conductor

Select size and length using Section 2-13. Conductors must comply with national, state, and local electrical codes. Use lugs of proper amperage capacity and correct hole size.

- 4 Strain Relief  
Route conductors through strain relief.
- 5 Machine Grounding Terminal
- 6 Line Terminals

▲ **Make input power connections to the welding power source before making connections into a deenergized line disconnect device.**

Connect green or green/yellow grounding conductor to machine grounding terminal first. Then connect input conductors to line terminals.

Close access door.

- 7 Disconnect Device (Supply) Grounding Terminal
- 8 Disconnect Device Line Terminals

▲ **In the deenergized line disconnect device, connect green or green/yellow grounding conductor to supply grounding terminal first, never to a line terminal. Be sure grounding conductor goes to an earth ground.**

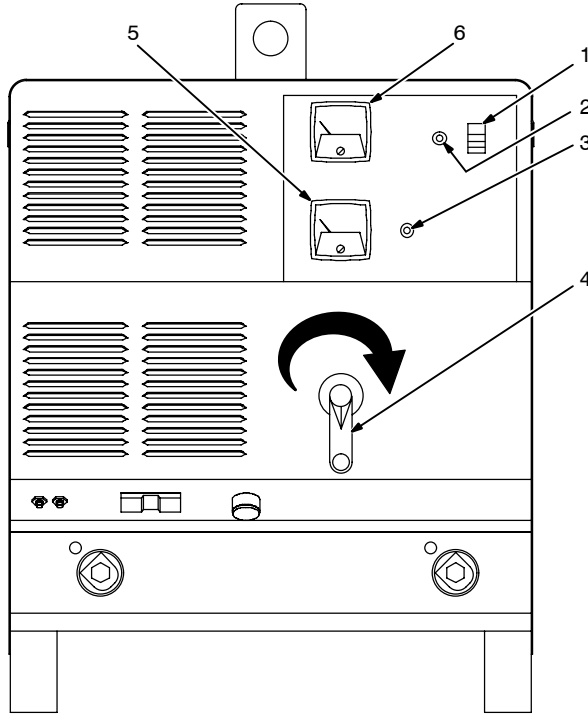
Connect input conductors to line terminals.

9 Overcurrent Protection  
Select type and size using Section 2-13 (fused disconnect switch shown).

Close door on line disconnect device.

# SECTION 3 – OPERATION

## 3-1. Controls



- 1 Power Switch
- 2 Pilot Light

Light is on when power is On.

- 3 Preset Indicator Light

When light is on, the voltmeter displays preset welding voltage as selected by the Voltage Adjustment control.

When light is off, the voltmeter displays actual welding voltage while welding.

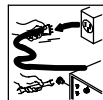
**▲ Weld output terminals are energized only when the preset indicator light is Off.**

- 4 Voltage Adjustment Control
- 5 Voltmeter
- 6 Ammeter

Ref. ST-801 380-B

# SECTION 4 – MAINTENANCE & TROUBLESHOOTING

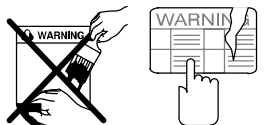
## 4-1. Routine Maintenance



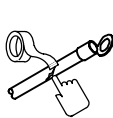
▲ Disconnect power before maintaining.

☞ Maintain more often during severe conditions.

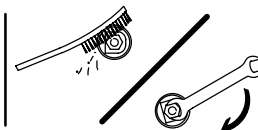
**3 Months**



Replace Damaged Or Unreadable Labels

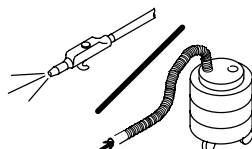


Repair Or Replace Cracked Cables And Cords



Clean And Tighten Weld Terminals

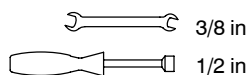
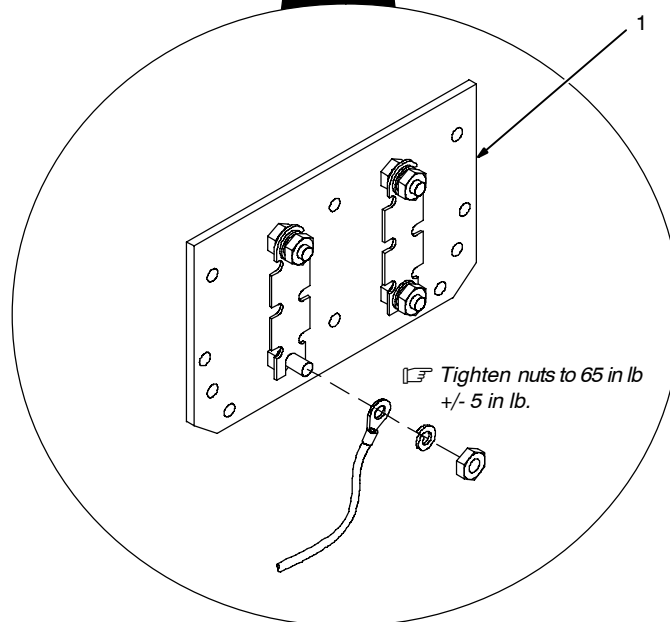
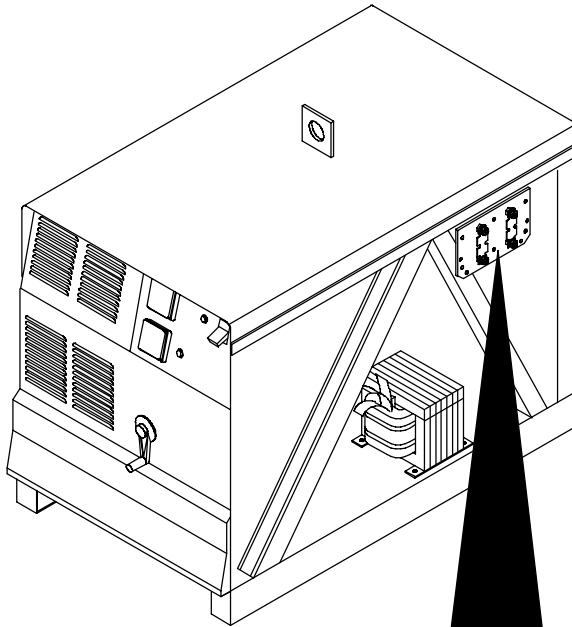
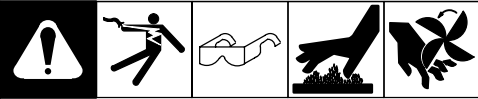
**6 Months**



Blow Out Or Vacuum Inside



## 4-2. Overload Protection



### ▲ Disconnect and lockout/tagout input power before removing side panel.

Lockout/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.

#### 1 Fuse Panel Module

Fuses F1 and F2 protect transformer T1.

If one fuse link opens, low weld output is available at output terminals.

If both fuse links open, no weld output will be available at the output terminals.

⚠ *Incorrect fuse can damage unit.*

Use only replacement fuse of same size, type and rating (see Section 6).

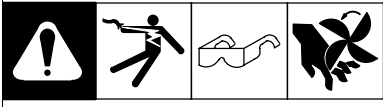
#### Replacing Fuse(s)

Remove top and right side panels.

Replace open or damaged fuse(s).


Reinstall side and top panels.

### 4-3. Troubleshooting

|  |   |
|---|---|
| Trouble   | Remedy  |
| Completely inoperative; fan does not run.   | Place line disconnect switch in the On position (see Section 2-15).       |
|   | Check and replace open line fuse(s) (see Section 2-15).                   |
|   | Check for proper jumper link positions (see Section 2-14).                |
|   | Check for proper input connections (see Section 2-15).                    |
| No weld output; fan motor FM running.   | Reset circuit breakers CB1 and/or CB2, if necessary (see Section 2-12).   |
|   | Unit overheated. Allow unit to cool with fan on (see Section 2-2).        |
|   | Check fuseable link (see Section 4-2).                                    |
|   | Have Factory Authorized Service Agent check control relay CR1.            |
| Excessive line current; line fuse(s) and/or circuit breaker(s) open repeatedly.   | Check for proper input connections (see Section 2-15).                    |
|   | Check for proper jumper link positions (see Section 2-14).                |
| Weld output available; fan does not run.  | Check for and remove anything blocking fan blades.                        |
|   | Have Factory Authorized Service Agent check fan motor FM.                 |
| Fan runs slowly.  | Check for proper jumper link positions (see Section 2-14).                |
| Limited output and low open-circuit voltage.                                      | Check and replace open line fuse(s) (see Section 2-15).                   |
|   | Check for proper input connections (see Section 2-15).                    |
|   | Check for proper jumper link positions (see Section 2-14).                |
| Erratic or improper weld output.  | Check for proper jumper link positions (see Section 2-14).                |
|   | Check for proper input connections (see Section 2-15).                    |
|   | Select correct size weld cables (see Section 2-10).                       |
|   | Clean and tighten weld cable connections (see Section 2-10).              |
|   | Have Factory Authorized Service Agent adjust brush contact on slide wire. |
|   | For 250 ampere models, check tap slope connections (see Section 2-8).     |
|   | For 300 ampere models, check inductance connections (see Section 2-9).    |
|   | Install wire feeder according to it's Owner's Manual.                     |
| No 115 volts ac output at Remote 14 receptacle RC8.                               | Reset circuit breaker CB1, if necessary (see Section 2-12).               |
| No 24 volts ac output at Remote 14 receptacle RC8.                                | Reset circuit breaker CB2, if necessary (see Section 2-12).               |
| Limited output.   | Check fuseable link (see Section 4-2).                                    |

# SECTION 5 - ELECTRICAL DIAGRAMS

**WARNING**



\* Do not touch live electrical parts.  
 \* Disconnect input power or stop engine before servicing.  
 \* Do not operate with covers removed.  
 \* Have only qualified persons install, use, or service this unit.

**ELECTRIC SHOCK HAZARD**

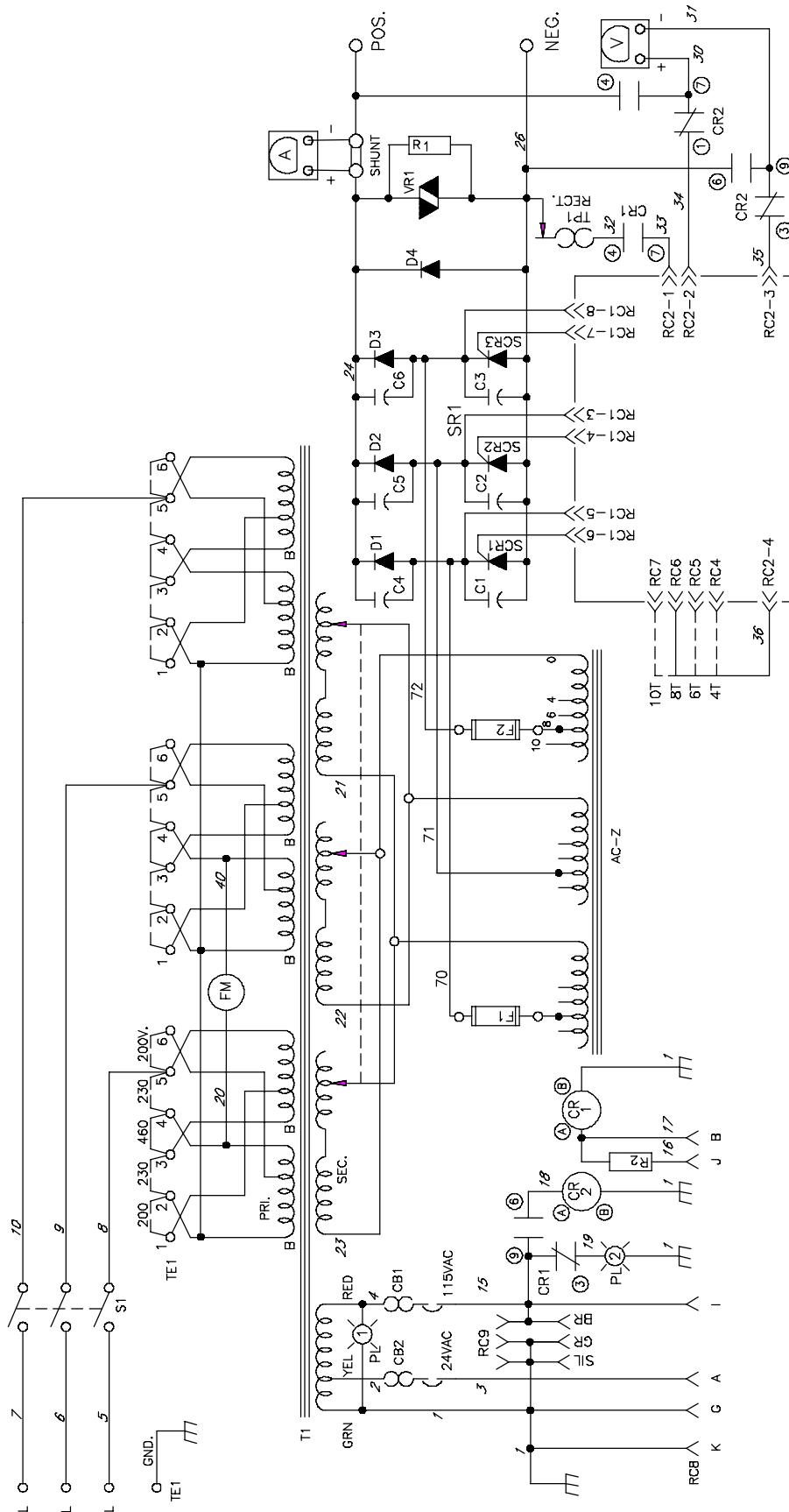



Figure 5-1. Circuit Diagram For 250 Ampere Model

**WARNING**



⚠ Do not touch live electrical parts.  
 ⚠ Disconnect input power or stop engine before servicing.  
 ⚠ Do not operate with covers removed.  
 ⚠ Have only qualified persons install, use, or service this unit.

**ELECTRIC SHOCK HAZARD**

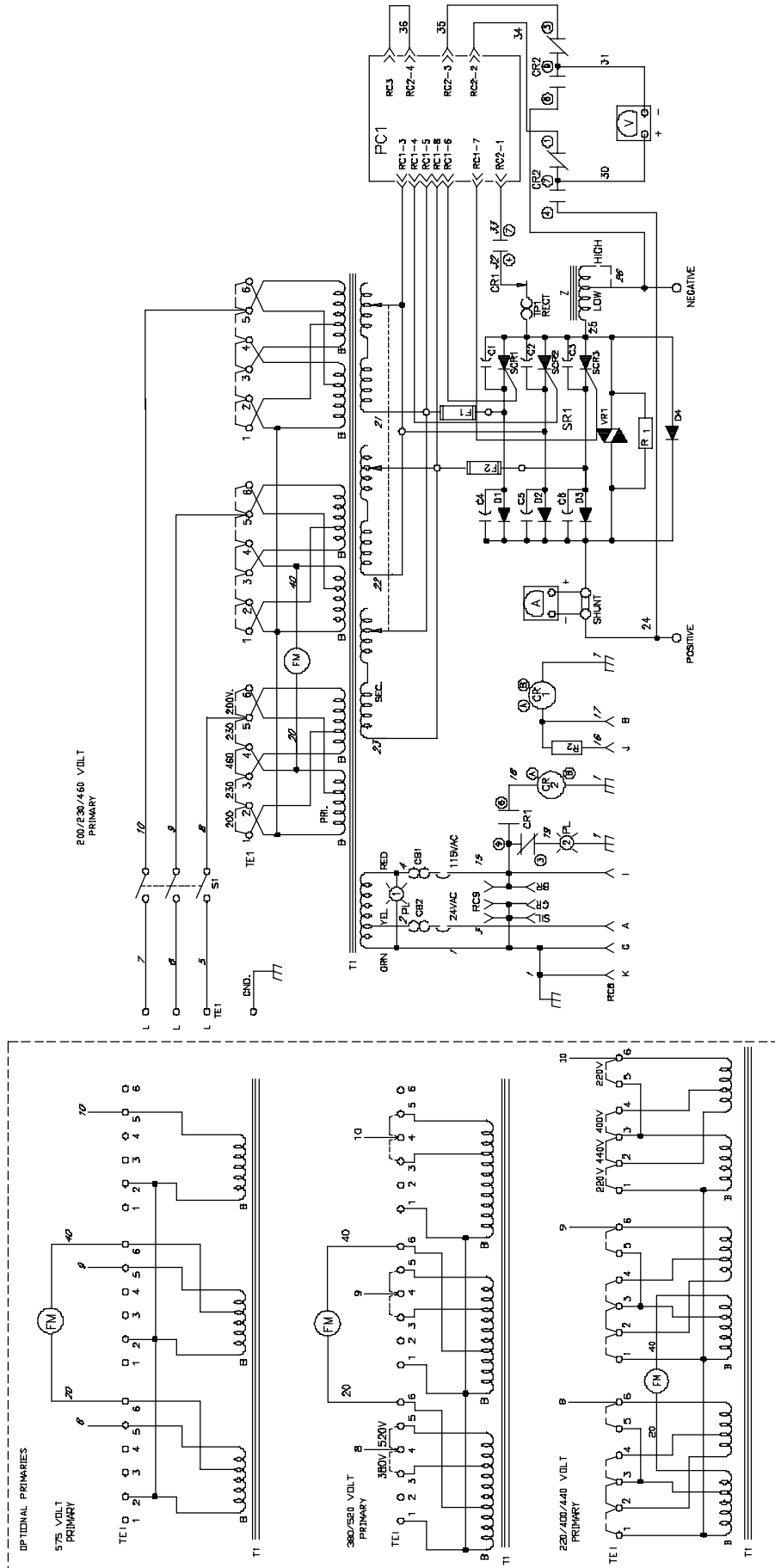


Figure 5-2. Circuit Diagram For 300 Ampere Models



# SECTION 6 – PARTS LIST

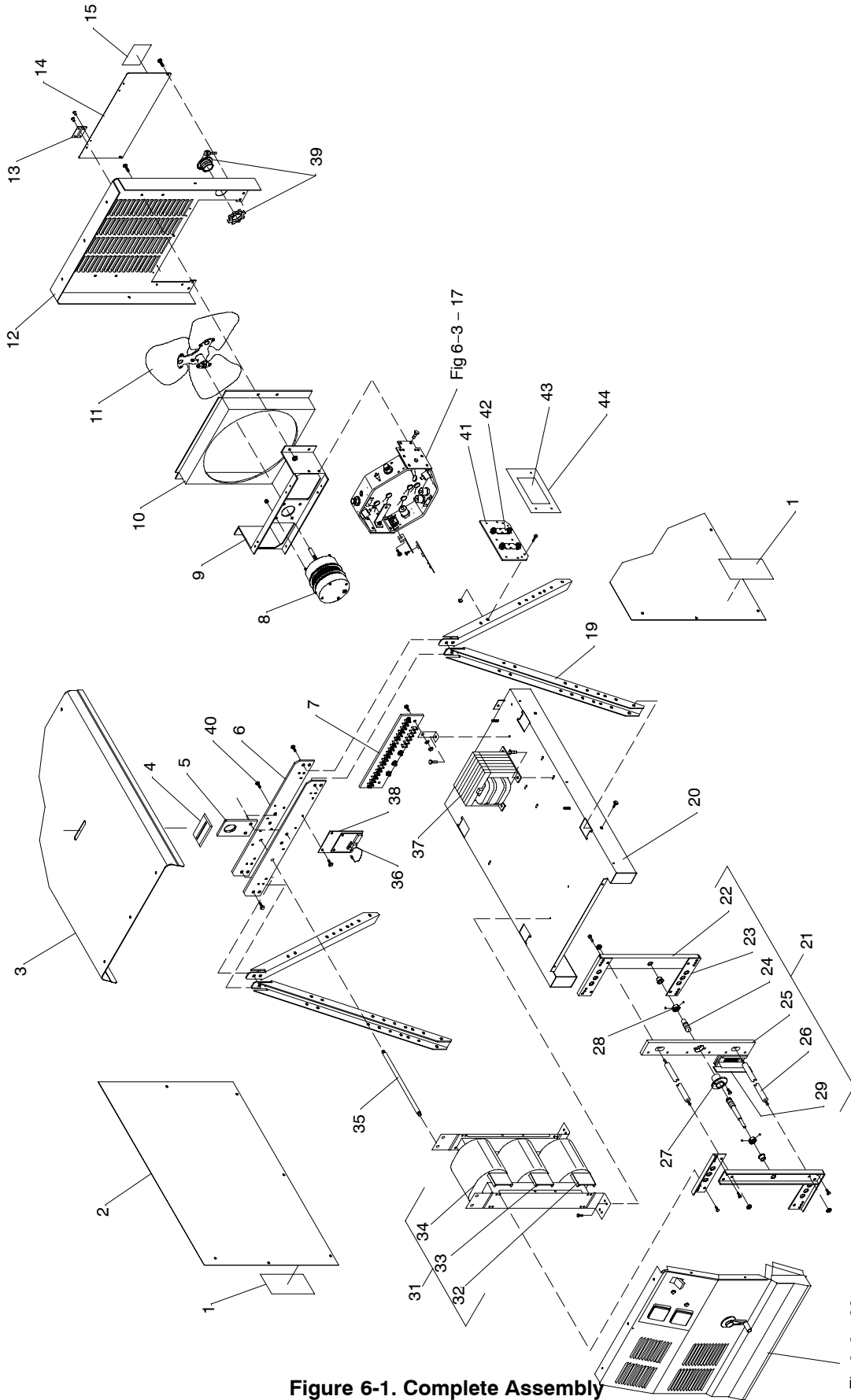


Figure 6-1. Complete Assembly

Fig 6-2 - 30

801 383-J

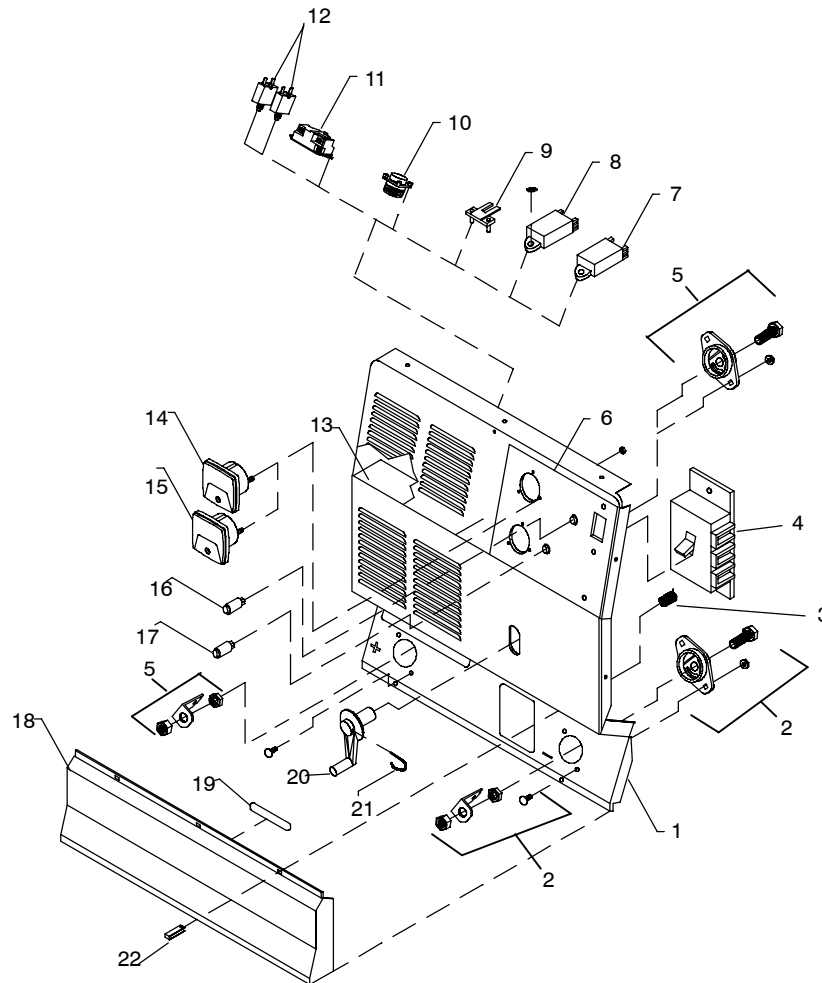
| Item No.                             | Dia. Mkgs. | Part No. | Description  | Quantity |
|--------------------------------------|------------|----------|--|----------|
| <b>Figure 6-1. Complete Assembly</b> |            |          |  |          |
| 1                                    |            | 134 464  | LABEL, warning general   | 2        |
| 2                                    |            | 179 430  | PANEL, side  | 2        |
| 3                                    |            | 179 429  | COVER, top   | 1        |
| 4                                    |            | 177 279  | GASKET, lift eye   | 1        |
| 5                                    |            | 162 830  | LIFT, eye  | 1        |
| 6                                    |            | 162 820  | BAR, mtg lift eye  | 2        |
| 7                                    | TE1        | 038 138  | TERMINAL ASSEMBLY, pri (consisting of)                           | 1        |
|                                      |            | 038 618  | JUMPER, link   | 6        |
| 8                                    | FM         | 208 402  | MOTOR, fan 1/12HP 230V 1550R                                     | 1        |
| 9                                    |            | 124 274  | BRACKET, mtg fan motor   | 1        |
| 10                                   |            | 173 283  | CHAMBER, plenum  | 1        |
| 11                                   |            | 180 165  | BLADE, fan 14.000 3wg 28D  | 1        |
| 12                                   |            | 162 807  | PANEL, rear  | 1        |
| 13                                   |            | 168 343  | HINGE  | 2        |
| 14                                   |            | 162 818  | DOOR, access primary   | 1        |
| 15                                   |            | 168 384  | LABEL, warning electric shock                                    | 1        |
| 17                                   | SR1        | 180 198  | RECTIFIER, assembly (Figure 6-3)                                 | 1        |
| 18                                   |            | 195 793  | ASSEMBLY, shunt  | 1        |
| 19                                   |            | 162 816  | CHANNEL, upright   | 4        |
| 20                                   |            | 180 455  | BASE   | 1        |
| 21                                   |            | 190 101  | RIGGING ASSEMBLY, brush (consisting of)                          | 1        |
| 22                                   |            | 176 635  | BRACKET, mtg vertical  | 2        |
| 23                                   |            | 187 677  | BRACKET, mtg horizontal  | 4        |
| 24                                   |            | 210 709  | SCREW, lead  | 1        |
| 25                                   | TE2        | 190 102  | MOUNTING, bd brush holder  | 1        |
| 26                                   |            | 187 678  | BAR, frame horizontal  | 2        |
| 27                                   |            | 210 708  | COLUMN, brush rigging  | 1        |
| 28                                   |            | 024 622  | NUT, 625-11 1.00 hex .50h stl 2 set screws                       | 2        |
| 29                                   |            | 190 100  | HOLDER, brush assembly (consisting of)                           | 3        |
|                                      |            | 190 103  | HOLDER, brush  | 1        |
|                                      |            | 190 107  | BRUSH SET, contact elect   | 1        |
|                                      |            | 190 106  | RETAINER, brush holder   | 1        |
|                                      |            | 018 606  | SPRING, cprsn  | 5        |
|                                      |            | 190 105  | SPACER, brush holder   | 2        |
| 30                                   |            |          | FRONT PANEL ASSEMBLY, (Figure 6-2)                               | 1        |
| 31                                   | T1         | 187 664  | TRANSFORMER, main power 200/230/460 (consisting of)              | 1        |
| 32                                   |            | 176 602  | COIL, pri/sec 200/230/460 No. 3 bottom                           | 1        |
| 33                                   |            | 176 601  | COIL, pri/sec 200/230/460 No. 2 center                           | 1        |
| 34                                   |            | 176 600  | COIL, pri/sec 200/230/460 No. 1 top                              | 1        |
| 31                                   | T1         | 187 667  | TRANSFORMER, main power 220/400/440 (302 models) (consisting of) | 1        |
| 32                                   |            | 176 770  | COIL, pri/sec 220/380/415 No. 3 bottom                           | 1        |
| 33                                   |            | 176 769  | COIL, pri/sec 220/380/415 No. 2 center                           | 1        |
| 34                                   |            | 176 767  | COIL, pri/sec 220/380/415 No. 1 top                              | 1        |
| 31                                   | T1         | 187 666  | TRANSFORMER, main power 380/520 (302 models) (consisting of)     | 1        |
| 32                                   |            | 176 666  | COIL, pri/sec 380/520 No. 3 bottom                               | 1        |
| 33                                   |            | 176 665  | COIL, pri/sec 380/520 No. 2 center                               | 1        |
| 34                                   |            | 176 664  | COIL, pri/sec 380/520 No. 1 top                                  | 1        |
| 31                                   | T1         | 187 665  | TRANSFORMER, power main 575V (302 model) (consisting of)         | 1        |
| 32                                   |            | 183 188  | COIL, pri/sec 575 No. 3 bottom                                   | 1        |
| 33                                   |            | 183 187  | COIL, pri/sec 575 No. 2 center                                   | 1        |
| 34                                   |            | 183 186  | COIL, pri/sec 575 No. 1 top                                      | 1        |
| 35                                   |            | 187 682  | BAR, mtg transformer   | 1        |
| 36                                   | PC1        | 180 264  | CIRCUIT CARD, firing   | 1        |
|                                      |            | 134 201  | STAND-OFF SUPPORT, pc card                                       | 4        |
| 37                                   | AC2        | 177 336  | REACTOR, (252 model)   | 1        |

| Item No. | Dia. Mkgs. | Part No. | Description | Quantity |
|----------|------------|----------|-------------|----------|
|----------|------------|----------|-------------|----------|

**Figure 6-1. Complete Assembly (continued)**

|        |     |         |   |   |
|--------|-----|---------|---|---|
| ... 37 | ... | 036 585 | .. STABILIZER, (302 models)                           | 1 |
| ... 38 | ... | 180 666 | .. BRACKET, mtg PC board                              | 1 |
| ...    | ... | 162 891 | .. LABEL, warning electric shock                      | 1 |
| ... 39 | ... | 010 467 | .. CONNECTOR, clamp cable 1.250                       | 1 |
| ... 40 | ... | 604 536 | .. SCREW, .312-18 x 1.75 hexhd-pln gr 5               | 2 |
| ... 41 | ... | 212 987 | .. FUSE PANEL, module                                 | 1 |
| ... 42 | ... | 212 988 | .. FUSE, link   | 1 |
| ... 43 | ... | 212 025 | .. LABEL, warning electric shock hazard fuses replace | 1 |
| ... 44 | ... | 212 986 | .. INSULATOR, cover fuse                              | 1 |

BE SURE TO PROVIDE MODEL AND SERIAL NUMBER WHEN ORDERING REPLACEMENT PARTS.



Ref. 802 497

**Figure 6-2. Panel, Front w/Components**

| Item No. | Dia. Mkgs. | Part No. | Description | Quantity |
|----------|------------|----------|-------------|----------|
|----------|------------|----------|-------------|----------|

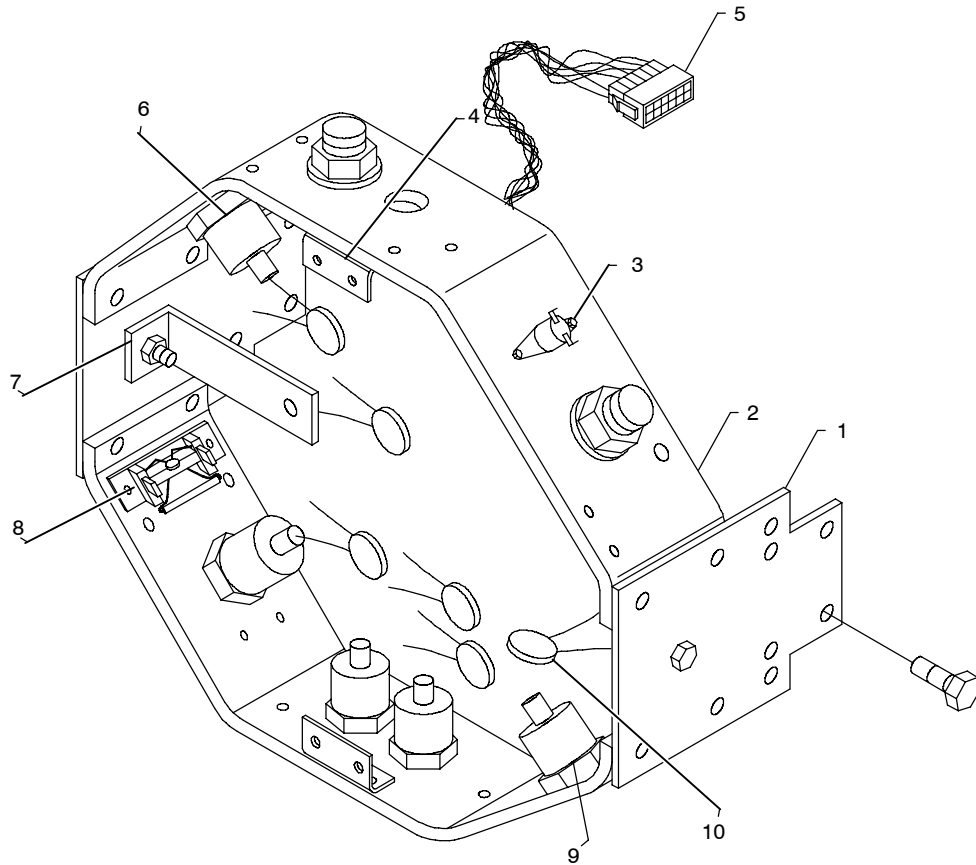
**Figure 6-2. Panel, Front w/Components (Figure 6-1 Item 30)**

|       |         |         |  |   |
|-------|---------|---------|--|---|
| ... 1 | ...     | 184 112 | .... FRONT PANEL                                   | 1 |
| ... 2 | ...     | 181 246 | .... TERMINAL, power output black                  | 1 |
| ... 3 | ...     | 161 303 | .. SPRING, cprsn .600 OD x .072                    | 3 |
| ... 4 | ... S1  | 128 756 | .... SWITCH, tgl 3PST 40A 600V                     | 1 |
| ... 5 | ...     | 181 245 | .... TERMINAL, power output red                    | 1 |
| ... 6 | ...     | ...     | .... NAMEPLATE, (order by model and serial number) | 1 |
| ... 7 | ... CR1 | 110 386 | .... RELAY, encl 24VAC DPDT                        | 1 |



| Item No.  | Dia. Mkgs. | Part No. | Description                                |   |
|---|------------|----------|--|---|
| <b>Figure 6-2. Panel, Front w/Components (continued) (Figure 6-1 Item 30)</b> |            |          |  |   |
| ... 8 ...   | CR2        | 186 162  | RELAY, encl 120VAC DPDT                    | 1 |
| ... 9 ...   | R2         | 114 050  | RESISTOR, WW fxd 10W 1K ohm                | 1 |
| ... 10 ...  | RC8        | 143 976  | RECEPTACLE & SOCKETS                       | 1 |
| ... 11 ...  | RC9        | 604 176  | RECEPTACLE, str dx grd 2P3W 15A 125V       | 1 |
| ... 12 ..   | CB1,2      | 093 995  | CIRCUIT BREAKER, man reset 1P 15A 250VAC   | 2 |
| ... 13 .....  |            | 176 632  | BAFFLE, air                                | 1 |
| ... 14 .....  |            | 119 005  | METER, amp DC 50MV 0-400                   | 1 |
| ... 15 .....  |            | 118 902  | METER, volt DC 0-50                        | 1 |
| ... 16 ...  | PL1        | 163 562  | LIGHT, ind wht lens 115VAC                 | 1 |
| ... 17 ...  | PL2        | 074 188  | LIGHT, ind red lens 115VAC                 | 1 |
| ... 18 .....  |            | 172 587  | COVER, stud output                         | 1 |
| ... 19 .....  |            | 162 891  | LABEL, electric shock and reduced ari flow | 1 |
| ... 20 .....  |            | 009 433  | HANDLE, current control                    | 1 |
| ... 21 .....  |            | 009 926  | PIN, handle current control                | 1 |
| ... 22 .....  |            | 160 935  | CLIP, spring                               | 3 |

BE SURE TO PROVIDE MODEL AND SERIAL NUMBER WHEN ORDERING REPLACEMENT PARTS.



**Figure 6-3. Rectifier Assembly**

Ref. 802 497-A

| Item No.   | Dia. Mkgs. | Part No. | Description                     |   |
|--|------------|----------|---------------------------------|---|
| <b>Figure 6-3. Rectifier Assembly (Figure 6-1 Item 17)</b> |            |          |                                 |   |
| ... 1  | .....      | 210 324  | ... MOUNTING BOARD, rectifier   | 2 |
| ... 2  | .....      | 087 461  | ... HEAT SINK                   | 2 |
| ... 3  | ... TP1    | 165 670  | ... THERMOSTAT, NC open 300F    | 1 |
| ... 4  | .....      | 024 241  | ... ANGLE, mtg term             | 2 |
| ... 5  | .. PLG1    | 158 720  | ... CONNECTOR & SOCKETS         | 1 |
| ... 6  | . SCR1-3   | 180 456  | ... THYRISTOR, SCR 175 A30      | 3 |
| ... 7  | .....      | 195 790  | ... ASSEMBLY BRACKET, rectifier | 2 |
| ... 8  | . R1, VR1  | 083 420  | ... SUPPRESSOR, rect            | 1 |
| ... 9  | ... D1-4   | 037 956  | ... DIODE, rect 275A 300V       | 4 |
| ... 10   | ... C1-6   | 031 689  | ... CAPACITOR, cer disc         | 6 |

BE SURE TO PROVIDE MODEL AND SERIAL NUMBER WHEN ORDERING REPLACEMENT PARTS.

# TRUE BLUE<sup>®</sup>

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2. 3 Years — Parts and Labor
  - \* Transformer/Rectifier Power Sources
  - \* Plasma Arc Cutting Power Sources
  - \* Semi-Automatic and Automatic Wire Feeders
  - \* Inverter Power Supplies
  - \* Intelligig
  - \* Engine Driven Welding Generators  
**(NOTE: Engines are warranted separately by the engine manufacturer.)**
3. 1 Year — Parts and Labor Unless Specified
  - \* DS-2 Wire Feeder
  - \* Motor Driven Guns (w/exception of Spoolmate Spoolguns)
  - \* Process Controllers
  - \* Positioners and Controllers
  - \* Automatic Motion Devices
  - \* RFCS Foot Controls
  - \* Induction Heating Power Sources
  - \* Water Coolant Systems
  - \* Flowgauge and Flowmeter Regulators (No Labor)
  - \* HF Units
  - \* Grids
  - \* Maxstar 85, 140
  - \* Spot Welders
  - \* Load Banks
  - \* Racks
  - \* Running Gear/Trailers
  - \* Plasma Cutting Torches (except APT & SAF Models)
  - \* Field Options  
**(NOTE: Field options are covered under True Blue<sup>®</sup> for the remaining warranty period of the product they are installed in, or for a minimum of one year — whichever is greater.)**
4. 6 Months — Batteries
5. 90 Days — Parts
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  - \* Induction Heating Coils and Blankets

- \* APT, ZIPCUT & PLAZCUT Model Plasma Cutting Torches
- \* Remote Controls
- \* Accessory Kits
- \* Replacement Parts (No labor)
- \* Spoolmate Spoolguns
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Please complete and retain with your personal records.

|               |  |
|---------------|--|
| Model Name    | Serial/Style Number  |
| Purchase Date | (Date which equipment was delivered to original customer.) |
| Distributor   |  |
| Address       |  |
| City          |  |
| State         | Zip  |



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