



OM-282170C

2020-09

Processes



MIG (GMAW) Welding



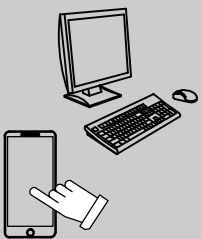
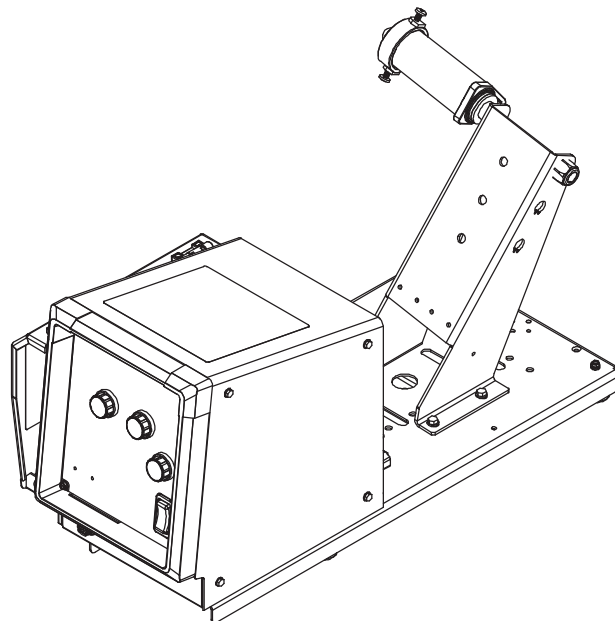
Flux Cored (FCAW) Welding

Description



Wire Feeder

Intelx™ Wire Feeder



For product information,
Owner's Manual translations,
and more, visit

www.MillerWelds.com

OWNER'S MANUAL

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, and our extensive service network is there to help fix the problem. Warranty and maintenance information for your particular model are also provided.

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 specification sheets. **To locate your nearest distributor or service agency call 1-800-4-A-Miller, or visit us at 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.



ISO 9001
Quality

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




TABLE OF CONTENTS


SECTION 1 – SAFETY PRECAUTIONS – READ BEFORE USING	1
1-1 Symbol Usage	1
1-2 Arc Welding Hazards	1
1-3 Additional Hazards For Installation, Operation, And Maintenance	3
1-4 California Proposition 65 Warnings	4
1-5 Principal Safety Standards	4
1-6 EMF Information	4
SECTION 2 – CONSIGNES DE SÉCURITÉ - LIRE AVANT UTILISATION	5
2-1 Symboles utilisés	5
2-2 Dangers relatifs au soudage à l'arc	5
2-3 Symboles de dangers supplémentaires en relation avec l'installation, le fonctionnement et la maintenance	7
2-4 Proposition californienne 65 Avertissements	9
2-5 Principales normes de sécurité	9
2-6 Informations relatives aux CEM	9
SECTION 3 – DEFINITIONS	10
3-1 Additional Safety Symbol Definitions	10
3-2 Miscellaneous Symbols And Definitions	11
SECTION 4 – SPECIFICATIONS	13
4-1 Serial Number And Rating Label Location	13
4-2 Software Licensing Agreement	13
4-3 Information About Default Weld Parameters And Settings	13
4-4 Specifications	13
4-5 Environmental Specifications	13
4-6 Duty Cycle And Overheating	13
SECTION 5 – INSTALLATION	14
5-1 Selecting A Location	14
5-2 Connecting Weld Output Cable	15
5-3 Connection Diagram	16
5-4 Arranging Welding Cables To Reduce Welding Circuit Inductance	17
5-5 Control Cable Connections	18
5-6 Wire Feeder Lower Front Panel Connections	19
5-7 Weld Voltage Sense Connection (Optional)	19
5-8 Connecting Shielding Gas	20
5-9 Rotating Drive Assembly	21
5-10 Installing Welding Gun	22
5-11 Installing Wire Guides And Drive Rolls	23
5-12 Installing And Threading Welding Wire	24
SECTION 6 – OPERATION	26
6-1 Wire Feeder User Interface	26
6-2 Description Of Front Panel Controls	27
6-3 Power Switch	27
6-4 Jog/Purge Switch	28
6-5 Arc Control	28
6-6 Trigger Hold	29
SECTION 7 – MAINTENANCE AND TROUBLESHOOTING	30
7-1 Routine Maintenance	30
7-2 Cleaning Debris From Shielding Gas Filter Fitting	30
7-3 Diagnostics Table For Fault Codes	31
7-4 Troubleshooting	31
SECTION 8 – ELECTRICAL DIAGRAMS	34
WARRANTY	39

SECTION 1 – SAFETY PRECAUTIONS – READ BEFORE USING


 Protect yourself and others from injury—read, follow, and save these important safety precautions and operating instructions.

1-1. Symbol Usage

 **DANGER!** – Indicates a hazardous situation which, if not avoided, will result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.

 Indicates a hazardous situation which, if not avoided, could result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.


NOTICE – Indicates statements not related to personal injury.


 Indicates special instructions.




This group of symbols means Warning! Watch Out! ELECTRIC SHOCK, MOVING PARTS, and HOT PARTS hazards. Consult symbols and related instructions below for necessary actions to avoid these 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 Principal Safety Standards listed in Section 1-5. Read and follow all Safety Standards.

 Only qualified persons should install, operate, maintain, and repair this equipment. A qualified person is defined as one who, by possession of a recognized degree, certificate, or professional standing, or who by extensive knowledge, training and experience, has successfully demonstrated the ability to solve or resolve problems relating to the subject matter, the work, or the project and has received safety training to recognize and avoid the hazards involved.

 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 weld output in damp, wet, or confined spaces, 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.
- Additional safety precautions are required when any of the following electrically hazardous conditions are present: in damp locations or while wearing wet clothing; on metal structures such as floors, gratings, or scaffolds; when in cramped positions such as sitting, kneeling, or lying; or when there is a high risk of unavoidable or accidental contact with the workpiece or ground. For these conditions, use the following equipment in order presented: 1) a semiautomatic DC constant voltage (wire) welder, 2) a DC manual (stick) welder, or 3) an AC welder with reduced open-circuit voltage. In most situations, use of a DC, constant voltage wire welder is recommended. And, do not work alone!

- 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, ground, and operate 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.
- Keep cords dry, free of oil and grease, and protected from hot metal and sparks.
- Frequently inspect input power cord and ground conductor for damage or bare wiring — replace immediately if damaged — bare wiring can kill.
- Turn off all equipment when not in use.
- Do not use worn, damaged, undersized, or repaired 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.
- Do not touch electrode holders connected to two welding machines at the same time since double open-circuit voltage will be present.
- 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. Disconnect cable for process not in use.
- Use GFCI protection when operating auxiliary equipment in damp or wet locations.

SIGNIFICANT DC VOLTAGE exists in inverter power sources AFTER removal of input power.

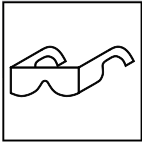
- Turn off unit, disconnect input power, and discharge input capacitors according to instructions in Manual before touching any parts.



HOT PARTS can burn.

- Do not touch hot parts bare handed.
- Allow cooling period before working on equipment.
- To handle hot parts, use proper tools and/or wear heavy, insulated welding gloves and clothing to

prevent burns.



FLYING METAL OR DIRT 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.



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.
- Ventilate the work area and/or use local forced ventilation at the arc to remove welding fumes and gases. The recommended way to determine adequate ventilation is to sample for the composition and quantity of fumes and gases to which personnel are exposed.
- If ventilation is poor, wear an approved air-supplied respirator.
- Read and understand the Safety Data Sheets (SDSs) and the manufacturer's instructions for adhesives, coatings, cleaners, consumables, coolants, degreasers, fluxes, and metals.
- Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Always have a trained watchperson 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 while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes if welded.



BUILDUP OF GAS can injure or kill.

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



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.

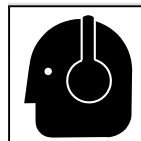
- Wear an approved welding helmet fitted with a proper shade of filter lenses to protect your face and eyes from arc rays and sparks when welding or watching (see ANSI Z49.1 and Z87.1 listed in Safety Standards).
- Wear approved safety glasses with side shields under your helmet.
- Use protective screens or barriers to protect others from flash, glare, and sparks; warn others not to watch the arc.
- Wear body protection made from durable, flame-resistant material (leather, heavy cotton, wool). Body protection includes oil-free clothing such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap.



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.

- Remove all flammables within 35 ft (10.7 m) of the welding arc. If this is not possible, tightly cover them with approved covers.
- Do not weld where flying sparks can strike flammable material.
- Protect yourself and others from flying sparks and hot metal.
- 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 cut or weld on tire rims or wheels. Tires can explode if heated. Repaired rims and wheels can fail. See OSHA 29 CFR 1910.177 listed in Safety Standards.
- Do not weld on containers that have held combustibles, or on closed containers such as tanks, drums, or pipes unless they are properly prepared according to AWS F4.1 and AWS A6.0 (see Safety Standards).
- Do not weld where the atmosphere can contain flammable dust, gas, or liquid vapors (such as gasoline).
- 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, sparks, 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 body protection made from durable, flame-resistant material (leather, heavy cotton, wool). Body protection includes oil-free clothing 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.
- After completion of work, inspect area to ensure it is free of sparks, glowing embers, and flames.
- Use only correct fuses or circuit breakers. Do not oversize or bypass them.
- Follow requirements in OSHA 1910.252 (a) (2) (iv) and NFPA 51B for hot work and have a fire watcher and extinguisher nearby.
- Read and understand the Safety Data Sheets (SDSs) and the manufacturer's instructions for adhesives, coatings, cleaners, consumables, coolants, degreasers, fluxes, and metals.



NOISE can damage hearing.

Noise from some processes or equipment can damage hearing.

- Wear approved ear protection if noise level is high.



ELECTRIC AND MAGNETIC FIELDS (EMF) can affect Implanted Medical Devices.

- Wearers of Pacemakers and other Implanted Medical Devices should keep away.

- Implanted Medical Device wearers should consult their doctor and the device manufacturer before going near arc welding, spot welding, gouging, plasma arc cutting, or induction heating operations.



CYLINDERS can explode if damaged.

Compressed 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, physical damage, 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 compressed 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. Do not stand in front of or behind the regulator when opening the valve.
- Keep protective cap in place over valve except when cylinder is in use or connected for use.
- Use the proper equipment, correct procedures, and sufficient number of persons to lift, move, and transport cylinders.
- Read and follow instructions on compressed gas cylinders, associated equipment, and Compressed Gas Association (CGA) publication P-1 listed in Safety Standards.

1-3. Additional Hazards For Installation, Operation, And Maintenance



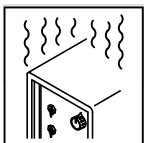
FIRE OR EXPLOSION hazard.

- 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.



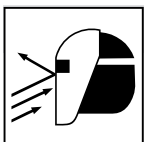
FALLING EQUIPMENT can injure.

- Use lifting eye to lift unit and properly installed accessories only, NOT gas cylinders. Do not exceed maximum lift eye weight rating (see Specifications).
- Use correct procedures and 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.
- Keep equipment (cables and cords) away from moving vehicles when working from an aerial location.
- Follow the guidelines in the Applications Manual for the Revised NIOSH Lifting Equation (Publication No. 94-110) when manually lifting heavy parts or equipment.



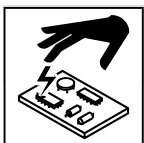
OVERUSE can cause OVERHEATING.

- 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.



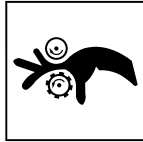
FLYING SPARKS can injure.

- Wear a face shield to protect eyes and face.
- Shape tungsten electrode only on grinder with proper guards in a safe location wearing proper face, hand, and body protection.
- Sparks can cause fires — keep flammables away.



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.



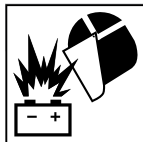
MOVING PARTS can injure.

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



WELDING WIRE can injure.

- 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.



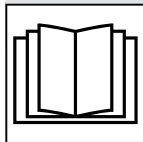
BATTERY EXPLOSION can injure.

- Do not use welder to charge batteries or jump start vehicles unless it has a battery charging feature designed for this purpose.



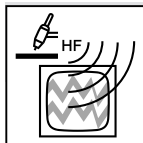
MOVING PARTS can injure.

- Keep away from moving parts such as fans.
- Keep all doors, panels, covers, and guards closed and securely in place.
- Have only qualified persons remove doors, panels, covers, or guards for maintenance and troubleshooting as necessary.
- Reinstall doors, panels, covers, or guards when maintenance is finished and before reconnecting input power.



READ INSTRUCTIONS.

- 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.
- Use only genuine replacement parts from the manufacturer.
- Perform installation, maintenance, and service according to the Owner's Manuals, industry standards, and national, state, and local codes.



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.

as robots.

- Electromagnetic energy can interfere with sensitive electronic equipment such as microprocessors, computers, and computer-driven equipment such

- 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. California Proposition 65 Warnings

⚠ WARNING – This product can expose you to chemicals including lead, which are known to the state of California to cause cancer and birth defects or other reproductive harm.

For more information, go to www.P65Warnings.ca.gov.

1-5. Principal Safety Standards

Safety in Welding, Cutting, and Allied Processes, American Welding Society standard ANSI Standard Z49.1. Website: <http://www.aws.org>.

Safe Practice For Occupational And Educational Eye And Face Protection, ANSI Standard Z87.1, from American National Standards Institute. Website: www.ansi.org.

Safe Practices for the Preparation of Containers and Piping for Welding and Cutting, American Welding Society Standard AWS F4.1 from Global Engineering Documents. Website: www.global.ihs.com.

Safe Practices for Welding and Cutting Containers that have Held Combustibles, American Welding Society Standard AWS A6.1 from Global Engineering Documents. Website: www.global.ihs.com.

National Electrical Code, NFPA Standard 70 from National Fire Protection Association. Website: www.nfpa.org and www.sparky.org.

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1 from Compressed Gas Association. Website: www.cganet.com.

Safety in Welding, Cutting, and Allied Processes, CSA Standard W117.2 from Canadian Standards Association. Website: www.csagroup.org.

Standard for Fire Prevention During Welding, Cutting, and Other Hot Work, NFPA Standard 51B from National Fire Protection Association. Website: www.nfpa.org.

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910.177 Subpart N, Part 1910 Subpart Q, and Part 1926, Subpart J. Website: www.osha.gov.

OSHA *Important Note Regarding the ACGIH TLV, Policy Statement on the Uses of TLVs and BEIs*. Website: www.osha.gov.

Applications Manual for the Revised NIOSH Lifting Equation from the National Institute for Occupational Safety and Health (NIOSH). Website: www.cdc.gov/NIOSH.

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1-6. EMF Information

Electric current flowing through any conductor causes localized electric and magnetic fields (EMF). The current from arc welding (and allied processes including spot welding, gouging, plasma arc cutting, and induction heating operations) creates an EMF field around the welding circuit. EMF fields can interfere with some medical implants, e.g. pacemakers. Protective measures for persons wearing medical implants have to be taken. For example, restrict access for passers-by or conduct individual risk assessment for welders. All welders should use the following procedures in order to minimize exposure to EMF fields from the welding circuit:

1. Keep cables close together by twisting or taping them, or using a cable cover.
2. Do not place your body between welding cables. Arrange cables to one side and away from the operator.
3. Do not coil or drape cables around your body.

4. Keep head and trunk as far away from the equipment in the welding circuit as possible.
5. Connect work clamp to workpiece as close to the weld as possible.
6. Do not work next to, sit or lean on the welding power source.
7. Do not weld whilst carrying the welding power source or wire feeder.

About Implanted Medical Devices:

Implanted Medical Device wearers should consult their doctor and the device manufacturer before performing or going near arc welding, spot welding, gouging, plasma arc cutting, or induction heating operations. If cleared by your doctor, then following the above procedures is recommended.

SECTION 2 – CONSIGNES DE SÉCURITÉ - LIRE AVANT UTILISATION

⚠ Pour écarter les risques de blessure pour vous-même et pour autrui — lire, appliquer et ranger en lieu sûr ces consignes relatives aux précautions de sécurité et au mode opératoire.

2-1. Symboles utilisés

⚠ **DANGER!** – Indique une situation dangereuse qui si on l'évite pas peut donner la mort ou des blessures graves. Les dangers possibles sont montrés par les symboles joints ou sont expliqués dans le texte.

⚠ Indique une situation dangereuse qui si on l'évite pas peut donner la mort ou des blessures graves. Les dangers possibles sont montrés par les symboles joints ou sont expliqués dans le texte.

AVIS – Indique des déclarations pas en relation avec des blessures personnelles.

👉 Indique des instructions spécifiques.



Ce groupe de symboles veut dire Avertissement! Attention! DANGER DE CHOC ELECTRIQUE, PIECES EN MOUVEMENT, et PIECES CHAUDES. Reportez-vous aux symboles et aux directives ci-dessous afin de connaître les mesures à prendre pour éviter tout danger.

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

⚠ Les symboles présentés ci-après sont utilisés tout au long du présent manuel pour attirer votre attention et identifier les risques de danger. Lorsque vous voyez un symbole, soyez vigilant et suivez les directives mentionnées afin d'éviter tout danger. Les consignes de sécurité présentées ci-après ne font que résumer les informations contenues dans les principales normes de sécurité énumérées à la section 2-5. Veuillez lire et respecter toutes ces normes de sécurité.

⚠ L'installation, l'utilisation, l'entretien et les réparations ne doivent être confiés qu'à des personnes qualifiées. Une personne qualifiée est définie comme celle qui, par la possession d'un diplôme reconnu, d'un certificat ou d'un statut professionnel, ou qui, par une connaissance, une formation et une expérience approfondies, a démontré avec succès sa capacité à résoudre les problèmes liés à la tâche, le travail ou le projet et a reçu une formation en sécurité afin de reconnaître et d'éviter les risques inhérents.

⚠ Au cours de l'utilisation, tenir toute personne à l'écart et plus particulièrement les enfants.



UNE DÉCHARGE ÉLECTRIQUE peut entraîner la mort.

Le contact d'organes électriques sous tension peut provoquer des accidents mortels ou des brûlures graves. Le circuit de l'électrode et de la pièce est sous tension lorsque le courant est délivré à la sortie. Le circuit d'alimentation et les circuits internes de la machine sont également sous tension lorsque l'alimentation est sur Marche. Dans le mode de soudage avec du fil, le fil, le dérouleur, le bloc de commande du rouleau et toutes les parties

métalliques en contact avec le fil sont sous tension électrique. Un équipement installé ou mis à la terre de manière incorrecte ou impropre constitue un danger.

- Ne pas toucher aux pièces électriques sous tension.
- Porter des gants isolants et des vêtements de protection secs et sans trous.
- S'isoler de la pièce à couper et du sol en utilisant des housses ou des tapis assez grands afin d'éviter tout contact physique avec la pièce à couper ou le sol.
- Ne pas utiliser de sortie de soudage CA dans des zones humides ou confinées ou s'il y a un risque de chute.
- Se servir d'une source électrique à courant électrique UNIQUEMENT si le procédé de soudage le demande.
- Si l'utilisation d'une source électrique à courant électrique s'avère nécessaire, se servir de la fonction de télécommande si l'appareil en est équipé.

- D'autres consignes de sécurité sont nécessaires dans les conditions suivantes : risques électriques dans un environnement humide ou si l'on porte des vêtements mouillés ; sur des structures métalliques telles que sols, grilles ou échafaudages ; en position coincée comme assise, à genoux ou couchée ; ou s'il y a un risque élevé de contact inévitable ou accidentel avec la pièce à souder ou le sol. Dans ces conditions, utiliser les équipements suivants, dans l'ordre indiqué : 1) un poste à souder DC à tension constante (à fil), 2) un poste à souder DC manuel (électrode) ou 3) un poste à souder AC à tension à vide réduite. Dans la plupart des situations, l'utilisation d'un poste à souder DC à fil à tension constante est recommandée. En outre, ne pas travailler seul !
- Couper l'alimentation ou arrêter le moteur avant de procéder à l'installation, à la réparation ou à l'entretien de l'appareil. Déverrouiller l'alimentation selon la norme OSHA 29 CFR 1910.147 (voir normes de sécurité).
- Installez, mettez à la terre et utilisez correctement cet équipement conformément à son Manuel d'Utilisation et aux réglementations nationales, gouvernementales et locales.
- 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.
- En effectuant les raccordements d'entrée, fixer d'abord le conducteur de mise à la terre approprié et contre-vérifier les connexions.
- Les câbles doivent être exempts d'humidité, d'huile et de graisse; protégez-les contre les étincelles et les pièces métalliques chaudes.
- Vérifier fréquemment le cordon d'alimentation et le conducteur de mise à la terre afin de s'assurer qu'il n'est pas altéré ou dénudé -, le remplacer immédiatement s'il l'est -. Un fil dénudé peut entraîner la mort.
- L'équipement doit être hors tension lorsqu'il n'est pas utilisé.
- Ne pas utiliser des câbles usés, endommagés, de grosseur insuffisante ou mal épissés.
- Ne pas enrôler 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 provenant d'une autre machine.
- Ne pas toucher des porte électrodes connectés à deux machines en même temps à cause de la présence d'une tension à vide doublée.
- N'utiliser qu'un matériel en bon état. Réparer ou remplacer sur-le-champ les pièces endommagées. Entretien l'appareil conformément à ce manuel.

- Porter un harnais de sécurité si l'on doit travailler au-dessus du sol.
- S'assurer que tous les panneaux et couvercles sont correctement en place.
- Fixer le câble de retour de façon à obtenir un bon contact métal-métal avec la pièce à souder ou la table de travail, le plus près possible de la soudure.
- Isoler la pince de masse quand pas mis à la pièce pour éviter le contact avec tout objet métallique.
- Ne pas raccorder plus d'une électrode ou plus d'un câble de masse à une même borne de sortie de soudage. Débrancher le câble pour le procédé non utilisé.
- Utiliser une protection différentielle lors de l'utilisation d'un équipement auxiliaire dans des endroits humides ou mouillés.

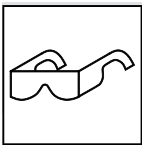
Il reste une TENSION DC NON NÉGLIGEABLE dans les sources de soudage onduleur UNE FOIS l'alimentation coupée.

- Éteignez l'unité, débranchez le courant électrique, et déchargez les condensateurs d'alimentation selon les instructions indiquées dans le manuel avant de toucher les pièces.



LES PIÈCES CHAUDES peuvent provoquer des brûlures.

- Ne pas toucher à mains nues les parties chaudes.
- Prévoir une période de refroidissement avant de travailler à l'équipement.
- Ne pas toucher aux pièces chaudes, utiliser les outils recommandés et porter des gants de soudage et des vêtements épais pour éviter les brûlures.



DES PIÈCES DE METAL ou DES SALETES peuvent provoquer des blessures dans les yeux.

- Le soudage, l'écaillage, le passage de la pièce à la brosse en fil de fer, et le meulage génèrent des étincelles et des particules métalliques volantes. Pendant la période de refroidissement des soudures, elles risquent de projeter du laitier.
- Porter des lunettes de sécurité avec écrans latéraux ou un écran facial.



LES FUMÉES ET LES GAZ peuvent être dangereux.

Le soudage génère des fumées et des gaz. Leur inhalation peut être dangereux pour votre santé.

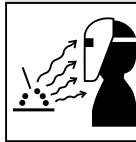
- Eloigner votre tête des fumées. Ne pas respirer les fumées.
- À l'intérieur, ventiler la zone et/ou utiliser une ventilation forcée au niveau de l'arc pour l'évacuation des fumées et des gaz de soudage. Pour déterminer la bonne ventilation, il est recommandé de procéder à un prélèvement pour la composition et la quantité de fumées et de gaz auxquelles est exposé le personnel.
- Si la ventilation est médiocre, porter un respirateur anti-vapeurs approuvé.
- Lire et comprendre les fiches de données de sécurité et les instructions du fabricant concernant les adhésifs, les revêtements, les nettoyants, les consommables, les produits de refroidissement, les dégraissants, les flux et les métaux.
- Travailler dans un espace fermé seulement s'il est bien ventilé ou en portant un respirateur à alimentation d'air. Demander toujours à un surveillant dûment formé de se tenir à proximité. Des fumées et des gaz de soudage peuvent déplacer l'air et abaisser le niveau d'oxygène provoquant des blessures ou des accidents mortels. S'assurer que l'air de respiration ne présente aucun danger.
- Ne pas souder dans des endroits situés 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 des métaux munis d'un revêtement, tels que l'acier galvanisé, plaqué en plomb ou au cadmium à moins que le revêtement n'ait été enlevé dans la zone de soudure, que l'endroit soit bien ventilé, et en portant un respirateur à alimentation d'air. Les revêtements et tous les métaux renfermant ces éléments peuvent dégager des fumées toxiques en cas de soudage.



LES ACCUMULATIONS DE GAZ risquent de provoquer des blessures ou même la mort.

- Fermer l'alimentation du gaz comprimé en cas de non utilisation.
- Veiller toujours à bien aérer les espaces confinés ou se servir d'un respirateur d'adduction d'air homologué.



LES RAYONS DE L'ARC peuvent provoquer des brûlures dans les yeux et sur la peau.

Le rayonnement de l'arc du procédé de soudage génère des rayons visibles et invisibles intenses (ultraviolets et infrarouges) susceptibles de provoquer des brûlures dans les yeux et sur la peau. Des étincelles sont projetées pendant le soudage.

- Porter un casque de soudage approuvé muni de verres filtrants approprié pour protéger visage et yeux pour protéger votre visage et vos yeux pendant le soudage ou pour regarder (voir ANSI Z49.1 et Z87.1 énuméré dans les normes de sécurité).
- Porter des lunettes de sécurité avec écrans latéraux même sous votre casque.
- Avoir recours à des écrans protecteurs ou à des rideaux pour protéger les autres contre les rayonnements les éblouissements et les étincelles ; prévenir toute personne sur les lieux de ne pas regarder l'arc.
- Porter un équipement de protection pour le corps fait d'un matériau résistant et ignifuge (cuir, coton robuste, laine). La protection du corps comporte des vêtements sans huile comme par ex. des gants de cuir, une chemise solide, des pantalons sans revers, des chaussures hautes et une casquette.

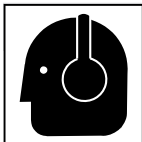


LE SOUDAGE peut provoquer un incendie ou une explosion.

Le soudage effectué sur des conteneurs fermés tels que des réservoirs, tambours ou des conduites peut provoquer leur éclatement. Des étincelles peuvent être projetées de l'arc de soudure. La projection d'étincelles, des pièces chaudes et des équipements chauds peut provoquer des incendies et des brûlures. Le contact accidentel de l'électrode avec des objets métalliques peut provoquer 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.

- Déplacer 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 homologuées.
- Ne pas souder dans un endroit où des étincelles peuvent tomber sur des substances inflammables.
- Se protéger et d'autres personnes de la projection d'étincelles et de métal chaud.
- Des étincelles et des matériaux chauds du soudage peuvent facilement passer dans d'autres zones en traversant de petites fissures et des ouvertures.
- Surveiller tout déclenchement d'incendie et tenir un extincteur à proximité.
- Le soudage effectué sur un plafond, plancher, paroi ou séparation peut déclencher un incendie de l'autre côté.

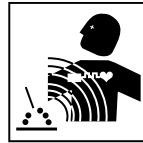
- Ne pas couper ou souder des jantes ou des roues. Les pneus peuvent exploser s'ils sont chauffés. Les jantes et les roues réparées peuvent défaillir. Voir OSHA 29 CFR 1910.177 énuméré dans les normes de sécurité.
- Ne pas effectuer le soudage sur des conteneurs fermés tels que des réservoirs, tambours, ou conduites, à moins qu'ils n'aient été préparés correctement conformément à AWS F4.1 et AWS A6.0 (voir les Normes de Sécurité).
- Ne pas souder là où l'air ambiant pourrait contenir des poussières, gaz ou émanations inflammables (vapeur d'essence, par exemple).
- Brancher le câble de masse sur la pièce la plus près possible de la zone de soudage pour éviter le transport du courant sur une longue distance par des chemins inconnus éventuels en provoquant des risques d'électrocution, d'étincelles 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 à la pointe de contact.
- Porter un équipement de protection pour le corps fait d'un matériau résistant et ignifuge (cuir, coton robuste, laine). La protection du corps comporte des vêtements sans huile comme par ex. des gants de cuir, une chemise solide, des pantalons sans revers, des chaussures hautes et une casquette.
- Avant de souder, retirer toute substance combustible de vos poches telles qu'un allumeur au butane ou des allumettes.
- Une fois le travail achevé, assurez-vous qu'il ne reste aucune trace d'étincelles incandescentes ni de flammes.
- Utiliser exclusivement des fusibles ou coupe-circuits appropriés. Ne pas augmenter leur puissance; ne pas les ponter.
- Suivre les recommandations dans OSHA 1910.252 (a) (2) (iv) et NFPA 51B pour les travaux à chaud et avoir de la surveillance et un extincteur à proximité.
- Lire et comprendre les fiches de données de sécurité et les instructions du fabricant concernant les adhésifs, les revêtements, les nettoyants, les consommables, les produits de refroidissement, les dégraisseurs, les flux et les métaux.



LE BRUIT peut endommager l'ouïe.

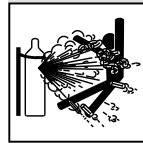
Le bruit des processus et des équipements peut affecter l'ouïe.

- Porter des protections approuvées pour les oreilles si le niveau sonore est trop élevé.



Les CHAMPS ÉLECTROMAGNÉTIQUES (CEM) peuvent affecter les implants médicaux.

- Les porteurs de stimulateurs cardiaques et autres implants médicaux doivent rester à distance.
- Les porteurs d'implants médicaux doivent consulter leur médecin et le fabricant du dispositif avant de s'approcher de la zone où se déroule du soudage à l'arc, du soudage par points, du gougeage, de la découpe plasma ou une opération de chauffage par induction.



LES BOUTEILLES peuvent exploser si elles sont endommagées.

Les bouteilles de gaz comprimé contiennent du gaz sous haute pression. Si une bouteille est endommagée, elle peut exploser. Du fait que les bouteilles de gaz font normalement partie du procédé de soudage, les manipuler avec précaution.

- Protéger les bouteilles de gaz comprimé d'une chaleur excessive, des chocs mécaniques, des dommages physiques, du laitier, des flammes ouvertes, 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 placer une torche de soudage sur une bouteille à gaz.
- Une électrode de soudage ne doit jamais entrer en contact avec une bouteille.
- Ne jamais souder une bouteille pressurisée - risque d'explosion.
- Utiliser seulement des bouteilles de gaz comprimé, régulateurs, tuyaux et raccords convenables pour cette application spécifique; les maintenir ainsi que les éléments associés en bon état.
- Tourner le dos à la sortie de vanne lors de l'ouverture de la vanne de la bouteille. Ne pas se tenir devant ou derrière le régulateur lors de l'ouverture de la vanne.
- Le couvercle du détendeur doit toujours être en place, sauf lorsque la bouteille est utilisée ou qu'elle est reliée pour usage ultérieur.
- Utilisez les équipements corrects, les bonnes procédures et suffisamment de personnes pour soulever, déplacer et transporter les bouteilles.
- Lire et suivre les instructions sur les bouteilles de gaz comprimé, l'équipement connexe et le dépliant P-1 de la CGA (Compressed Gas Association) mentionné dans les principales normes de sécurité.

2-3. Symboles de dangers supplémentaires en relation avec l'installation, le fonctionnement et la maintenance



Risque D'INCENDIE OU D'EXPLOSION.

- Ne pas placer l'appareil sur, au-dessus ou à proximité de surfaces inflammables.
- 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'ÉQUIPEMENT peut provoquer des blessures.

- Utiliser l'anneau de levage uniquement pour soulever l'appareil, NON PAS les chariots, les bouteilles de gaz ou tout autre accessoire.
- Utilisez les procédures correctes et des équipements d'une capacité appropriée pour soulever et supporter l'appareil.
- En utilisant des fourches de levage pour déplacer l'unité, s'assurer que les fourches sont suffisamment longues pour dépasser du côté opposé de l'appareil.
- Tenir l'équipement (câbles et cordons) à distance des véhicules mobiles lors de toute opération en hauteur.

- Suivre les consignes du Manuel des applications pour l'équation de levage NIOSH révisée (Publication N°94-110) lors du levage manuel de pièces ou équipements lourds.



L'EMPLOI EXCESSIF peut SURCHAUFFER L'ÉQUIPEMENT.

- Prévoir une période de refroidissement ; respecter le cycle opératoire nominal.
- Réduire le courant ou le facteur de marche avant de poursuivre le soudage.
- Ne pas obstruer les passages d'air du poste.



LES ÉTINCELLES PROJETÉES peuvent provoquer des blessures.

- Porter un écran facial pour protéger le visage et les yeux.
- Affûter l'électrode au tungstène uniquement à la meuleuse dotée de protecteurs. Cette manœuvre est à exécuter dans un endroit sûr lorsque l'on porte l'équipement homologué de protection du visage, des mains et du corps.
- Les étincelles risquent de causer un incendie - éloigner toute substance inflammable.



LES CHARGES ÉLECTROSTATIQUES peuvent endommager les circuits imprimés.

- Établir la connexion avec la barrette de terre 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.

- Ne pas s'approcher des organes mobiles.
- Ne pas s'approcher des points de coincement tels que des rouleaux de commande.



LES FILS DE SOUDAGE peuvent provoquer des blessures.

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



L'EXPLOSION DE LA BATTERIE peut provoquer des blessures.

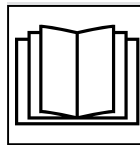
- Ne pas utiliser l'appareil de soudage pour charger des batteries ou faire démarrer des véhicules à l'aide de câbles de démarrage, sauf si l'appareil dispose d'une fonctionnalité de charge de batterie destinée à cet usage.



Les PIÈCES MOBILES peuvent causer des blessures.

- S'abstenir de toucher des organes mobiles tels que des ventilateurs.
- Maintenir fermés et verrouillés les portes, panneaux, recouvrements et dispositifs de protection.

- Lorsque cela est nécessaire pour des travaux d'entretien et de dépannage, faire retirer les portes, panneaux, recouvrements ou dispositifs de protection uniquement par du personnel qualifié.
- Remettre les portes, panneaux, recouvrements ou dispositifs de protection quand l'entretien est terminé et avant de rebrancher l'alimentation électrique.

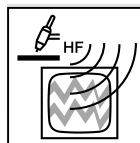


LIRE LES INSTRUCTIONS.

- Lire et appliquer les instructions sur les étiquettes et le Mode d'emploi avant l'installation, l'utilisation ou l'entretien de l'appareil. Lire les informations de sécurité au début du manuel et dans chaque

section.

- N'utiliser que les pièces de rechange recommandées par le constructeur.
- Effectuer l'installation, l'entretien et toute intervention selon les manuels d'utilisateurs, les normes nationales, provinciales et de l'industrie, ainsi que les codes municipaux.



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

- Le rayonnement haute fréquence (H.F.) peut provoquer des interférences avec les équipements de radio-navigation et de communication, les services de sécurité et les ordinateurs.
- Demander seulement à des personnes qualifiées familiarisées avec des équipements électroniques de faire fonctionner l'installation.
- L'utilisateur est tenu de faire corriger rapidement par un électricien qualifié les interférences résultant de l'installation.
- Si le FCC signale des interférences, arrêter immédiatement l'appareil.
- Effectuer régulièrement le contrôle et l'entretien de l'installation.
- Maintenir soigneusement fermés les portes et les panneaux des sources de haute fréquence, maintenir les éclateurs à une distance correcte et utiliser une terre et un blindage pour réduire les interférences éventuelles.



LE SOUDAGE À L'ARC risque de provoquer des interférences.

- L'énergie électromagnétique risque de provoquer des interférences pour 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 électromagnétiquement.
- Pour réduire la possibilité d'interférence, maintenir les câbles de soudage aussi courts que possible, les grouper, et les poser aussi bas que possible (ex. par terre).
- Veiller à souder à une distance de 100 mètres de tout équipement électronique sensible.
- Veiller à ce que ce poste de soudage soit posé et mis à la terre conformément à ce mode d'emploi.
- En cas d'interférences après avoir pris les mesures 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.

2-4. Proposition californienne 65 Avertissements

⚠️ AVERTISSEMENT – Ce produit peut vous exposer à des produits chimiques tels que le plomb, reconnus par l'État de Californie comme cancérigènes et sources de malformations ou d'autres troubles de la reproduction.

Pour plus d'informations, consulter www.P65Warnings.ca.gov.

2-5. Principales normes de sécurité

Safety in Welding, Cutting, and Allied Processes, American Welding Society standard ANSI Standard Z49.1. Website: <http://www.aws.org>.

Safe Practice For Occupational And Educational Eye And Face Protection, ANSI Standard Z87.1, from American National Standards Institute. Website: www.ansi.org.

Safe Practices for the Preparation of Containers and Piping for Welding and Cutting, American Welding Society Standard AWS F4.1 from Global Engineering Documents. Website: www.global.ihs.com.

Safe Practices for Welding and Cutting Containers that have Held Combustibles, American Welding Society Standard AWS A6.0 from Global Engineering Documents. Website: www.global.ihs.com.

National Electrical Code, NFPA Standard 70 from National Fire Protection Association. Website: www.nfpa.org and www.sparky.org.

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1 from Compressed Gas Association. Website: www.cganet.com.

Safety in Welding, Cutting, and Allied Processes, CSA Standard W117.2 from Canadian Standards Association. Website: www.csagroup.org.

Standard for Fire Prevention During Welding, Cutting, and Other Hot Work, NFPA Standard 51B from National Fire Protection Association. Website: www.nfpa.org.

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910.177 Subpart N, Part 1910 Subpart Q, and Part 1926, Subpart J. Website: www.osha.gov.

OSHA *Important Note Regarding the ACGIH TLV, Policy Statement on the Uses of TLVs and BEIs*. Website: www.osha.gov.

Applications Manual for the Revised NIOSH Lifting Equation from the National Institute for Occupational Safety and Health (NIOSH). Website: www.cdc.gov/NIOSH.

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2-6. Informations relatives aux CEM

Le courant électrique qui traverse tout conducteur génère des champs électromagnétiques (CEM) à certains endroits. Le courant issu d'un soudage à l'arc (et de procédés connexes, y compris le soudage par points, le gougeage, le découpage plasma et les opérations de chauffage par induction) crée un champ électromagnétique (CEM) autour du circuit de soudage. Les champs électromagnétiques produits peuvent causer interférence à certains implants médicaux, p. ex. les stimulateurs cardiaques. Des mesures de protection pour les porteurs d'implants médicaux doivent être prises: par exemple, des restrictions d'accès pour les passants ou une évaluation individuelle des risques pour les soudeurs. Tous les soudeurs doivent appliquer les procédures suivantes pour minimiser l'exposition aux CEM provenant du circuit de soudage:

1. Rassembler les câbles en les torsadant ou en les attachant avec du ruban adhésif ou avec une housse.
2. Ne pas se tenir au milieu des câbles de soudage. Disposer les câbles d'un côté et à distance de l'opérateur.

3. Ne pas courber et ne pas entourer les câbles autour de votre corps.
4. Maintenir la tête et le torse aussi loin que possible du matériel du circuit de soudage.
5. Connecter la pince sur la pièce aussi près que possible de la soudure.
6. Ne pas travailler à proximité d'une source de soudage, ni s'asseoir ou se pencher dessus.
7. Ne pas souder tout en portant la source de soudage ou le dévidoir.





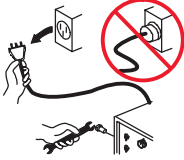



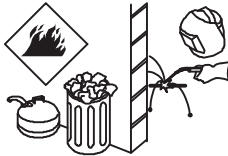
En ce qui concerne les implants médicaux :





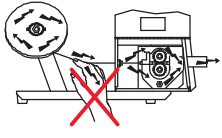

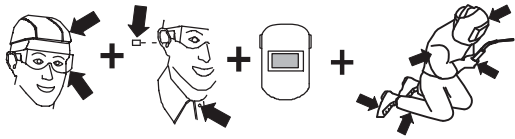
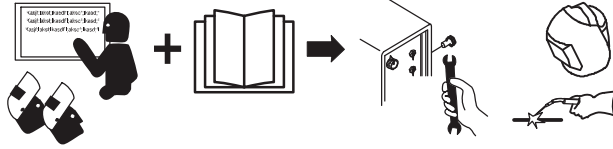
Les porteurs d'implants doivent d'abord consulter leur médecin avant de s'approcher des opérations de soudage à l'arc, de soudage par points, de gougeage, du coupage plasma ou de chauffage par induction. Si le médecin approuve, il est recommandé de suivre les procédures précédentes.

SECTION 3 – DEFINITIONS






3-1. Additional Safety Symbol Definitions




Some symbols are found only on CE products.




	<p>Warning! Watch Out! There are possible hazards as shown by the symbols.</p>
	<p>Do not discard product (where applicable) with general waste. Reuse or recycle Waste Electrical and Electronic Equipment (WEEE) by disposing at a designated collection facility. Contact your local recycling office or your local distributor for further information.</p>
	<p>Wear dry insulating gloves. Do not touch electrode with bare hand. Do not wear wet or damaged gloves.</p>
	<p>Protect yourself from electric shock by insulating yourself from work and ground.</p>
	<p>Disconnect input plug or power before working on machine.</p>
	<p>Keep your head out of the fumes.</p>
	<p>Use forced ventilation or local exhaust to remove the fumes.</p>
	<p>Use ventilating fan to remove fumes.</p>
	<p>Keep flammables away from welding. Do not weld near flammables.</p>




	<p>Welding sparks can cause fires. Have a fire extinguisher nearby, and have a watchperson ready to use it.</p>
	<p>Do not weld on drums or any closed containers.</p>
	<p>Do not remove or paint over (cover) the label.</p>
	<p>Drive rolls can injure fingers.</p>
	<p>Welding wire and drive parts are at welding voltage during operation - keep hands and metal objects away.</p>
	<p>Pinch points can injure.</p>
	<p>Wear hat and safety glasses. Use ear protection and button shirt collar. Use welding helmet with correct shade of filter. Wear complete body protection.</p>
	<p>Become trained and read the instructions before working on the machine or welding.</p>

3-2. Miscellaneous Symbols And Definitions

<p>A</p>	<p>Amperage</p>	<p>IP</p>	<p>Degree Of Protection</p>		<p>Input</p>
<p>V</p>	<p>Voltage</p>		<p>Increase</p>		<p>Output</p>
	<p>Direct Current (DC)</p>		<p>Gas Input</p>	<p>%</p>	<p>Percent</p>

	Purge By Gas
I_2	Rated Welding Current
	Line Connection
	Cold Jog (Inch) Towards Workpiece

	Trigger Hold On
	Gas Metal Arc Welding (GMAW) Gun
U_1	Primary Voltage
	Filter

	Arc Control
	Read Instructions
	Voltage Sense Input

SECTION 4 – SPECIFICATIONS

4-1. Serial Number And Rating Label Location

The serial number and rating information for this product is located on the back. Use rating label to determine input power requirements and/or rated output. For future reference, write serial number in space provided on back cover of this manual.

4-2. Software Licensing Agreement

The End User License Agreement and any third-party notices and terms and conditions pertaining to third-party software can be found at <https://www.millerwelds.com/eula> and are incorporated by reference herein.

4-3. Information About Default Weld Parameters And Settings

NOTICE – Each welding application is unique. Although certain Miller Electric products are designed to determine and default to certain typical welding parameters and settings based upon specific and relatively limited application variables input by the end user, such default settings are for reference purposes only; and final weld results can be affected by other variables and application-specific circumstances. The appropriateness of all parameters and settings should be evaluated and modified by the end user as necessary based upon application-specific requirements. The end user is solely responsible for selection and coordination of appropriate equipment, adoption or adjustment of default weld parameters and settings, and ultimate quality and durability of all resultant welds. Miller Electric expressly disclaims any and all implied warranties including any implied warranty of fitness for a particular purpose.

4-4. Specifications

Input Power	Welding Power Source Type	Wire Feed Speed Range*	Wire Diameter Range	Welding Circuit Rating	Overall Dimensions	Weight
50 VDC	Deltaweld 350 Deltaweld 500	Standard: 50-780 ipm (1.3-19.8mpm)	.023 To 5/64 in. (0.6 To 2 mm) Max Spool Capacity: 18 in. (457 mm) Max Spool Weight: 60 lb (27 kg)	113 Volts DC 600 Amperes, 60% Duty Cycle	Height: 16-1/4 in. (413 mm) Width: 12-3/8 in. (314 mm) Length: 27-7/8 in.(708 mm)	44.8 lb (20.3 kg)

4-5. Environmental Specifications



A. IP Rating

IP Rating
IP2X
This equipment is designed for indoor use and is not intended to be used or stored outside.





B. Temperature Specifications

Operating Temperature Range	Storage/Transportation Temperature Range
14 to 104°F (-10 to 40°C)	-4 to 131°F (-20 to 55°C)

4-6. Duty Cycle And Overheating

60% Duty Cycle At 600 Amperes



→



6 Minutes Welding

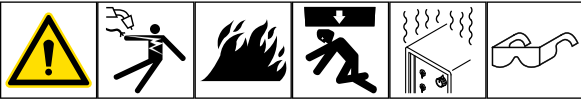
4 Minutes Resting

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

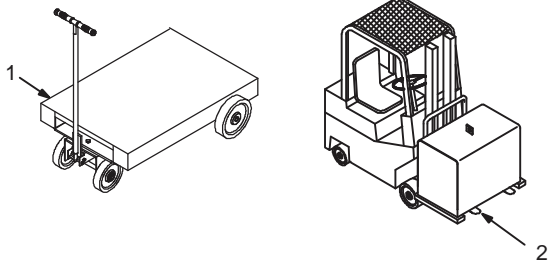
NOTICE – Exceeding duty cycle can damage unit and void warranty.

SECTION 5 – INSTALLATION

5-1. Selecting A Location



Movement



- Do not put feeder where welding wire hits cylinder.
- Do not move or operate unit where it could tip.
- Special installation may be required where gasoline or volatile liquids are present — see NEC Article 511 or CEC Section 20.

- 1 Hand Cart
- 2 Lifting Forks

Use cart or similar device to move unit.

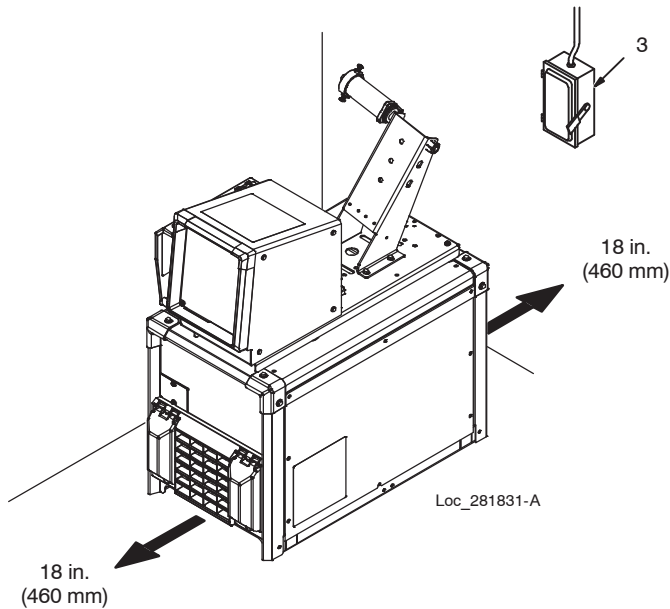
If using lifting forks, extend forks beyond opposite side of unit.

- 3 Line Disconnect Device

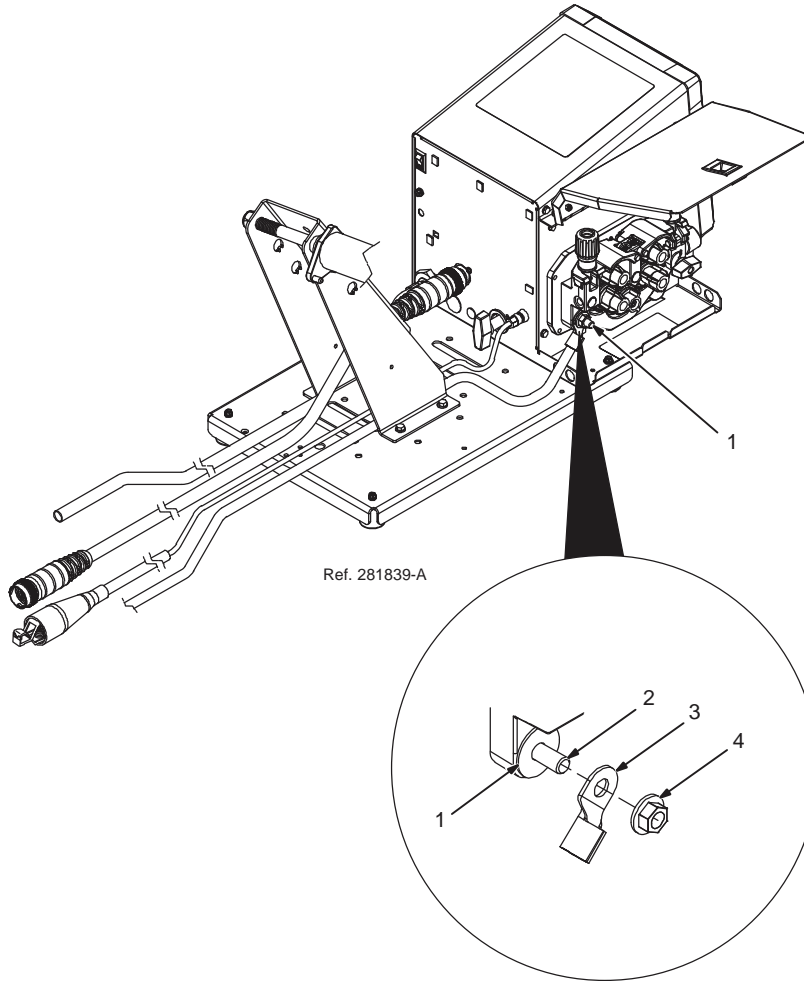
Locate unit near correct input power supply.





Location And Airflow



5-2. Connecting Weld Output Cable




 Turn off power before connecting to weld terminal or receptacle.

 Failure to properly connect weld cables may cause excessive heat and start a fire, or damage your machine.

Ensure all connections are tight.

Weld Cable Connection

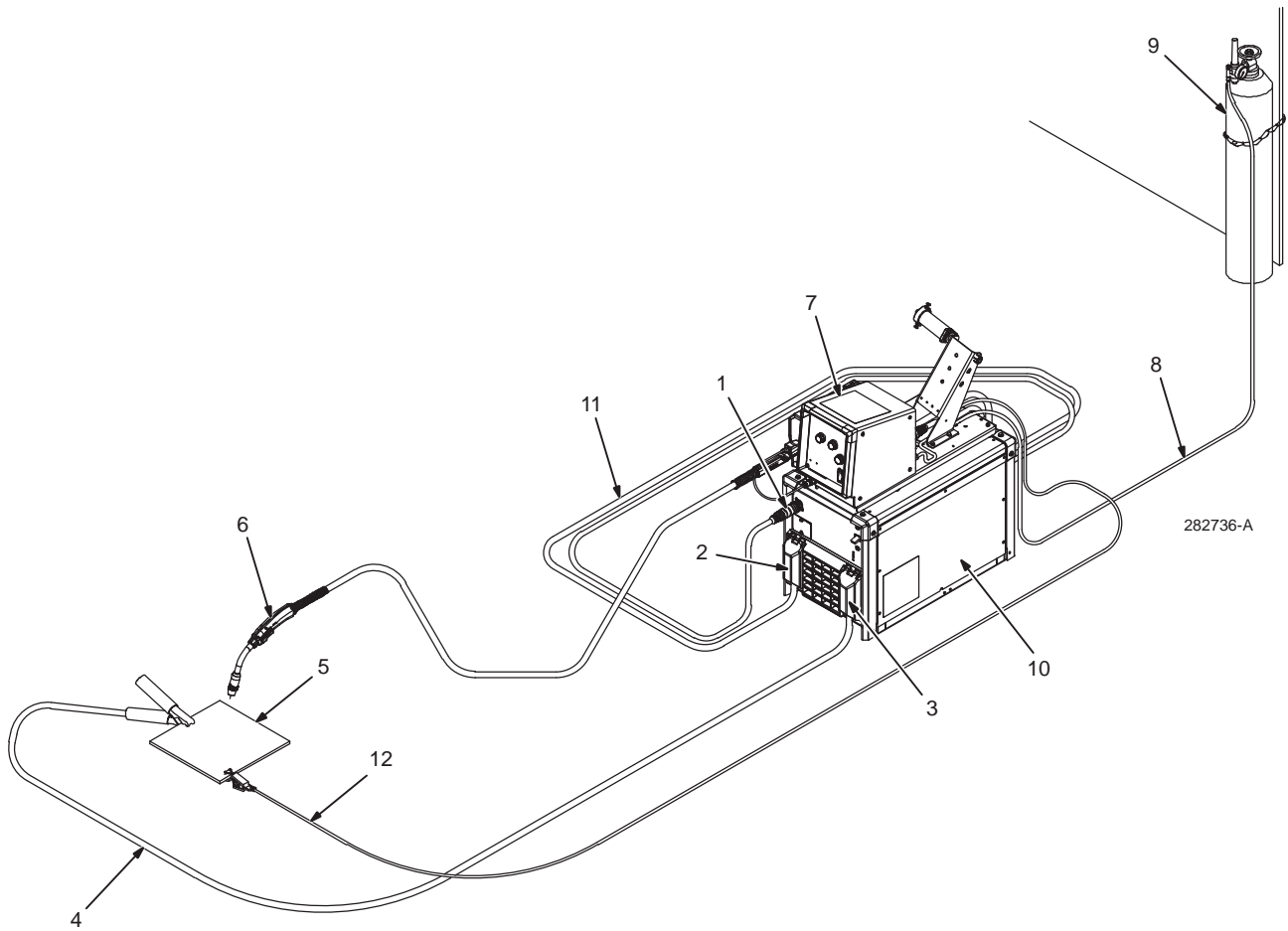
 Do not place anything between weld cable terminal and weld terminal. Make sure that all surfaces are clean.

- 1 Weld Terminal
- 2 Weld Terminal Bolt
- 3 Weld Cable Terminal
- 4 Supplied Nut

Remove supplied nut from weld terminal. Install cable on weld terminal bolt. Screw nut onto bolt and tighten to 250 in lb (28.2 N·m).



5-3. Connection Diagram



⚠ Turn off power before making connections.

- | | |
|-------------------------------------|-------------------------------|
| 1 Wire Feeder Cable | 7 Wire Feeder |
| 2 Positive (+) Weld Output Terminal | 8 Gas Hose |
| 3 Negative (-) Weld Output Terminal | 9 Gas Cylinder |
| 4 Work Cable | 10 Welding Power Source |
| 5 Workpiece | 11 Electrode Cable |
| 6 Welding Gun | 12 Volt Sense Lead (Optional) |

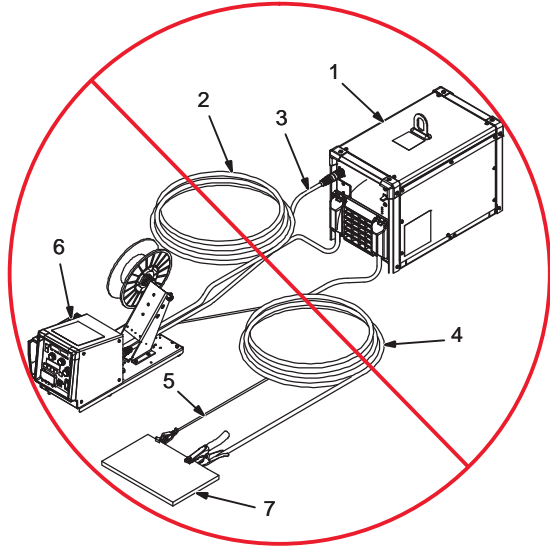
Use of shielding gas is dependant on Wire Type.

☞ The connection diagram illustrates DCEP (reverse polarity) suitable for all wires except self-shielded FCAW. The majority of self-shielded FCAW wires require DCEN (straight polarity).

5-4. Arranging Welding Cables To Reduce Welding Circuit Inductance



Bad

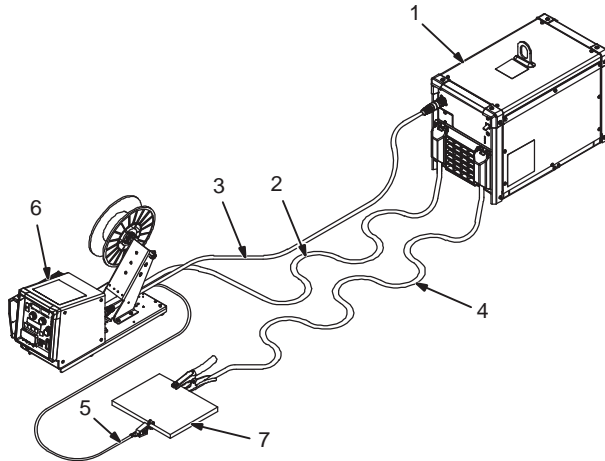


- 1 Welding Power Source
- 2 Electrode Cable
- 3 Feeder Cable
- 4 Work Cable
- 5 Voltage Sense Lead
- 6 Wire Feeder
- 7 Workpiece

The arrangement of the cables has an effect that is significant to the welding properties. As an example, Accupulse welding process can produce high welding circuit inductance depending on cable length and arrangement. This can result in limited current rise during droplet transfer into the welding puddle.

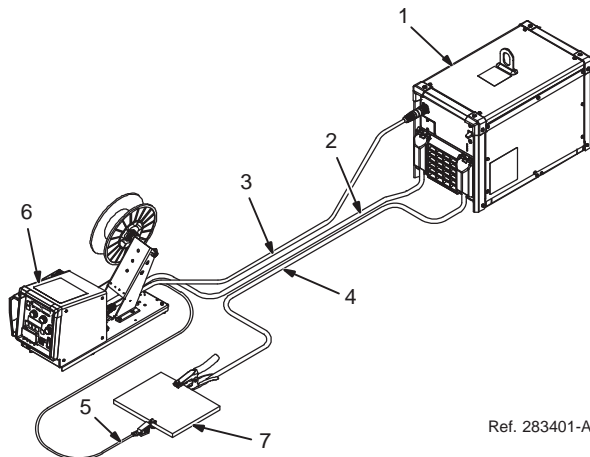
The work sense lead connects to the rear of the wire feeder. This work sense lead automatically compensates for work cable voltage drop when connected.

Better



Do not coil excess cables. Use cables that are the appropriate length for the application. Whenever using long weld cables [longer than 50 ft (15 m)] try to arrange positive and negative weld cables together to reduce the magnetic field surrounding the cables. Avoid coupling the feeder and work sense leads with the weld cables.


Best



Ref. 283401-A

5-5. Control Cable Connections



 **Turn off power before connecting control cables.**

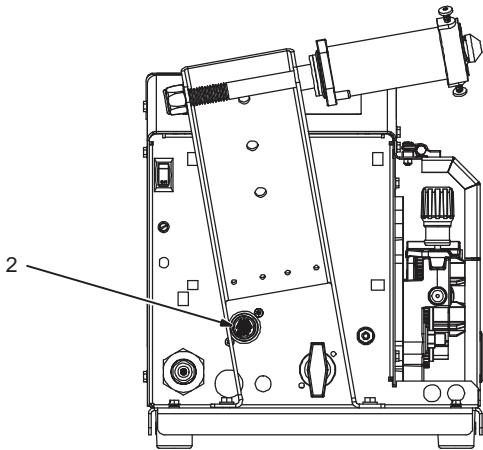
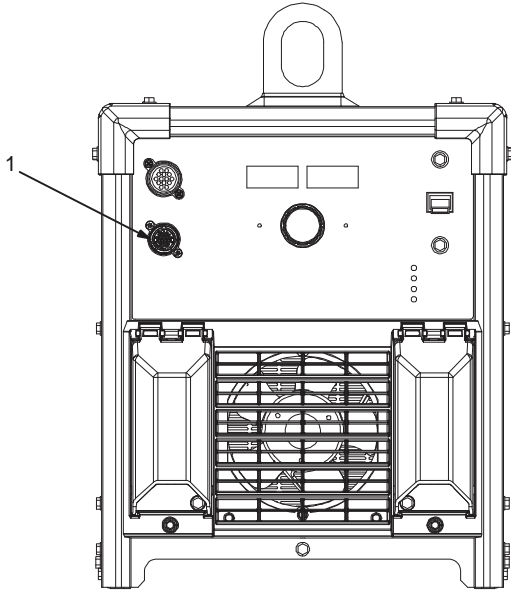
Welding Power Source Front View

1 Remote ArcConnect Receptacle RC2

Wire Feeder Rear View

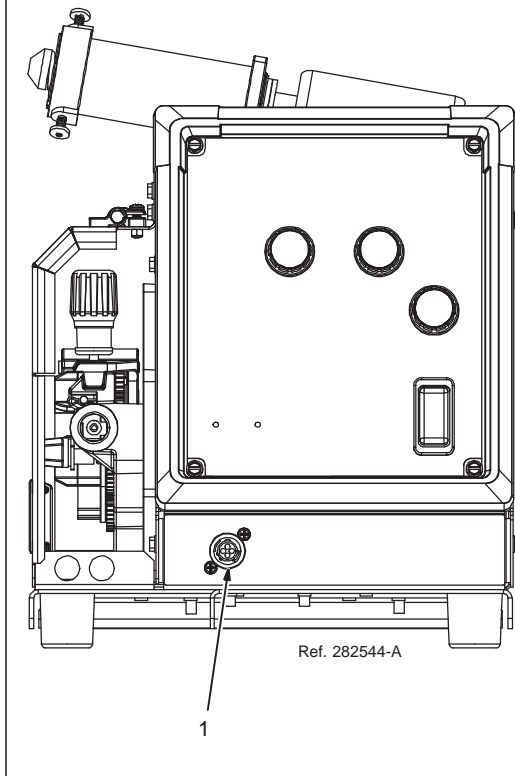
2 Remote ArcConnect Receptacle RC1

Connect control cable between receptacle RC2 on front of welding power source to receptacle RC1 on rear of wire feeder.



Ref. 280823-A / Ref. 281841-A

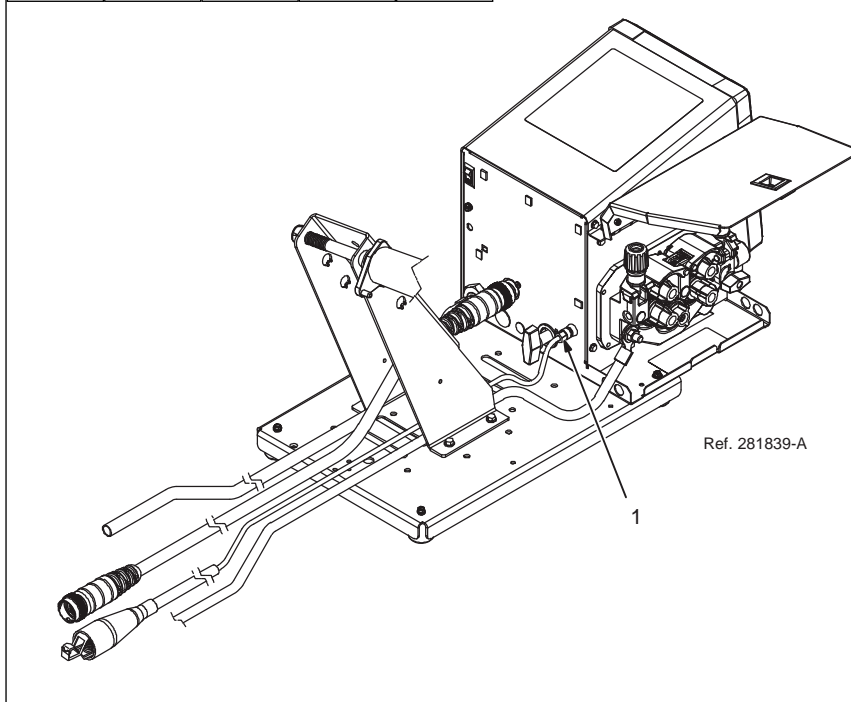
5-6. Wire Feeder Lower Front Panel Connections



1 4-socket Gun Trigger Receptacle RC2

Connect gun trigger plug to receptacle RC2 on lower front panel on wire feeder.

5-7. Weld Voltage Sense Connection (Optional)

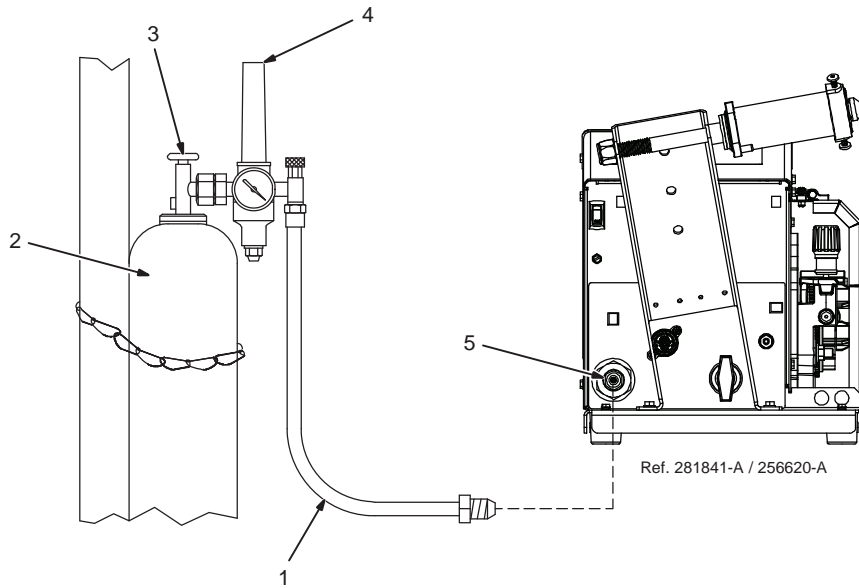
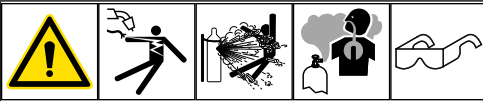


1 Weld Voltage Sense Receptacle RC3

Connect voltage sense lead from weld voltage sense receptacle RC3 on rear of wire feeder to work piece (see Sections 5-3 and 5-4) for more information.

Connecting sense lead is optional as required by desired weld process.

5-8. Connecting Shielding Gas



NOTICE – This feeder has a shielding gas filter that requires special attention when cleaning. See Section 7-2 for proper cleaning instructions.

1 Gas Hose With 5/8-18 Right-hand Thread Fittings (Customer Supplied)

☞ Tighten gas hose fitting to a maximum of 100 in. lbs (12 Nm).

2 Shielding Gas Cylinder

☞ Shielding gas pressure not to exceed 100 psi (689 kPa).

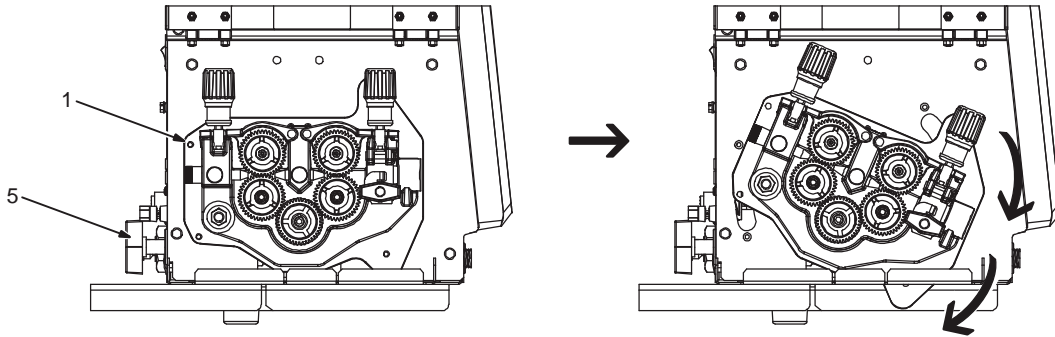
3 Valve

4 Flowmeter

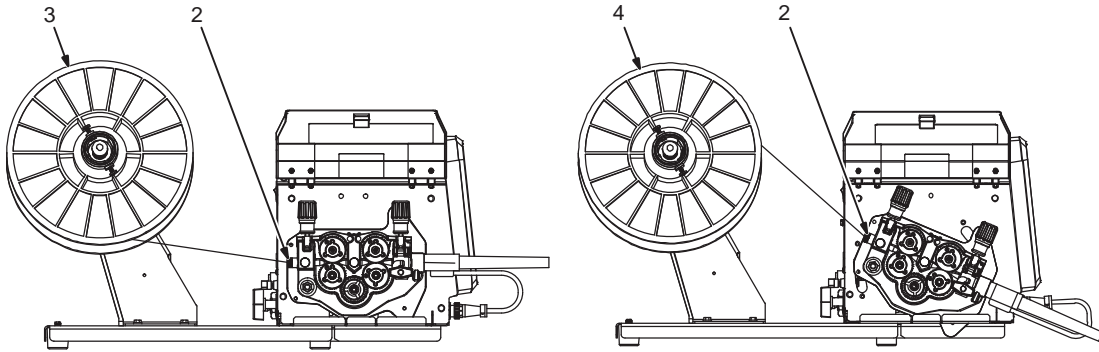
5 Shielding Gas Fitting

Close valve on cylinder when finished welding.

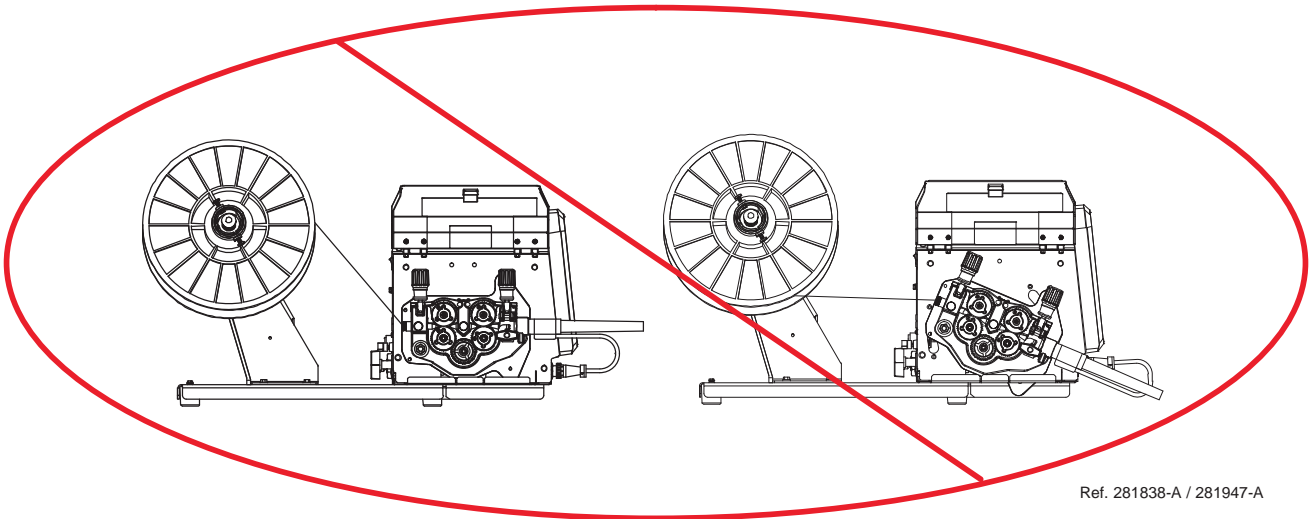
5-9. Rotating Drive Assembly



Good



Bad



Ref. 281838-A / 281947-A

1 Drive Assembly

2 Wire Drive Assembly Angle

Rotate the drive assembly to reduce bends in the MIG gun cable.

3 Wire Feeding Off Bottom Of Spool

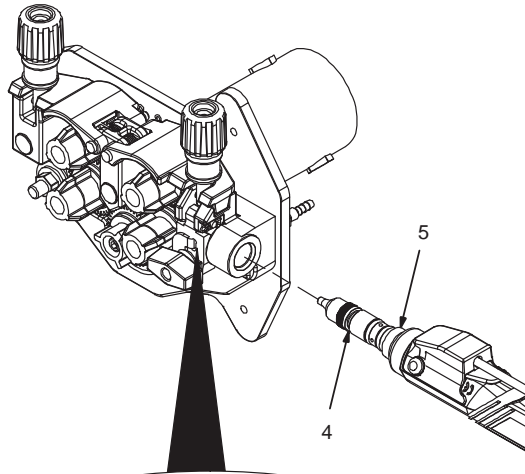
4 Wire Feeding Off Top Of Spool

Wire can be setup to feed off either the top or bottom of wire spool. Select the option that results in the straightest possible path into drive assembly.

5 Drive Assembly Rotation Knob

To rotate the drive assembly, loosen drive assembly rotation knob, rotate drive assembly to desired position and tighten knob to secure.

5-10. Installing Welding Gun



- 1 Power Clamp Knob
- 2 Gun Locking Tab
- 3 Gun Locking Tab Rotated 180 Degrees
- 4 Power Pin Groove
- 5 Gun Connection End
- 6 Installing Gun With Accu-Mate Connection

Loosen power clamp knob to allow power pin of gun to clear the gun locking tab.

Push power pin into power clamp as far as possible to align the groove in the power pin of the gun with the gun locking tab.

Secure gun by tightening power clamp knob.

- 7 Installing Gun Without Accu-Mate Connection

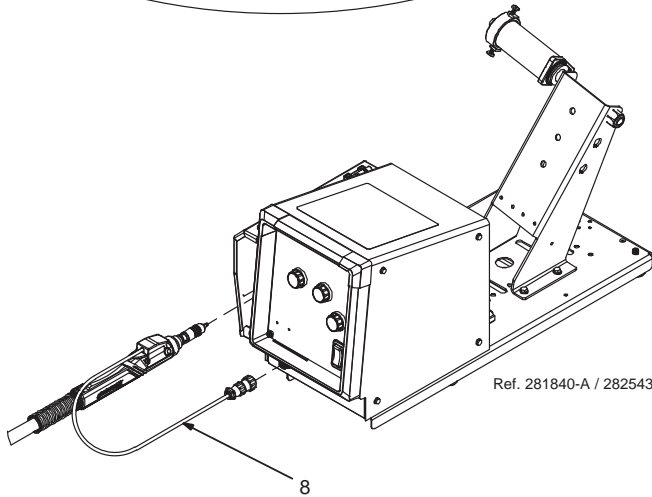
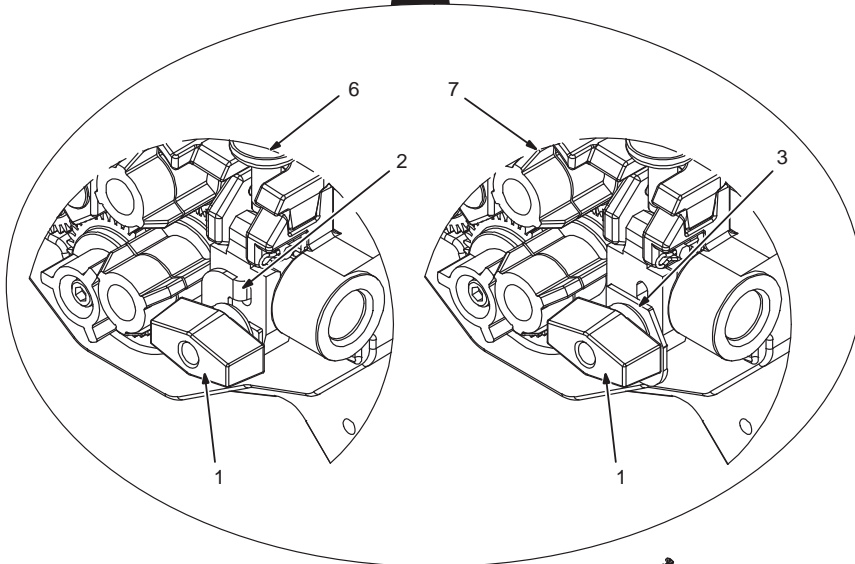
When using a gun without the groove in the power pin, loosen power clamp knob and rotate gun locking tab 180 degrees. This prevents the locking tab from extending into the power pin gun connection.

Push power pin into power clamp as far as possible.

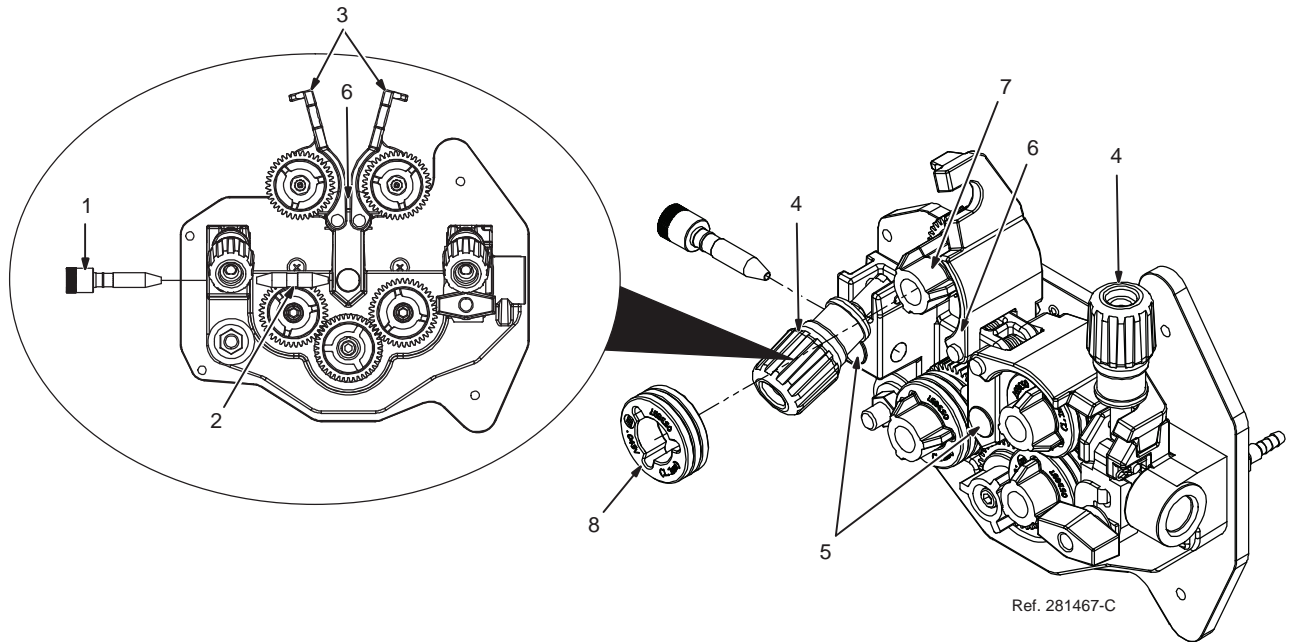
Secure gun by tightening power clamp knob.

- 8 Gun Control Cable

Insert plug into Gun Control receptacle, and tighten threaded collar.



5-11. Installing Wire Guides And Drive Rolls



Installing Wire Guides

- 1 Inlet Wire Guide
- 2 Intermediate Wire Guide
- 3 Upper Drive Roll Carrier
- 4 Drive Roll Pressure Adjustment Knob
- 5 Wire Guide Securing Button

Open upper drive roll carriers by grasping drive roll pressure adjustment knob and pull out and down. Carrier will spring open. Repeat for other carrier.

Insert inlet wire guide into wire entry as shown. Push into place to secure. Repeat procedure for intermediate guide.

To remove wire guides, push on wire guide securing button and remove guide.

Installing Drive Rolls

- 6 Drive Roll Carrier
- 7 Drive Roll Retaining Nut
- 8 Drive Roll

With upper drive roll carriers open, slide drive roll onto carrier. Rotate drive roll

retaining nut one click to secure in place. Repeat procedure for remaining drive rolls.

To remove drive rolls reverse procedure.

Aligning Wire Guide And Drive Rolls

Self-aligning drive rolls do not require any manual adjustment.

Cleaning Drive Rolls

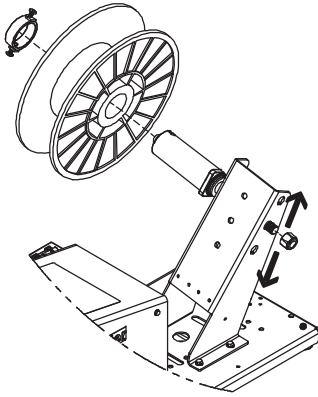
Remove drive rolls, and clean grooves using a wire brush.

Close drive assembly cover.

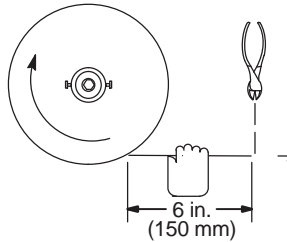
5-12. Installing And Threading Welding Wire



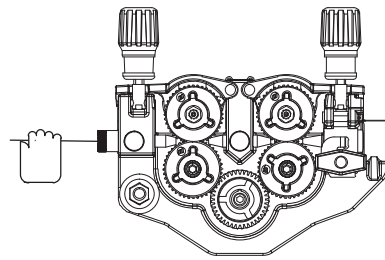
1



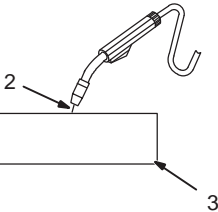
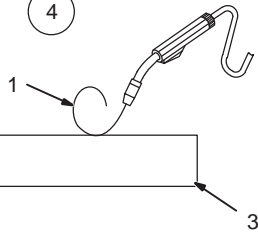
2



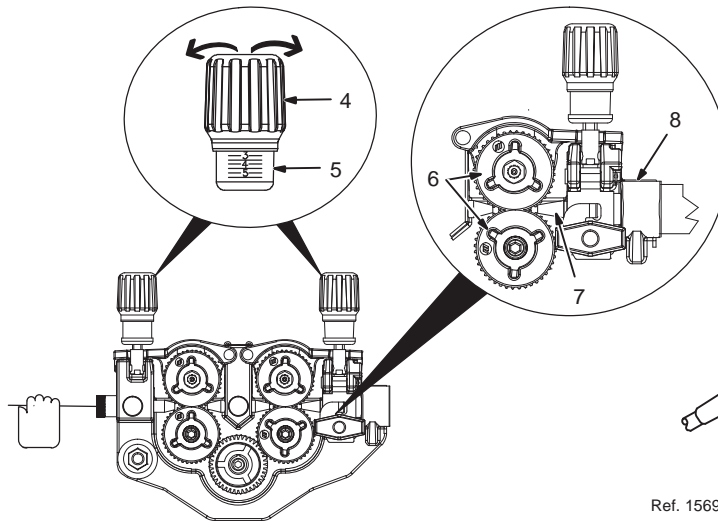
3



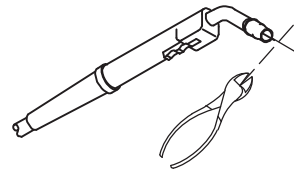
4



5



6



Ref. 156929-A / 281838-A / 242517-A



Verify correct drive rolls are installed.

- 1 Example Of No Wire Slippage
- 2 Example Of Wire Slippage
- 3 Nonconductive Surface
- 4 Pressure Adjust Knob
- 5 Pressure Indicator Scale
- 6 Drive Rolls
- 7 End Of Liner
- 8 Back Of Gun

Step 1. Select wire spool hub mounting position. Install wire spool. Adjust tension nut so wire is taut when wire feed stops.

Step 2. Pull and hold wire. Cut off end of wire.

Hold wire tightly to keep it from unraveling.

Step 3. Push wire through guides up to drive rolls; continue to hold wire.

Install gun. Lay gun cable out straight. Cut off end of wire. Push wire through guides up to drive rolls; continue to hold wire. Press Jog button to feed wire out gun.

For best wire feeding performance, be sure that the outlet cable has the proper size liner for the welding wire size being used. Also, when the gun is installed, the liner extending from the back of the gun should be as close to the drive rolls as possible, without touching.

Step 4. To adjust drive roll pressure, begin by holding nozzle about 2 in. (51 mm) from nonconductive surface and pressing gun trigger to feed wire against surface.

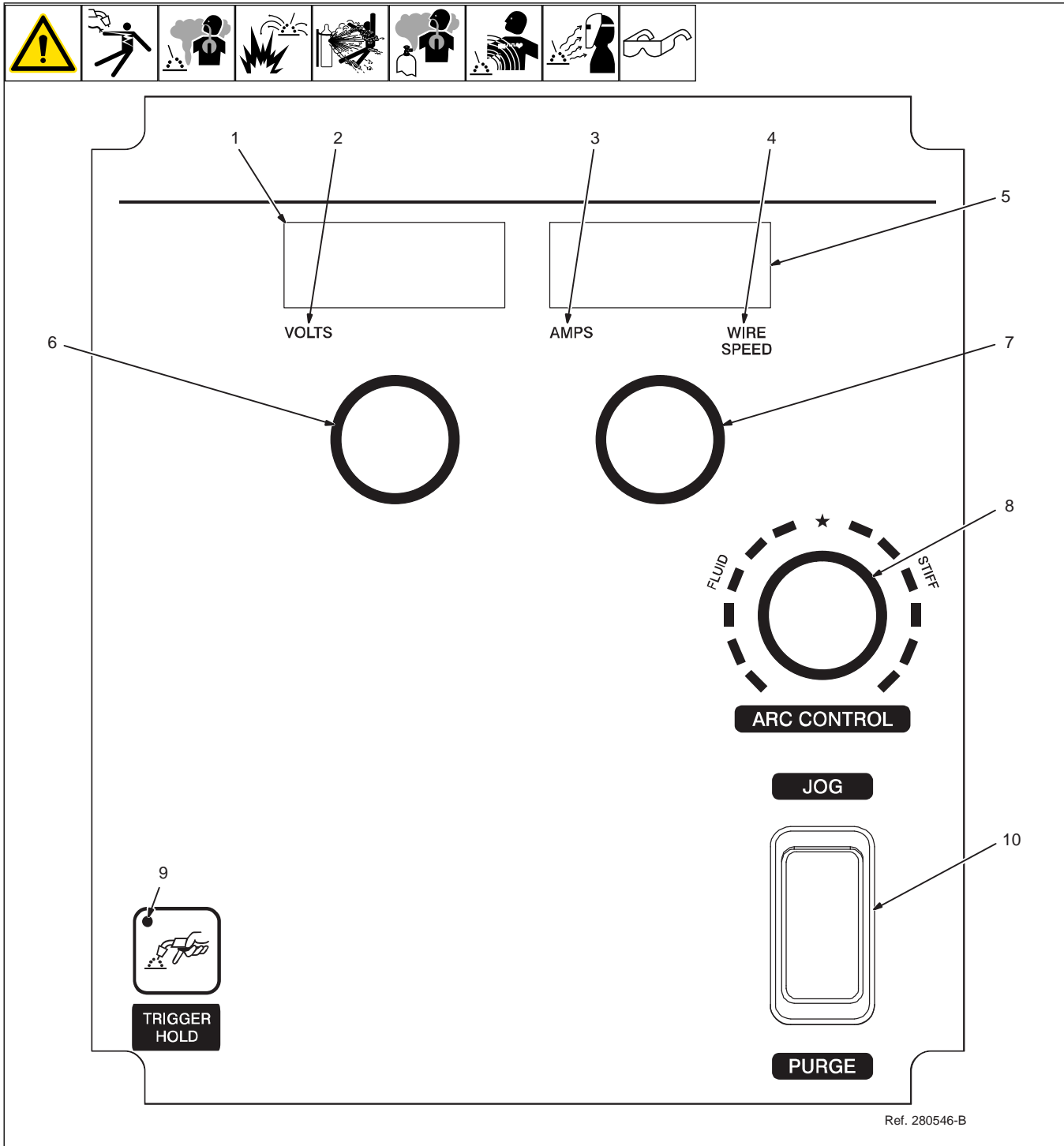
Step 5. Tighten knob so wire does not slip or wire will coil. Do not overtighten. When contact tip is completely blocked, (by moving nozzle closer) wire should slip at the feeder (see pressure adjustment in step 4).

Step 6. Cut wire off. Close cover.

For soft wire or small diameter stainless steel wire, reduce drive roll pressure on the rear roll to half that of the front rolls.

SECTION 6 – OPERATION

6-1. Wire Feeder User Interface



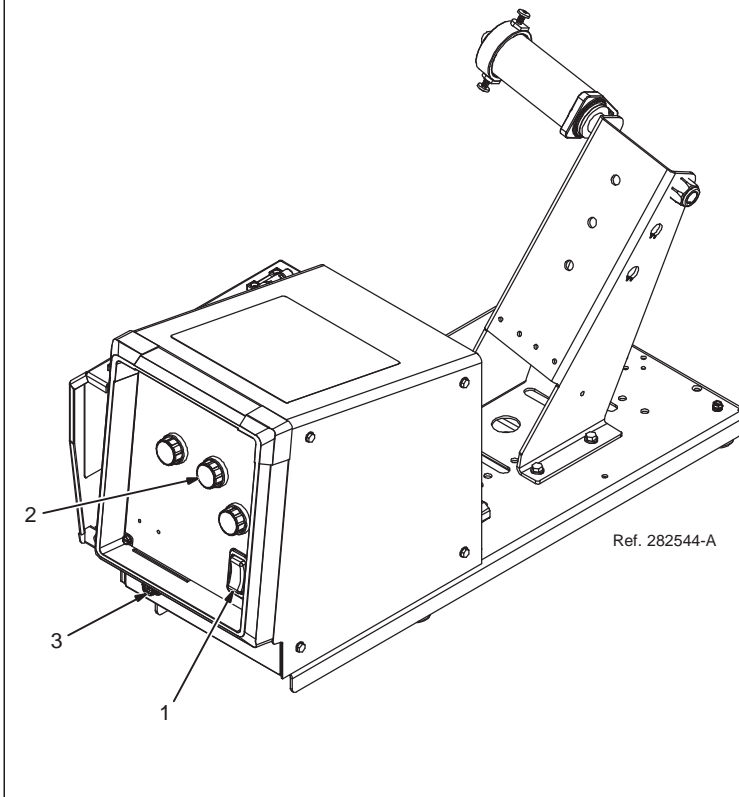
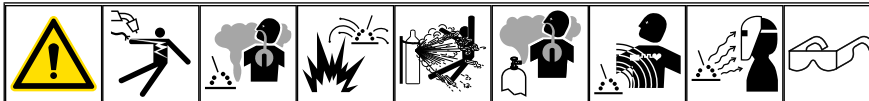
6-2. Description Of Front Panel Controls

<p>1 Left Display</p> <p>Indicates weld voltage as determined by indicator below display.</p>	<p>Indicates wire speed value shown on Right Display.</p>	<p>8 Arc Control</p> <p>Use control to adjust arc characteristics.</p>
<p>2 Voltage Indicator</p> <p>Indicates weld voltage value shown on Left Display.</p>	<p>5 Right Display</p> <p>Indicates weld amperage or wire feed speed as determined by indicator below display.</p>	<p>9 Trigger Hold Button</p> <p>Use to enable and disable trigger hold function. Indicator is lit when active.</p>
<p>3 Amps Indicator</p> <p>Indicates weld amperage value shown on Right Display.</p>	<p>6 Voltage Control</p> <p>Use control to adjust voltage as determined by indicator below Left Display.</p>	<p>10 Jog/Purge Switch</p> <p>Pressing the top portion of switch enables wire feeder to feed wire without energizing weld power or gas valve. Pressing bottom portion of switch enable gas valve to purge gas lines.</p>
<p>4 Wire Speed Indicator</p>	<p>7 Wire Speed Control</p> <p>Use control to adjust wire feed speed as determined by indicator below Right Display.</p>	

6-3. Power Switch

<p>Ref. 282544-A</p>	<p>1 Power Switch (Located on rear of feeder)</p>

6-4. Jog/Purge Switch



1 Jog/Purge Switch

Pressing the top portion of switch enables wire feeder to feed wire without energizing weld output or gas valve.

Pressing bottom portion of switch enables gas valve to purge gas lines.

2 Wire Speed Control

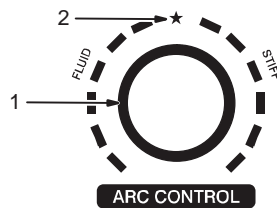
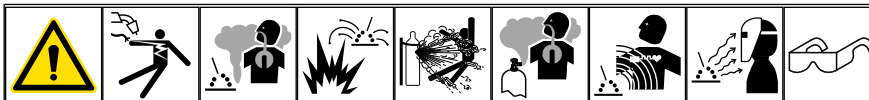
Wire speed can be adjusted with the Wire Speed control when the unit is jogging wire. The unit displays wire speed while the unit is being jogged.

3 Gun Trigger Receptacle

The wire feeder can also be jogged by using the gun trigger. However, the weld output is energized for 3 seconds. If the welding arc does not initiate in 3 seconds after the gun trigger is activated the unit will perform a jog operation for a maximum of one minute. If the gun trigger is still activated after one minute, the jog operation is terminated to prevent complete despooling of the wire, as in the case of a damaged gun.

The unit displays HELP HELD to inform operator to release gun trigger or Jog switch

6-5. Arc Control



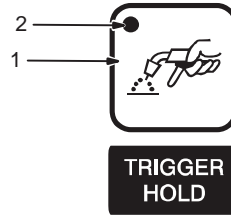
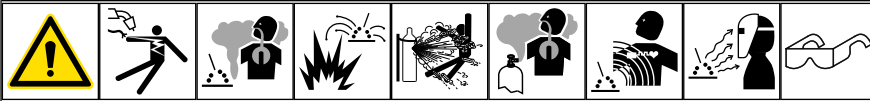
1 Arc Control Knob

2 Arc Control Indicators

Arc control allows the arc characteristics, *fluid* versus *stiff*, to be changed for specific applications and wires. The *star* setting is good for most applications. Use *fluid* settings (0 -25) to soften the arc, increase puddle fluidity and flatten the weld bead appearance. Use *stiff* settings (0-25) to stiffen the arc, reduce puddle fluidity and crown the weld bead appearance.

To adjust or review the arc control setting, begin by turning Arc Control knob. The type (*fluid or stiff*) and value (0-25) will be displayed in the Left and Right display for three seconds. Turn knob to desired arc control setting. Indicators around arc control knob will light to give visual indication of arc control setting.

6-6. Trigger Hold



- 1 Trigger Hold Button
- 2 Trigger Hold LED

Trigger Hold function allows the operator to weld without continuously pressing the welding gun trigger. The operator presses the welding gun trigger for five seconds and an arc is established. The weld enable signal latches on and the operator can release the welding gun trigger. The welding operation will continue. To stop the welding operation, press and release the welding gun trigger.

To enable Trigger Hold function, press and release button. Indicator will light. To disable press and release button. Indicator will not be lit.

SECTION 7 – MAINTENANCE AND TROUBLESHOOTING

7-1. Routine Maintenance


<p>⚠ Disconnect power before maintaining.</p> <p><i>👉 Service equipment more often if used in severe conditions.</i></p>				
🕒	✓ = Check	◇ = Change	○ = Clean	☆ = Replace
Every 3 Months	<p>☆ Unreadable Labels</p>	<p>○ Weld Terminals</p>	<p>✓ ☆ Weld Cords And Cables</p>	
	<p>☆ Damaged Gas Hose</p>	<p>✓ ○ Clean And Tighten Weld Connections</p>		
Every 6 Months	<p>○ Inside Unit</p>	<p>○ Drive Rolls</p>		


*To be done by Factory Authorized Service Agent.

7-2. Cleaning Debris From Shielding Gas Filter Fitting







	<p>⚠ Disconnect Power Before Maintaining.</p> <p>1 Shielding Gas Filter Fitting</p> <p>Remove fitting from gas valve on back panel of feeder.</p> <p>Blow compressed air through the threaded male end of fitting to dislodge debris from internal mesh screen.</p> <p><i>👉 Replace fitting if blowing compressed air through fitting does not clear obstructions.</i></p> <p>Reinstall fitting into gas valve.</p> <p>Tighten fitting to 150 in. lbs (17 N×m).</p>
	<p>283551-A</p>
<p>3/4 in.</p>	


7-3. Diagnostics Table For Fault Codes


Unit Display Toggles Message		Description
HELP SET	HELP 10XX	Indicates an issue with the weld program library, or the wire feeder attempted to use an invalid memory. Select a different memory (PRO feeder only). If the problem persists, contact a Factory Authorized Service Agent.
HELP COMM	HELP 11XX	Indicates a communication failure between two of the circuit boards within the system. Cycle power. Inspect and replace the ArcConnect cable between the power source and wire feeder. If the problem persists, contact a Factory Authorized Service Agent.
HELP FEED	HELP 14XX	Indicates input power to the wire feeder is outside specifications, or the motor experienced an overcurrent. Verify the power source is operating within it's rated supply voltages. Check the drive rolls, spool tension, gun liner, wire guides and contact tip for anything that could cause excessive drag on the wire feeding.
HELP DUTY	HELP 2501 or HELP 2502	Indicates the wire feeder motor(s) are operating at too high of a current over a period of time. Check the drive rolls, spool tension, gun liner, wire guides and contact tip for anything that could cause excessive drag on the wire feeding.  <i>HELP 2500 indicates a power source over-duty cycle, consult power source Owner's manual.</i>
HELP HELD	HELP 26XX	Indicates a button or trigger is held for too long or is stuck. Verify no buttons are held down on the wire feeder or gun. Unplug the gun trigger. If the problem goes away, there is an issue with the gun trigger. If the problem persists, contact a Factory Authorized Service Agent.
HELP XXXX	HELP XXXX	For other codes not listed, consult power source Owner's manual.

 The last two digits in the right display (shown with XX in the table) will indicate a specific fault a Factory Authorized Service Agent can use to troubleshoot the wire feeder.

7-4. Troubleshooting

     					
Trouble		Remedy			
Wire feeds, shielding gas flows, but electrode wire is not energized.	Check and secure weld cable connections (see Section 5-2).				
Electrode wire feeding stops or feeds erratically during welding.	Check welding gun trigger and connection. See gun Owner's Manual.				
	Readjust hub tension and drive roll pressure (see Section 5-12).				
	Change to correct size drive roll.				
	Clean or replace dirty or worn drive roll.				
	Incorrect size or worn wire guides.				
	Replace contact tip or liner. See welding gun Owner's Manual.				
Wire feeder power is on, displays light up, but unit is inoperative.	Remove weld spatter or foreign matter from around nozzle opening.				
	Check welding gun trigger connection at wire feeder.				
Unit completely inoperative- no display.	Check welding gun trigger leads and trigger switch. See welding gun Owner's Manual.				
	Turn Power switch On (see Section 6-3).				
	Check ArcConnect cable connection at wire feeder and power source.				
Wire feeds when Jog switch is pressed but not when gun trigger is pressed.	Check supplementary protector at power source. See welding power source Owner's Manual.				
	Check welding gun trigger connection at wire feeder. Check gun trigger leads and trigger switch. See gun Owner's Manual.				
Wire does not feed until trigger is pressed but continues to feed after trigger is released. Wire feeds as soon as power is applied	Check for short between gun trigger leads and weld cable. Repair or replace gun trigger leads.				
Gas does not flow; wire feeds.	Check gas supply.				
	Check gas flowmeter.				
	Check gas hose for damage or loose connections.				
	Check for blockage in gas filter (see Section 7-2).				
Erratic or improper weld output.	Check for blockage in welding gun.				
	Use proper size and type of weld cable.				

 Complete Parts List is available at www.MillerWelds.com

	Clean and tighten all weld connections.
	Check for correct polarity or welding circuit.
	Poor weld cable layout. See (Section 5-4) for recommended cable arrangement.
	If using weld voltage sense lead, verify cable and connections. Repair or replace as needed.
	 Do not leave unused lead connected to the weld voltage sense terminal.

SECTION 8 – ELECTRICAL DIAGRAMS

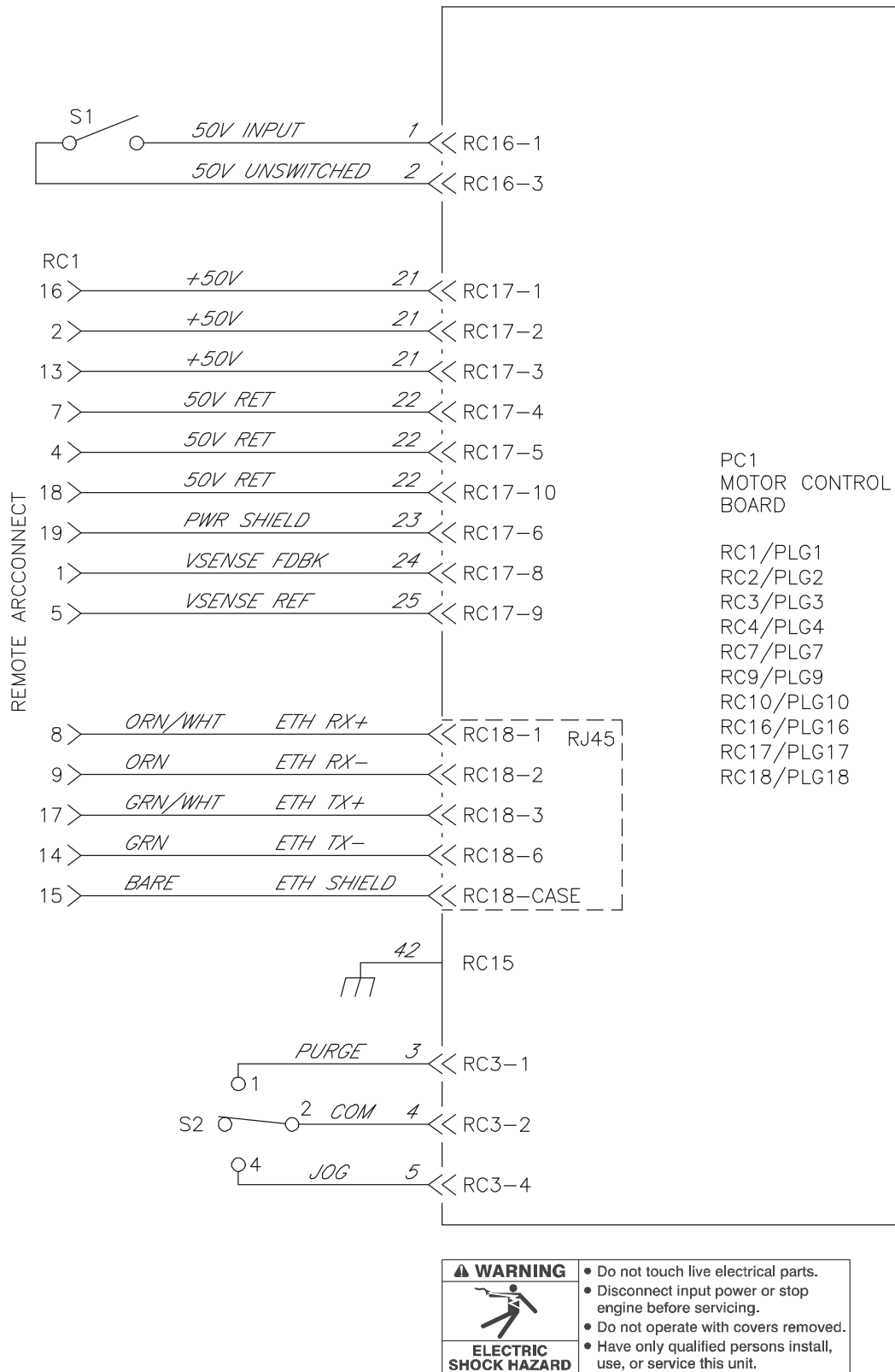
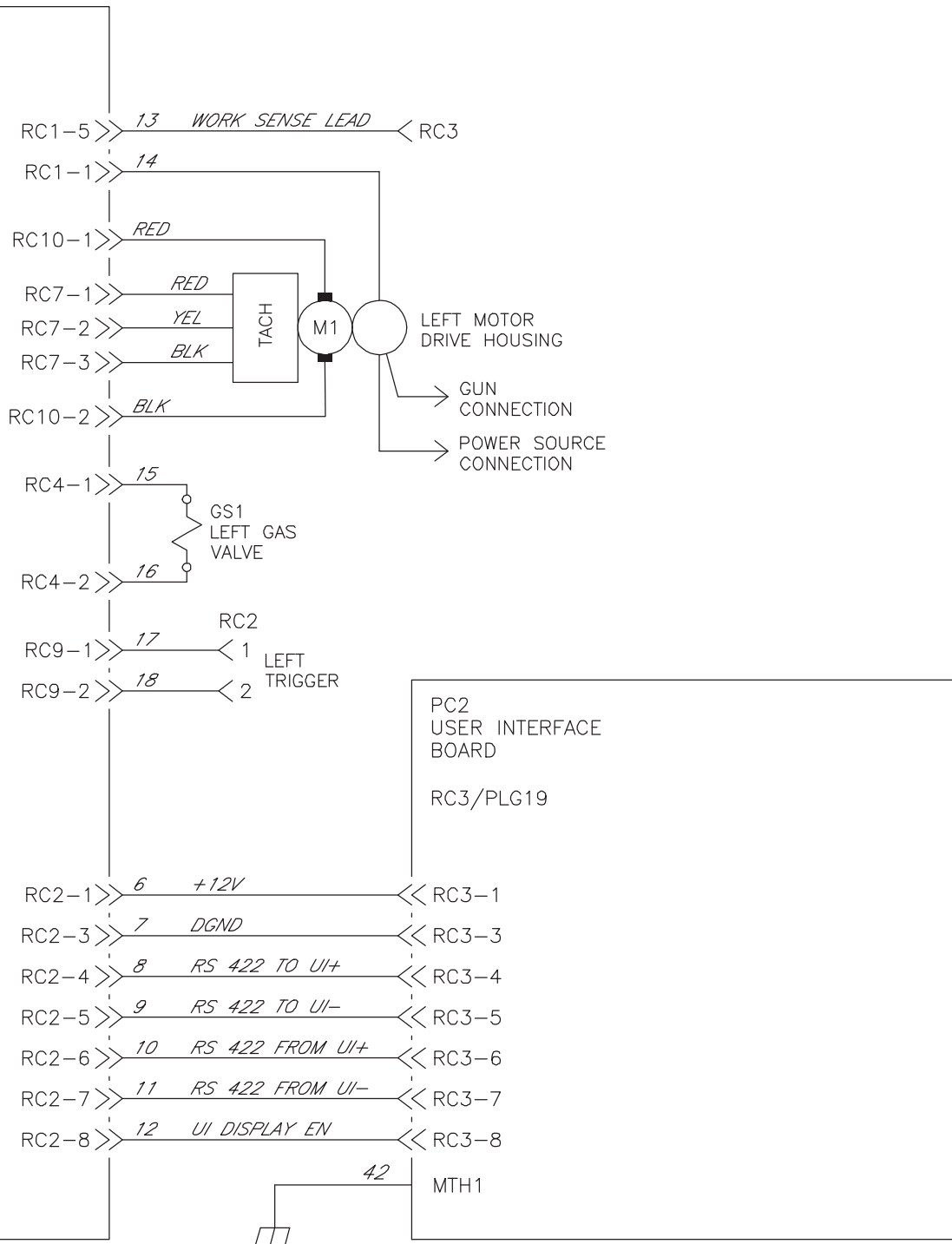


Figure 8-1. Circuit Diagram



282167-B

TRUE BLUE[®]

WARRANTY

Effective January 1, 2020

(Equipment with a serial number preface of NA or newer)

This limited warranty supersedes all previous Miller warranties and is exclusive with no other guarantees or warranties expressed or implied.

LIMITED WARRANTY – Subject to the terms and conditions below, Miller Electric Mfg. LLC, Appleton, Wisconsin, warrants to authorized distributors that new Miller equipment sold after the effective date of this limited warranty is free of defects in material and workmanship at the time it is shipped by Miller. THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

Within the warranty periods listed below, Miller will repair or replace any warranted parts or components that fail due to such defects in material or workmanship. Miller must be notified in writing within thirty (30) days of such defect or failure, at which time Miller will provide instructions on the warranty claim procedures to be followed. Notifications submitted as online warranty claims must provide detailed descriptions of the fault and troubleshooting steps taken to diagnose failed parts. Warranty claims that lack the required information as defined in the Miller Service Operation Guide (SOG) may be denied by Miller.

Miller shall honor warranty claims on warranted equipment listed below in the event of a defect within the warranty coverage time periods listed below. Warranty time periods start on the delivery date of the equipment to the end-user purchaser, or 12 months after the equipment is shipped to a North American distributor, or 18 months after the equipment is shipped to an international distributor, whichever occurs first.

1. 5 Years Parts — 3 Years Labor
 - * Original Main Power Rectifiers Only to Include SCRs, Diodes, and Discrete Rectifier Modules
2. 3 Years — Parts and Labor Unless Specified
 - * Auto-Darkening Helmet Lenses (No Labor) (See Classic Series Exception Below)
 - * Engine Driven Welder/Generators
(NOTE: Engines are Warranted Separately by the Engine Manufacturer.)
 - * Insight Welding Intelligence Products (Except External Sensors)
 - * Inverter Power Sources
 - * Plasma Arc Cutting Power Sources
 - * Process Controllers
 - * Semi-Automatic and Automatic Wire Feeders
 - * Transformer/Rectifier Power Sources
3. 2 Years — Parts and Labor
 - * Auto-Darkening Helmet Lenses – Classic Series Only (No Labor)
 - * Auto-Darkening Weld Masks (No Labor)
 - * Fume Extractors – Capture 5, Filtair 400 and Industrial Collector Series
4. 1 Year — Parts and Labor Unless Specified
 - * ArcReach Heater
 - * AugmentedArc and LiveArc Welding Systems
 - * Automatic Motion Devices
 - * Bernard BTB Air-Cooled MIG Guns (No Labor)
 - * CoolBelt (No Labor)
 - * Desiccant Air Dryer System
 - * Field Options
(NOTE: Field options are covered for the remaining warranty period of the product they are installed in, or for a minimum of one year — whichever is greater.)
 - * RFCS Foot Controls (Except RFCS-RJ45)
 - * Fume Extractors – Filtair 130, MWX and SWX Series, ZoneFlow Extraction Arms and Motor Control Box HF Units
 - * ICE/XT Plasma Cutting Torches (No Labor)
 - * Induction Heating Power Sources, Coolers
(NOTE: Digital Recorders are Warranted Separately by the Manufacturer.)
 - * Load Banks
 - * Motor-Driven Guns (except Spoolmate Spoolguns)
 - * PAPR Blower Unit (No Labor)
 - * Positioners and Controllers
 - * Racks (For Housing Multiple Power Sources)
 - * Running Gear/Trailers
 - * Subarc Wire Drive Assemblies

- * Supplied Air Respirator (SAR) Boxes and Panels
 - * TIG Torches (No Labor)
 - * Tregaskiss Guns (No Labor)
 - * Water Cooling Systems
 - * Wireless Remote Foot/Hand Controls and Receivers
 - * Work Stations/Weld Tables (No Labor)
5. 6 Months — Parts
 - * Batteries
 6. 90 Days — Parts
 - * Accessories (Kits)
 - * ArcReach Heater Quick Wrap and Air Cooled Cables
 - * Canvas Covers
 - * Induction Heating Coils and Blankets, Cables, and Non-Electronic Controls
 - * MDX Series MIG Guns
 - * M-Guns
 - * MIG Guns, Subarc (SAW) Torches, and External Cladding Heads
 - * Remote Controls and RFCS-RJ45
 - * Replacement Parts (No labor)
 - * Spoolmate Spoolguns

Miller's True Blue[®] Limited Warranty shall not apply to:

1. **Consumable components; such as contact tips, cutting nozzles, contactors, brushes, relays, work station table tops and welding curtains, or parts that fail due to normal wear. (Exception: brushes and relays are covered on all engine-driven products.)**
2. Items furnished by Miller, but manufactured by others, such as engines or trade accessories. These items are covered by the manufacturer's warranty, if any.
3. Equipment that has been modified by any party other than Miller, or equipment that has been improperly installed, improperly operated or misused based upon industry standards, or equipment which has not had reasonable and necessary maintenance, or equipment which has been used for operation outside of the specifications for the equipment.
4. Defects caused by accident, unauthorized repair, or improper testing.

MILLER PRODUCTS ARE INTENDED FOR COMMERCIAL AND INDUSTRIAL USERS TRAINED AND EXPERIENCED IN THE USE AND MAINTENANCE OF WELDING EQUIPMENT.

The exclusive remedies for warranty claims are, at Miller's option, either: (1) repair; or (2) replacement; or, if approved in writing by Miller, (3) the pre-approved cost of repair or replacement at an authorized Miller service station; or (4) payment of or credit for the purchase price (less reasonable depreciation based upon use). Products may not be returned without Miller's written approval. Return shipment shall be at customer's risk and expense.

The above remedies are F.O.B. Appleton, WI, or Miller's authorized service facility. Transportation and freight are the customer's responsibility. TO THE EXTENT PERMITTED BY LAW, THE REMEDIES HEREIN ARE THE SOLE AND EXCLUSIVE REMEDIES REGARDLESS OF THE LEGAL THEORY. IN NO EVENT SHALL MILLER BE LIABLE FOR DIRECT, INDIRECT, SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES (INCLUDING LOSS OF PROFIT) REGARDLESS OF THE LEGAL THEORY. ANY WARRANTY NOT PROVIDED HEREIN AND ANY IMPLIED WARRANTY, GUARANTY, OR REPRESENTATION, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE, ARE EXCLUDED AND DISCLAIMED BY MILLER.

Some US states do not allow limiting the duration of an implied warranty or the exclusion of certain damages, so the above limitations may not apply to you. This warranty provides specific legal rights, and other rights may be available depending on your state. In Canada, some provinces provide additional warranties or remedies, and to the extent the law prohibits their waiver, the limitations set out above may not apply. This Limited Warranty provides specific legal rights, and other rights may be available, but may vary by province.

Warranty Questions?

Call
1-800-4-A-MILLER
for your local
Miller distributor.

Your distributor also gives
you ...

Service

You always get the fast,
reliable response you
need. Most replacement
parts can be in your
hands in 24 hours.

Support

Need fast answers to the
tough welding questions?
Contact your distributor.
The expertise of the
distributor and Miller is
there to help you, every
step of the way.



Owner's Record

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 _____

Register your product at www.MillerWelds.com/Register

For Service

Contact a DISTRIBUTOR or SERVICE AGENCY near you.

Always provide Model Name and Serial/Style Number.

Contact your Distributor for:

- Welding Supplies and Consumables
- Options and Accessories
- Personal Protective Equipment (PPE)
- Service and Repair
- Replacement Parts
- Training (Schools, Videos, Books)
- Welding Process Handbooks

To locate a Distributor or Service Agency visit www.millerwelds.com or call 1-800-4-A-Miller

Contact the Delivering Carrier to:

File a claim for loss or damage during shipment.

For assistance in filing or settling claims, contact your distributor and/or equipment manufacturer's Transportation Department.

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