

Set Up Machine in 3 Easy Steps

1 Process Selection Control

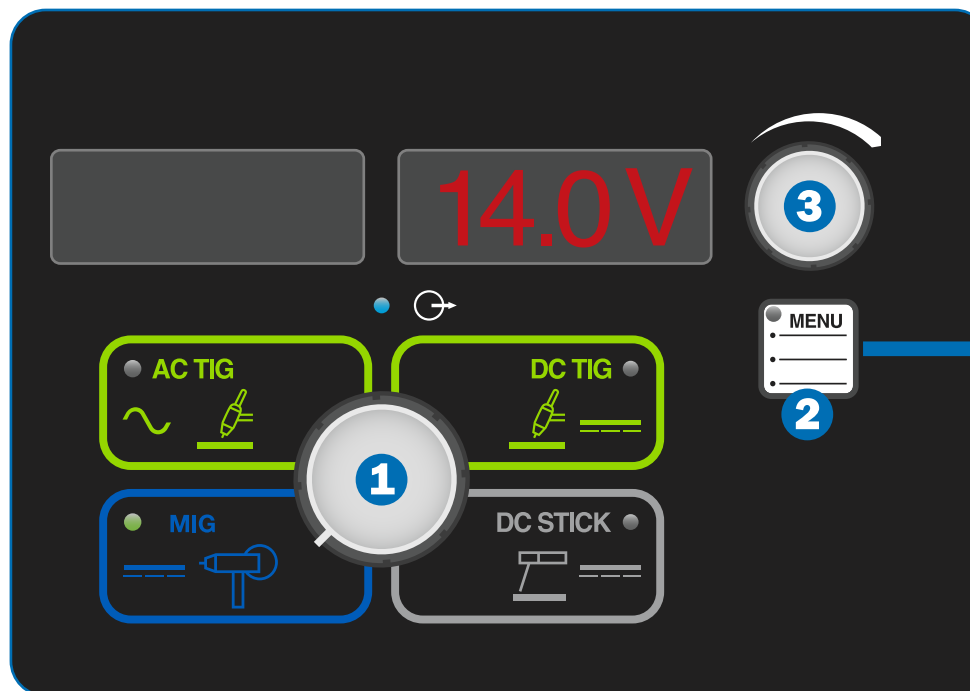
Turn to select process.

2 Menu Button

Press to access process parameters.
Menu automatically returns to amperage setting 15 seconds after adjustment.

3 Encoder Control

Turn to adjust selected parameter.



Press 1x

WFS 0

To Access User Menu (Auto-Set™)

Hold 3 sec.

GUN S150

Press 1x

PROC C25

Press 2x

WIRE 0.030

Press 3x

MAT 18GA

Voltage Control

Controls the welding voltage output.

[WFS] Wire Feed Speed

Controls the speed of the wire feed with a minimum of 0.0 to maximum of 10.

Auto-Set™ feature. Use this when you want the speed, convenience, and confidence of pre-set controls. Simply set the spool gun, process/gas type, wire size, and material thickness, and you're ready to weld.

User Menu—Hold Down Menu Button for 3 Seconds to Access

[GUN] Spool Gun

Choose the correct spool gun you are welding with using the Encoder Control. Select from the Spoolmate™ 100 and the Spoolmate™ 150.

[PROC] Process/Gas Type

Choose the correct process you are welding with using the Encoder Control. Select from Flux, Trigas, C25, C100, 4043 and 5356. (5356 is only selectable with the Spoolmate 150.)

[WIRE] Wire Size

Choose the appropriate wire size by using the Encoder Control. Select from 0.024, 0.030 and 0.035.

[MAT] Material Thickness

Choose the correct material thickness for the material you are welding with using the Encoder Control. Select from 24GA, 22GA, 20GA, 18GA, 16GA, 14GA, 1/8, 3/16, 1/4, and 3/8.



Read and follow all labels and the Owner's Manual carefully before installing, operating, or servicing unit.
Read the safety information at the beginning of the manual and in each section.

Note: These settings are intended to be a starting point for control panel setup — this is not a welding procedure specification nor a substitute for procedure qualification.

Wire Welding (MIG/Flux-Cored) Parameters for Spoolmate™ 100

| Material | Wire Type | Polarity* | Shielding Gas | Wire Dia. | 24 ga. | 22 ga. | 20 ga. | 18 ga. | 16 ga. | 14 ga. | 1/8" | 3/16" | 1/4" | 3/8" | |
|--------------------|--------------------|-------------|--------------------------|-----------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|----------|----------|--------|-------|
| | | | | | 120 V / 240 V | 120 V / 240 V | 120 V / 240 V | 120 V / 240 V | 120 V / 240 V | 120 V / 240 V | 120 V / 240 V | 240 V | 240 V | 240 V | 240 V |
| Steel | Solid Wire ER70S-6 | DCEP | Ar/CO ₂ "C25" | 0.024 | 16/3.7 | 16/3.7 | 16.2/4.6 | 16.7/8.8 | 17.7/9.3 | 18.4/9.9 | 18.9/10 | | | | |
| | | | | 0.030 | 15.4/0 | 15.4/0 | 16/0.6 | 17/1 | 17/3.2 | 17.8/4.8 | 19.5/6 | 20.1/6.9 | 21.8/7.5 | | |
| | | | | 0.035 | | | 16/0.2 | 17/0.8 | 17.7/1.6 | 18.4/1.5 | 19.6/2.8 | 20.8/3.9 | 21/4.3 | 22.1/5 | |
| | | | CO ₂ "C100" | 0.024 | 17/0.7 | 17/0.7 | 17.5/1.3 | 18.6/2.5 | 19.8/3.8 | 21/8.9 | 21.8/10 | | | | |
| | | | | 0.030 | 17/0.3 | 17/0.3 | 17.5/0.5 | 18.6/1.5 | 17.4/3.2 | 19.3/3.9 | 21.2/5.1 | 21.8/5.6 | | | |
| | | | | 0.035 | | | 17.5/0.3 | 18.6/1.2 | 19.8/1.9 | 20.5/2.2 | 20.9/2.9 | 21.8/3.2 | | | |
| Flux-Cored E71T-11 | DCEN | None "Flux" | 0.030 | | | | | | 18.3/3.6 | 18.5/3.8 | 20.5/5.2 | 22.5/8.6 | | | |
| | | | 0.035 | | | | | | | 18.5/3.5 | 20.5/4.7 | 21.5/5.5 | 22/6.5 | | |
| Stainless Steel | Stainless Steel | DCEP | "Trigas" | 0.030 | | 18/0.2 | 18.3/0.5 | 18.5/0.7 | 18.9/1 | 19.4/1.2 | 20.9/6.6 | 21.5/7 | 22.5/7.5 | | |
| | | | | 0.035 | | | 18.3/0.3 | 18.5/0.4 | 18.9/0.6 | 19.4/0.9 | 20.9/3.6 | 21.5/3.9 | 22.3/4.2 | | |
| Aluminum | Aluminum ER4043 | DCEP | Argon | 0.030 | | | | | | 14.8/8.5 | 15.2/8.8 | 20.7/9.8 | 22.5/10 | | |
| | | | | 0.035 | | | | | | 14.8/8.2 | 15.2/8.6 | 20.3/9.7 | 21.4/9.9 | | |

Wire Welding (MIG/Flux-Cored) Parameters for Spoolmate™ 150

| Material | Wire Type | Polarity* | Shielding Gas | Wire Dia. | 24 ga. | 22 ga. | 20 ga. | 18 ga. | 16 ga. | 14 ga. | 1/8" | 3/16" | 1/4" | 3/8" | | |
|-----------------|--------------------|-----------|--------------------------|--------------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|----------|----------|----------|----------|--|
| | | | | | 120 V / 240 V | 120 V / 240 V | 120 V / 240 V | 120 V / 240 V | 120 V / 240 V | 120 V / 240 V | 120 V / 240 V | 240 V | 240 V | 240 V | 240 V | |
| Steel | Solid Wire ER70S-6 | DCEP | Ar/CO ₂ "C25" | 0.030 | 15.4/0 | 15.4/0 | 16/0.5 | 17/1 | 17.7/1.4 | 17.8/4.8 | 19.5/6 | 20.1/6.9 | 21.8/7.4 | | | |
| | | | | 0.035 | | | 16/0.2 | 17/0.6 | 17.7/1.1 | 18.4/1.3 | 19.6/2.2 | 20.8/3.9 | 21/4.3 | 22.1/4.7 | | |
| | | | | 0.030 | 17/0.2 | 17/0.2 | 17.5/0.5 | 18.6/1.1 | 19.8/1.5 | 19.3/3.6 | 21.2/4.6 | 21.3/5.2 | | | | |
| | | | CO ₂ "C100" | 0.035 | | | 17.5/0.1 | 18.6/0.6 | 19.8/1 | 20.5/1.2 | 19.3/3.6 | 21.2/4.6 | 21.3/5.2 | | | |
| | | | | Flux-Cored E71T-11 | DCEN | None "Flux" | 0.030 | | | | | 18.3/3.3 | 19.3/4.1 | 21.4/7.9 | 22.5/8.6 | |
| | | | | | | | 0.035 | | | | | 18.5/3.2 | 20.5/4.4 | 21.5/5.3 | 22/6.5 | |
| Stainless Steel | Stainless Steel | DCEP | "Trigas" | 0.030 | | 18/0 | 18.3/0.4 | 18.5/0.8 | 18.9/1.1 | 19.4/1.6 | 21.5/7 | 22.5/7.2 | | | | |
| | | | | 0.035 | | | 18.3/0.1 | 18.5/0.2 | 18.9/0.4 | 19.4/0.9 | 20.9/3.7 | 21.5/3.9 | 22.3/4.2 | | | |
| Aluminum | Aluminum ER4043 | DCEP | Argon | 0.030 | | | | | 14.8/7.5 | 18/7.9 | 20.7/8.4 | 21.6/8.9 | | | | |
| | | | | 0.035 | | | | | 15.4/3.8 | 18/6.5 | 19.3/7.8 | 20.4/8.8 | | | | |
| | Aluminum ER5356 | DCEP | Argon | 0.030 | | | | | 14.5/8.9 | 15.7/9.2 | | | | | | |
| | | | | 0.035 | | | | | 15.8/7.4 | 17.2/8.7 | 19.2/10 | | | | | |

*Polarity selection is done automatically by the power source.

Note: Some parameters are not available in 120 V due to limited input power. **Blue values** are only available when connected to 240 V.

