



TIG QUICK START GUIDE STICK PRO 180 WELDER (NOT RECOMMENDED FOR ALUMINUM)



1.   Read user manual

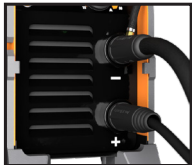
2.  Select  process



* TIG Torch sold separately



3. Connect TIG torch and ground clamp



4. Connect TIG torch lead to gas (100% Argon)

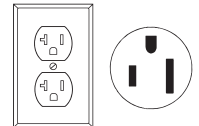


5. Adjust amperage per material thickness



6.  Connect to Input Power

120VAC, 20A outlet, 30A breaker recommended



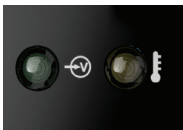
- Generator OK with continuous output $\geq 4,500$ W (120V) or 10,000 W (230V)
- Extension cord: #12 AWG (120V) or #8 AWG (230V) or larger. 25' (8m) or shorter extension cords recommended.

7.  Initiate the arc with a scratch or lift technique when in contact with the metal

ELECTRODE IS ALWAYS ELECTRICALLY HOT WHILE IN TIG MODE

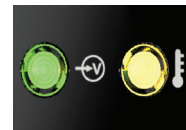
TIG TROUBLESHOOTING TIPS

Both LED lights off



Verify machine is plugged in and on. See manual.

Both LED lights on



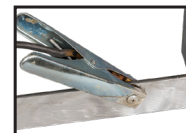
Duty cycle exceeded or insufficient air flow. Allow machine to cool. Ensure vents are clear of obstacles. See manual.

Aluminum welding



- Not recommended for this machine.
- Output is DC only which is not recommended for TIG welding aluminum.

Workpiece grounding



Connect ground clamp to clean, bare metal. No rust, paint or other coatings. Attach the ground clamp directly to the workpiece if you are experiencing issues.

Frequently tripping circuit breaker or exceeding duty cycle



Welder should be the only thing plugged into the circuit.

Low weld output or poor fusion

- Usually due to low input power.
- Welder should be only thing plugged into circuit.
- Avoid using extension cords. If one must be used, it must be #10 AWG or larger; 25' (8m) or shorter.
- Generators must be 4,500 W continuous output and not have a low-idle function (or have it disabled).



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STICK QUICK START GUIDE

STICK PRO 180 WELDER (NOT RECOMMENDED FOR ALUMINUM)

1.



Read user manual

2.



Select process

Electrode Holder



Ground Clamp



3.

Connect electrode holder and ground clamp according to desired polarity



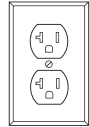
Usually
DCEP -
Electrode
Positive

4.



Connect to Input Power

120VAC, 20A
outlet, 30A
breaker
recommended



- Generator OK with continuous output $\geq 4,500$ W (120V) or 10,000 W (230V)
- Extension cord: #12 AWG (120V) or #8 AWG (230V) or larger. 25' (8m) or shorter extension cords recommended.

5.

Adjust amperage per settings chart on the welder



6.

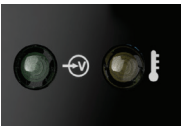
Recommended electrodes

Electrode	Diameter		Amperage
	Inches	MM	AMPS
E6010 & E6011	3/32	2,4	30-75
	1/8	3,2	35-120
E6013	5/32	4,0	80-160
	1/16	1,6	20-50
	3/32	2,4	40-90
E7014	1/8	3,2	50-130
	5/32	4,0	90-180
	3/32	2,4	40-90
E7018	1/8	3,2	60-130
	5/32	4,0	90-180
	3/32	2,4	50-100

*Performance may vary by brand

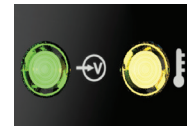
STICK TROUBLESHOOTING TIPS

Both LED lights off



Verify machine is plugged in and on. See manual.

Both LED lights on



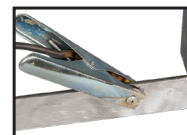
Duty cycle exceeded or insufficient air flow. Allow machine to cool. Ensure vents are clear of obstacles. See manual.



Aluminum welding

- Not recommended for this machine.
- Requires more amperage on Stick than this machine is designed to output.

Workpiece grounding



Connect ground clamp to clean, bare metal. No rust, paint or other coatings. Attach the ground clamp directly to the workpiece if you are experiencing issues.

Frequently tripping circuit breaker or exceeding duty cycle



Use 5/32" diameter electrodes or smaller. Some 5/32" may draw too much amperage.



Trying to weld single pass on material larger than 1/4" thick is not possible with this machine. Multi-pass recommended for thicker materials.



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- Generators must be 4,500 W continuous output and not have a low-idle function (or have it disabled).



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