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Processes



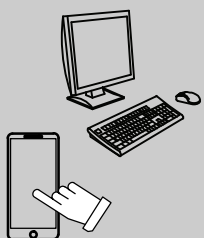
Multiprocess Welding

Description



120-240 Volt Arc Welding Power Source

Syncrowave 212



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.



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



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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. 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.
- Do not store or use equipment in standing water.
- 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

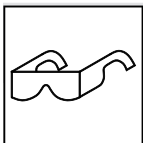
(stick) welder, or 3) an AC welder with reduced open-circuit voltage. In most situations, use of a DC, constant voltage wire welder is recommended. And, do not work alone!

- 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.



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.

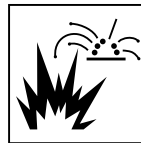
- Shut off compressed gas supply when not in use.
- Always ventilate confined spaces or use approved air-supplied respirator.



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.

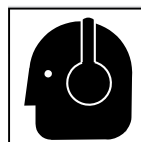
- Wear an approved welding helmet fitted with a proper shade of filter lenses to protect your face and eyes from arc rays and sparks when welding or watching (see ANSI Z49.1 and Z87.1 listed in Safety Standards).
- Wear approved safety glasses with side shields under your helmet.
- Use protective screens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

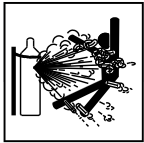
Noise from some processes or equipment can damage hearing.

- 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.

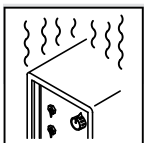
- Do not install or place unit on, over, or near combustible surfaces.
- Do not install unit near flammables.
- Do not overload building wiring—be sure power supply system is properly sized, rated, and protected to handle this unit.



FALLING EQUIPMENT can injure.

- Use lifting eye to lift unit only, NOT running gear, gas cylinders, or any other accessories.
- Use correct procedures and equipment of adequate capacity to lift and support unit.

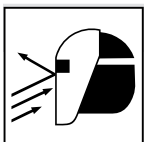
- If using lift forks to move unit, be sure forks are long enough to extend beyond opposite side of unit.
- Keep equipment (cables and cords) away from moving vehicles when working from an aerial location.
- Follow the guidelines in the Applications Manual for the Revised NIOSH Lifting Equation (Publication 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.



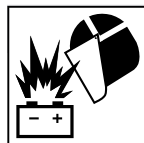
MOVING PARTS can injure.

- 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.



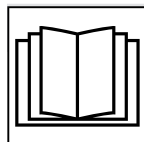
BATTERY EXPLOSION can injure.

- 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.

- Electromagnetic energy can interfere with sensitive electronic equipment such as microprocessors, computers, and computer-driven equipment such as robots.
- Be sure all equipment in the welding area is electromagnetically compatible.

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

1-4. 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: www.aws.org.

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

Safe Practices for the Preparation of Containers and Piping for Welding and Cutting, American Welding Society Standard AWS F4.1. Website: www.aws.org.

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



UNE DÉCHARGE ÉLECTRIQUE peut entraîner la mort.

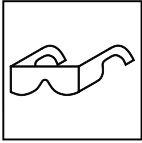
Le contact d'organes électriques sous tension peut provoquer des accidents mortels ou des brûlures graves. Le circuit de l'électrode et de la pièce est sous tension lorsque le courant est délivré à la sortie. Le circuit d'alimentation et les circuits internes de la machine sont également sous tension 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).
- Brancher correctement la mise à la terre et utiliser cet appareil conformément à son manuel d'utilisateur et aux codes nationaux, provinciaux et municipaux.
- Toujours vérifier la mise à la terre — vérifier et assurez-vous que le conducteur de mise à la terre du cordon d'alimentation est bien raccordé à la borne de mise à la terre dans le boîtier de déconnexion 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 enrouler les câbles autour du corps.
- Si la pièce soudée doit être mise à la terre, le faire directement avec un câble distinct.
- Ne pas toucher l'électrode quand on est en contact avec la pièce, la terre ou une électrode 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. Entretenir 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.



LES PIÈCES CHAUDES peuvent provoquer des brûlures.

- Ne pas toucher des parties chaudes à mains nues.
- 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.

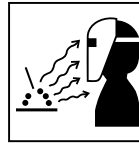
Le soudage génère des fumées et des gaz. Leur inhalation peut être dangereuse pour votre santé.

- 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.

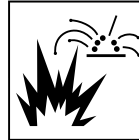
- Fermer l'alimentation du gaz comprimé en cas de non utilisation.
- Veiller toujours à bien aérer les espaces confinés ou se servir d'un respirateur d'adduction d'air homologué.



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 pendant le soudage (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 une protection corporelle en cuir ou des vêtements ignifuges (FRC). La protection du corps comporte des vêtements sans huile, comme des gants de cuir, une chemise solide, des pantalons sans revers, des chaussures hautes et une casquette.

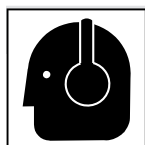


LE SOUDAGE peut provoquer un incendie ou une explosion.

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 (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 dégelier 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 une protection corporelle en cuir ou des vêtements ignifuges (FRC). La protection du corps comporte des vêtements sans huile, comme 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.

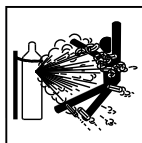
Le bruit des processus et des équipements peut affecter l'ouïe.

- 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.



Si des BOUTEILLES sont endommagées, elles pourront exploser.

Des bouteilles de gaz comprimé protecteur 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.

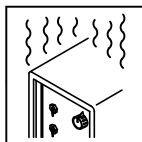
- Protéger les bouteilles de gaz comprimé d'une chaleur excessive, des chocs mécaniques, des dommages physiques, du laitier, des flammes ouvertes, des étincelles et des arcs.
- Placer les bouteilles debout en les fixant dans un support stationnaire ou dans un porte-bouteilles pour les empêcher de tomber 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.
- Maintenir le chapeau de protection sur la soupape, sauf en cas d'utilisation ou de branchement de la bouteille.
- 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.



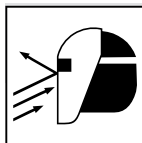
L'EMPLOI EXCESSIF peut SURCHAUFFER L'ÉQUIPEMENT.

- Laisser l'équipement refroidir ; respecter le facteur de marche nominal.
- Réduire le courant ou le cycle opératoire avant de recommencer le soudage.
- Ne pas obstruer les passages d'air du poste.



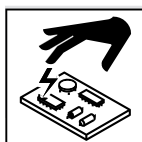
LA CHUTE DE L'ÉQUIPEMENT peut provoquer des blessures.

- Utiliser l'anneau de levage uniquement pour soulever l'appareil, NON PAS les organes de roulement, 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.



LES ÉTINCELLES PROJÉTÉES 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 gachette 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.



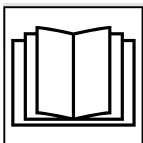
L'EXPLOSION DE LA BATTERIE peut provoquer des blessures.

- 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.

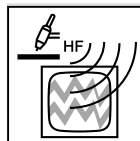
- S'abstenir de toucher des organes mobiles tels que des ventilateurs.
- Maintenir fermés et verrouillés les portes, panneaux, recouvrements et dispositifs de protection.
- Lorsque cela est nécessaire pour des travaux d'entretien et de dépannage, faire retirer les portes, panneaux, recouvrements ou dispositifs 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 des pièces de remplacement provenant du fabricant.

- 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: www.aws.org.

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

Safe Practices for the Preparation of Containers and Piping for Welding and Cutting, American Welding Society Standard AWS F4.1. Website: www.aws.org.

National Electrical Code, NFPA Standard 70 from National Fire Protection Association. Website: www.nfpa.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 – SPECIFICATIONS

3-1. Specifications

 This equipment will deliver rated output at an ambient air temperature up to 104° F (40° C).

 Do not use information in unit specifications table to determine electrical service requirements. See Sections [4-13](#) and [4-14](#) for information on connecting input power.

Welding Amperage Range	Open-Circuit Voltage (U ₀)	Rated Peak Striking Voltage (U _p)
20-210 ¹	46 ²	15KV ³

¹ Welding range for Stick process is 35-160 amperes.

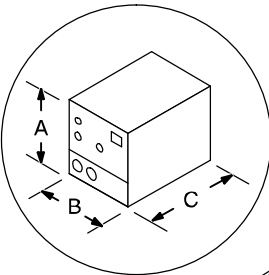
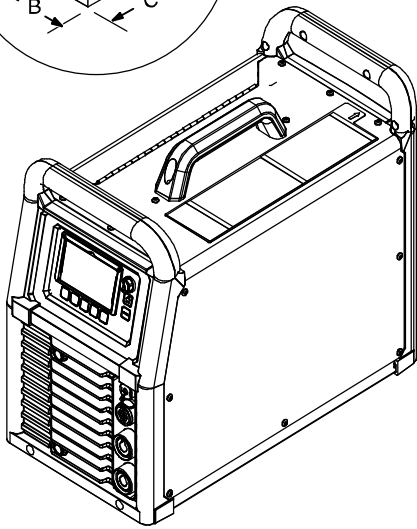
² Low open-circuit voltage (18–22) while in TIG Lift Arc⁺, or while in Stick.

³ Arc starting device is designed for manual guided operations.

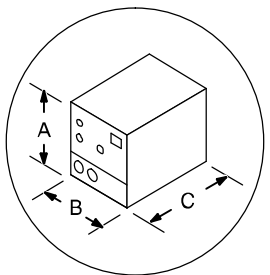
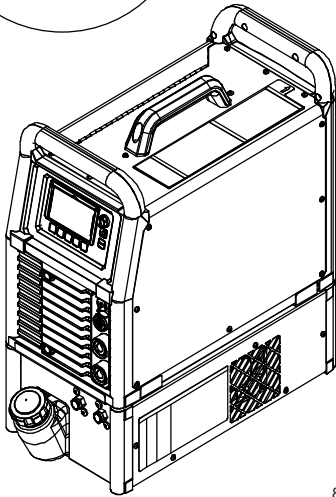
Process	Output Ratings			Phase	Current Draw (A) At Rated Input Voltages (V)		
	Current (A)	Voltage (V)	Duty Cycle		120V	208V	240V
STICK	160	26.4	20%	1	—	27	23
	120	24.8	60%	1	—	20	16
	100	24	100%	1	—	16	14
	90	23.6	30%	1	25	—	—
	70	22.8	60%	1	19	—	—
	55	22.2	100%	1	15	—	—
TIG	210	18.4	20%	1	—	28	23
	130	15.2	60%	1	—	22	18
	120	14.8	100%	1	—	12	11
	140	15.6	30%	1	26	—	—
	110	14.8	60%	1	19	—	—
	90	13.6	100%	1	15	—	—
MIG	175	22.8	20%	1	—	25	22
	130	20.5	60%	1	—	19	16
	110	19.5	100%	1	—	16	14
	100	19	30%	1	23	—	—
	90	18.5	60%	1	19	—	—
	70	17.5	100%	1	15	—	—

3-2. Dimensions And Weights

A. Welding Power Source

  805683-A	Dimensions	
	A	17.5 in. (445 mm)
	B	11.25 in. (286 mm)
	C	21.5 in. (546 mm)
Weight	54 lb (25 kg)	

B. Welding Power Source With Optional Cooler

  805865-A	Dimensions	
	A	24.125 in. (614 mm)
	B	11.25 in. (286 mm)
	C	24 in. (610 mm)
Weight (Empty)	79 lb (36 kg)	

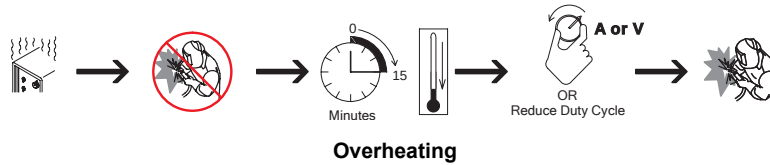
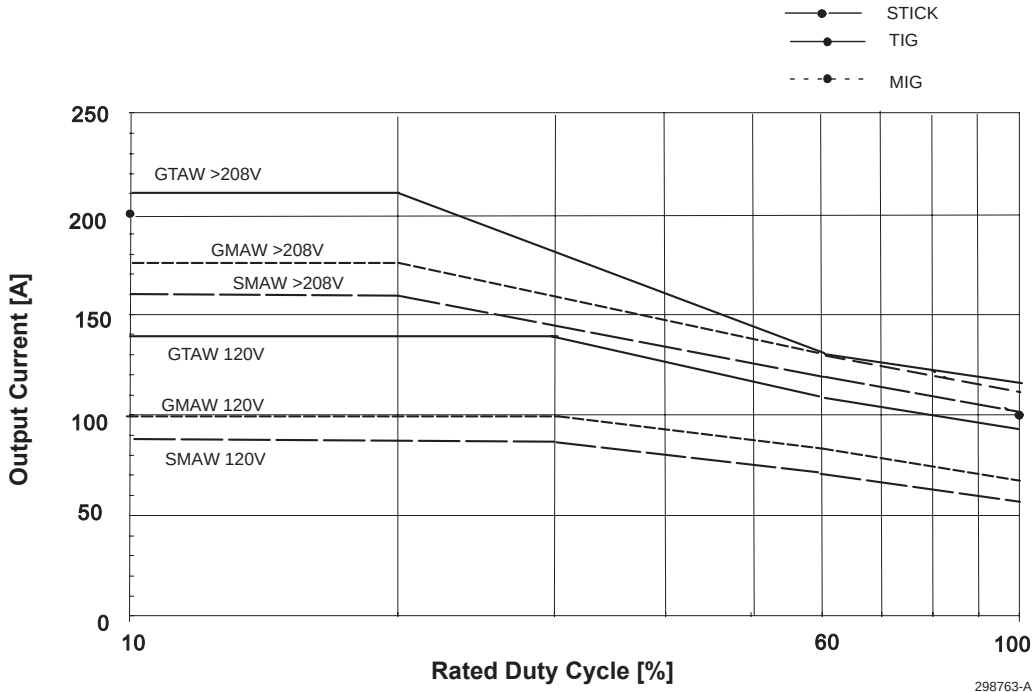
3-3. Duty Cycle And Overheating



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

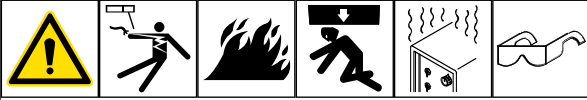
If unit overheats, output stops, a Help message is displayed (see Troubleshooting in Technical Manual), and cooling fan runs. Wait fifteen minutes for unit to cool. Reduce amperage or voltage, or duty cycle before welding.

NOTICE – Exceeding duty cycle can damage machine or torch and void warranty.



SECTION 4 – INSTALLATION

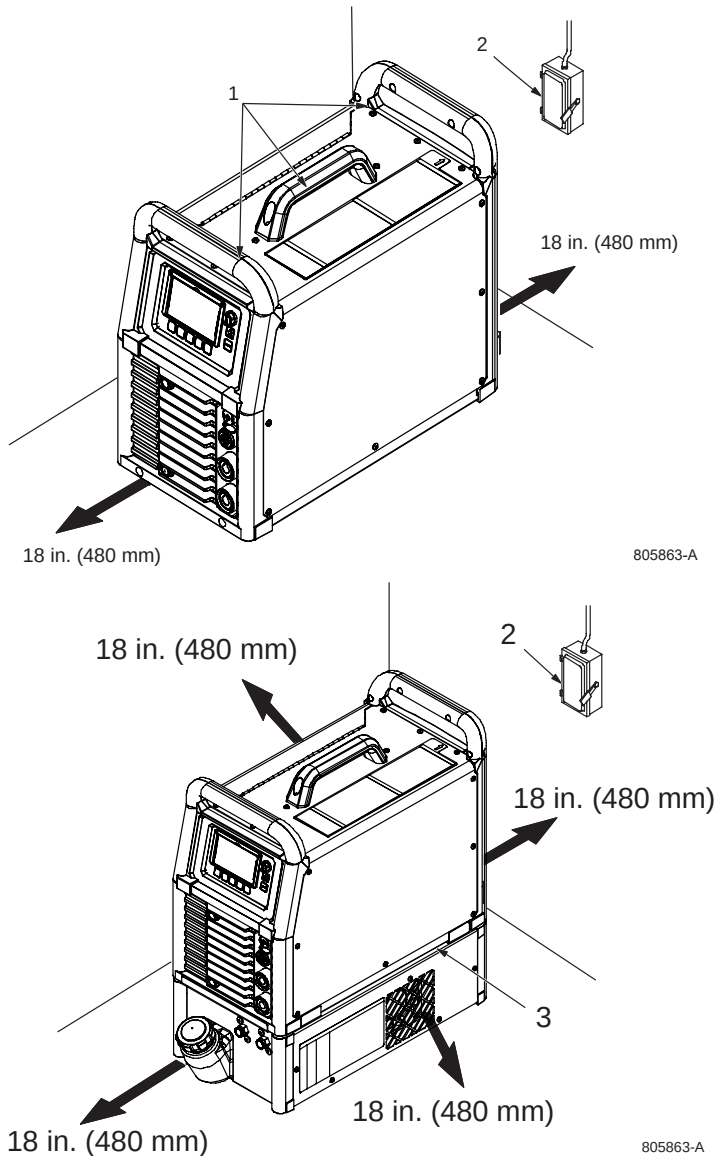
4-1. Selecting A Location



Movement



Location And Airflow



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.

Do not use carry strap to lift welder when attached to cart/cooler.

1 Carry Handle

Use carry handle to carry power source and optional cooler.

2 Line Disconnect Device

Locate unit near correct input power supply.

Do not use lift handle to lift unit when gas cylinder and accessories are connected.

3 Welding Power Source Tray

If using welding power source with optional cooler, place welding power source within top tray of cooler or next to cooler with adequate airflow allowance.

4-2. Selecting Cable Sizes¹

NOTICE – The Total Cable Length in Weld Circuit (see table below) is the combined length of both weld cables. For example, if the power source is 100 ft (30 m) from the workpiece, the total cable length in the weld circuit is 200 ft (2 cables x 100 ft). Use the 200 ft (60 m) column to determine cable size.

	Weld Cable Size ² and Total Cable (Copper) Length in Weld Circuit Not Exceeding			
	100 ft (30 m) or Less ⁴		150 ft (45 m)	200 ft (60 m)
Welding Amperes ³	10 - 60% Duty Cycle AWG (mm ²)	60 - 100% Duty Cycle AWG (mm ²)	10 - 100% Duty Cycle AWG (mm ²)	
100	4 (20)	4 (20)	4 (20)	3 (30)
150	3 (30)	3 (30)	2 (35)	1 (50)
200	3 (30)	2 (35)	1 (50)	1/0 (60)
250	2 (35)	1 (50)	1/0 (60)	2/0 (70)

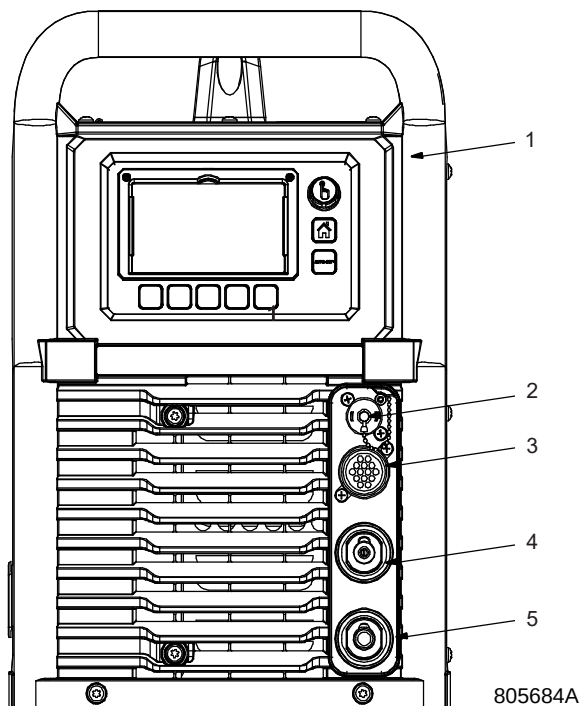
¹ This chart is a general guideline and may not suit all applications. If cable overheats, use next size larger cable.

² Weld cable size (AWG) is based on either a 4 volts or less drop or a current density of at least 300 circular mils per ampere. () = mm² for metric use.

³ Select weld cable size for pulsing application at peak amperage value.

⁴ For distances longer than 100 ft (30 m) and up to 200 ft (60 m), use direct current (DC) output only. For distances longer than those shown in this guide, see AWS Fact Sheet No. 39, Welding Cables, available from the American Welding Society at <http://www.aws.org>.

4-3. Front Panel Connections



Turn off power before connecting to weld output terminals.

Do not use worn, damaged, undersized, or repaired cables.

1 Front Panel

2 Spool Gun Trigger Receptacle

Receptacle cover should be installed when not in use.

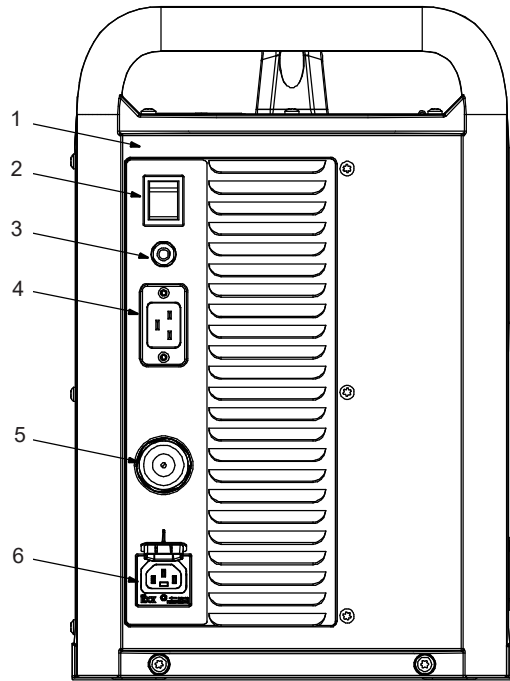
3 Remote Control Receptacle (See Section 4-15)

4 TIG Torch, or Stick Electrode Holder or Spool Gun Power Pin connection.

Spool Gun requires power pin twist lock adapter (301861).

5 Work Lead Connection

4-4. Rear Panel Connections



⚠ Turn off power before connecting to weld output terminals.

⚠ Do not use worn, damaged, undersized, or repaired cables.

1 Rear Panel

2 Main Power Switch

Use switch to energize/de-energize machine.

3 Supplementary Protector

4 Power Inlet Receptacle

Connect appropriate power cord for available power.

5 Gas In Connection

Fitting has 5/8-18 in. right hand threads, and usually requires an 11/16 in. wrench. Maximum pressure is 90 psi.

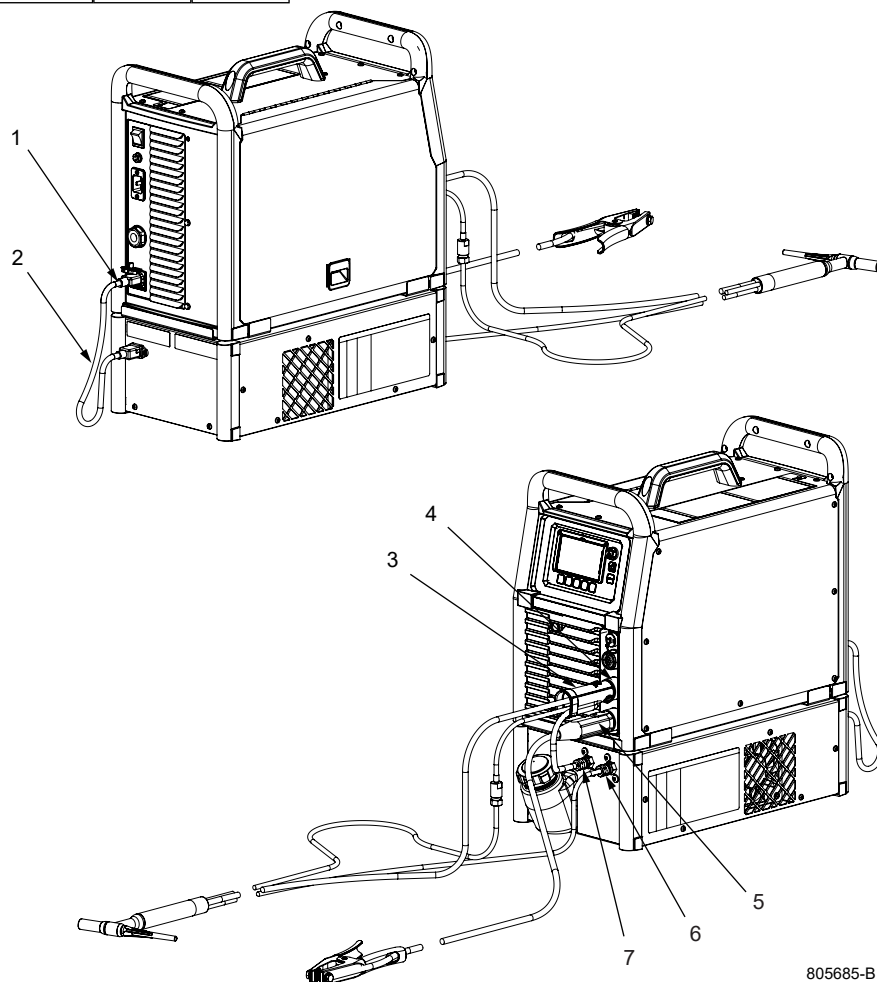
6 Coolmate 1S Dedicated Power Supply Receptacle

Provides 120V-240V to power Coolmate 1S only.

805684-A

 11/16 in.

4-5. Cooler Connections



⚠ Turn off power before connecting to weld output terminals.

⚠ Do not use worn, damaged, undersized, or repaired cables.

1 Coolmate 1S Power Receptacle Connection

Syncrowave 212 provides 120 VAC-240 VAC to power Coolmate 1S cooler only.

2 Cooler Power Cord (IEC/EN 60320-1 C13 to C14)

Connect cord supplied with cooler to the Coolmate 1S power receptacle on welding power source.

3 Torch Adapter

Included with optional water cooled package. Connect water cooled torch to torch adapter.

4 Electrode Weld Output Terminal/Gas Out Connection

Connect TIG torch to electrode weld output terminal with torch adapter.

5 Work Weld Output Terminal Connection

Connect work lead to work weld output terminal.

6 Water-Out (To Torch) Connection

Connect torch water-in (blue) hose to cooler's water-out connection.

7 Water-In (From Torch) Connection

Connect torch water-out (red) hose to cooler's water-in connection by way of torch adapter.

805685-B

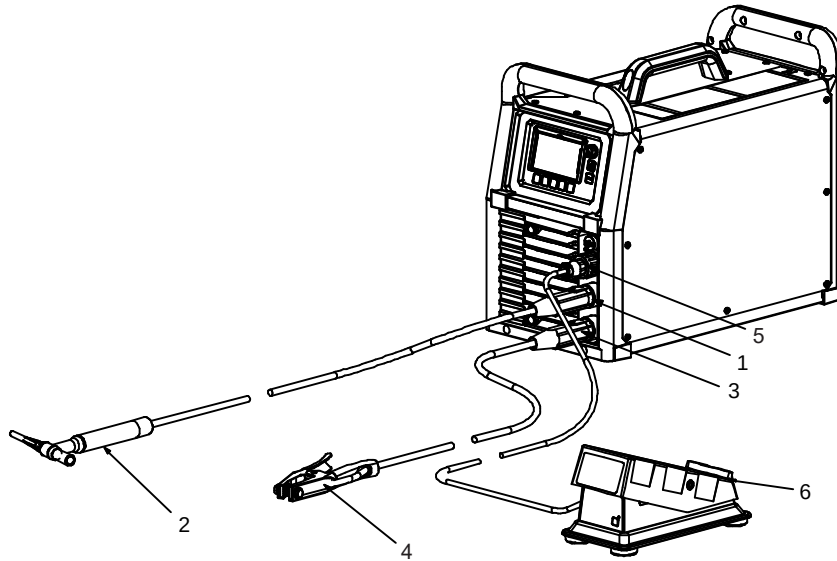
11/16 in.

Coolant Specifications

Application	GTAW or where HF (high frequency current) is used
Coolant (1 gal)	Low Conductivity Coolant 043810 ● 50/50 solution ● Protects to -37°F (-38°C) ● Resists algae growth Distilled or deionized water okay above 32°F (0°C)

NOTICE – Use of any coolant other than those listed in the table voids the warranty on any parts that come in contact with the coolant (pump, radiator, etc.).

4-6. TIG Welding Connections



- Turn off unit and disconnect input power before making connections.**
- Do not use worn, damaged, under-sized, or repaired cables.**

1 Electrode Weld Output Terminal / Gas Out

2 TIG Torch And Cable

Connect TIG torch to electrode weld output terminal.

3 Work Weld Output Terminal

4 Work Clamp And Cable

Connect work clamp cable to work weld output terminal.

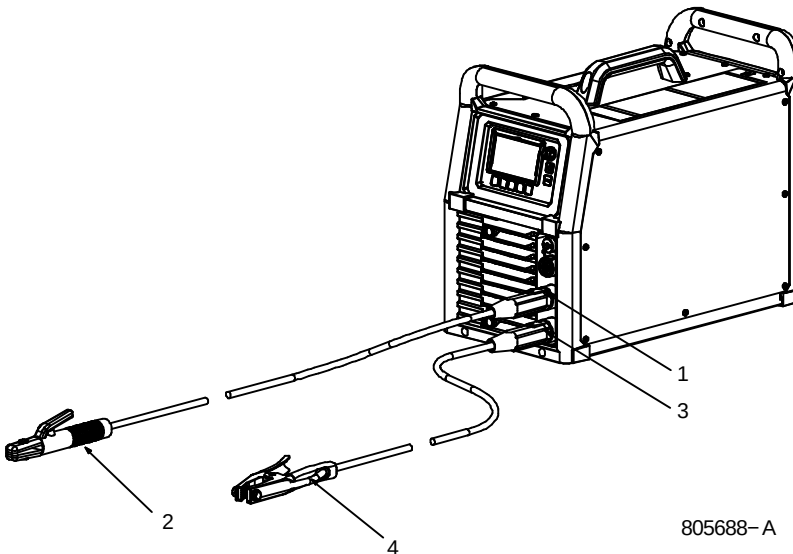
5 Remote Control Receptacle

6 Foot Control And Cable

Connect foot control to remote control receptacle.

805688A

4-7. Stick Welding Connections



- Turn off unit and disconnect input power before making connections.**
- Do not use worn, damaged, under-sized, or repaired cables.**

1 Electrode Weld Output Terminal / Gas Out

2 Stick Electrode Holder And Cable

Connect stick electrode holder cable to electrode weld output terminal.

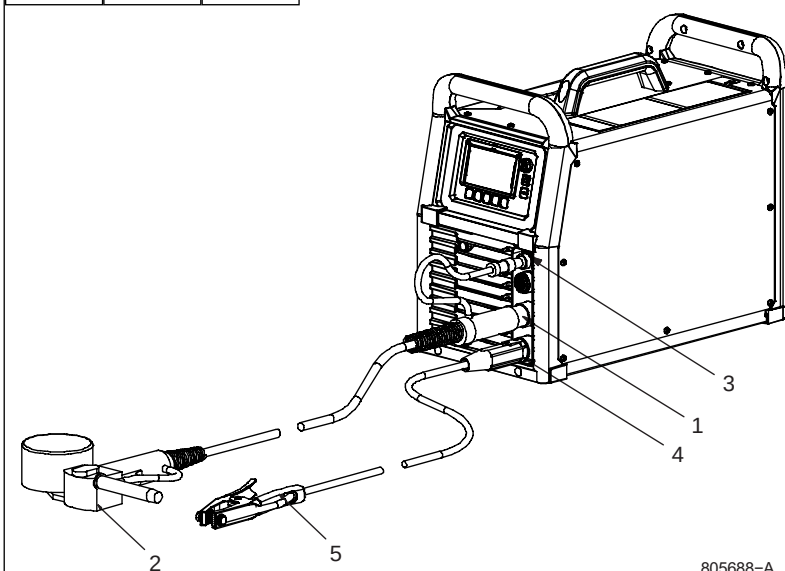
3 Work Weld Output Terminal

4 Work Clamp And Cable

Connect work clamp to weld work output terminal.

805688-A

4-8. Spool Gun Welding Connections



⚠ Turn off unit and disconnect input power before making connections.

⚠ Do not use worn, damaged, undersized, or repaired cables.

1 Electrode Weld Output Terminal / Gas Out

2 Spool Gun And Cable

Connect spool gun to electrode weld output terminal. Spool gun requires power pin twist lock adapter 301861. See Section [4-10](#)

3 Spool Gun Trigger Control Receptacle

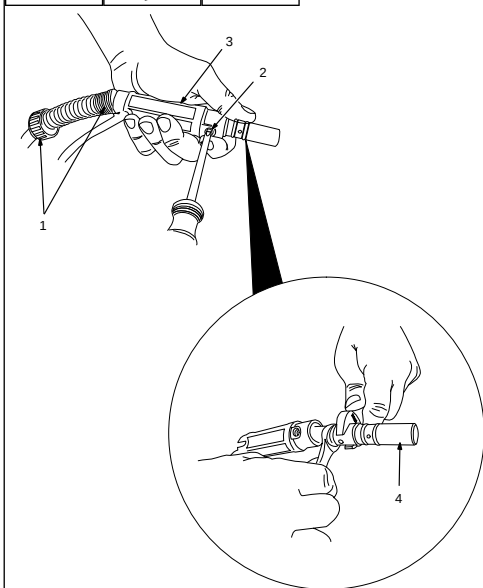
Remove cover on spool gun trigger receptacle. Connect spool gun trigger control cable. Re-install receptacle cover when not in use.

4 Work Weld Output Terminal

5 Work Clamp And Cable

Connect work clamp to weld work output terminal.

4-9. Removing Power Pin Style Connector To Adapt Spoolmate 150 Model For Use With The Syncrowave® 212



⚠ Turn Off welding power source and disconnect spool gun.

Photo 1 -Power Pin Style Connector

Power pin style connector that comes standard with the spool gun must be changed to a Dinse style connector for use with the Syncrowave® 212.

1 Strain relief

Turn strain relief cap 1/4 turn counter clockwise, and slide strain relief down cable.

2 Phillips Screw

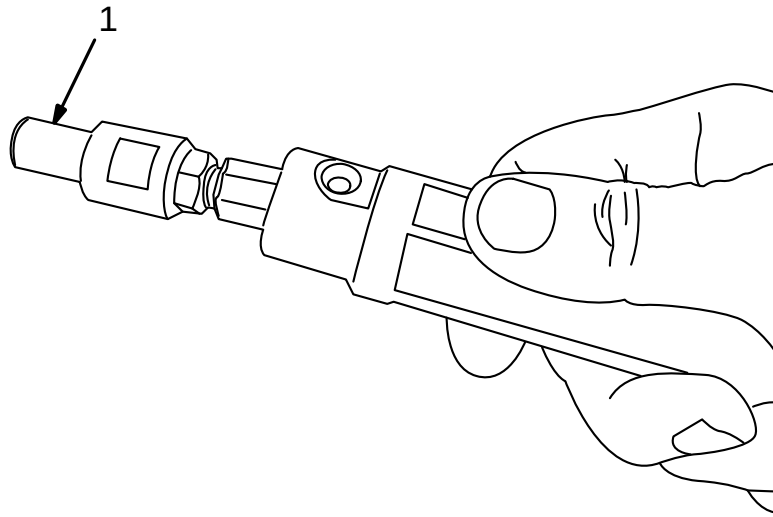
3 Handle

Remove screw, and handle.

4 Power Pin Connector

Use 13 and 17 mm wrenches to remove power pin style connector.

4-10. Installing Dinse Style Connector To Adapt Spoolmate 150 Model For Use With The Syncrowave® 212



 Turn Off welding power source and disconnect spool gun.

1 Dinse Style Connector

Screw on Dinse style connector (301861) and tighten with 13 and 17 mm wrenches.

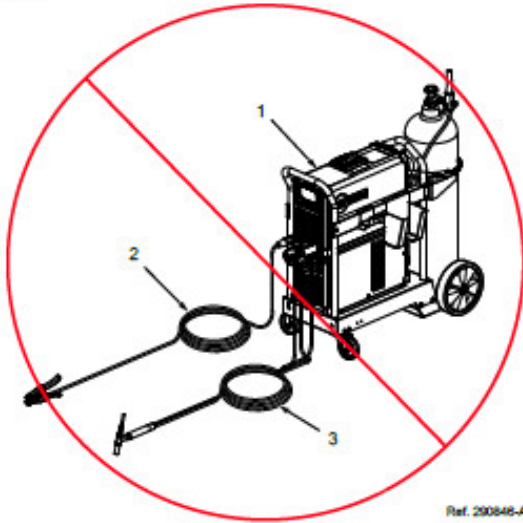
Slide handle back into position, and secure with Phillips screw removed earlier.

Slide strain relief into position, and tighten strain relief cap.

4-11. Arranging Weld Cables To Reduce Welding Circuit Inductance



Bad



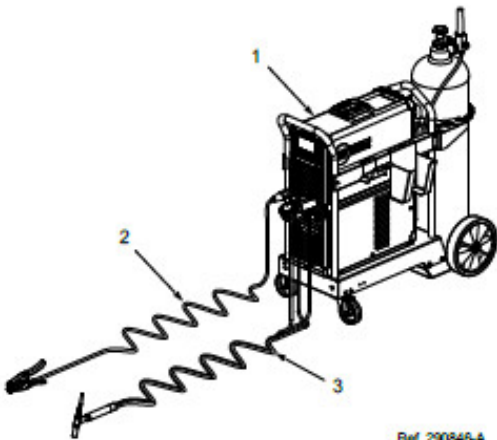
Ref. 290846-A

- 1 Welding Power Source
- 2 Work Cable
- 3 Electrode Cable

The arrangement of the cables has an effect that is significant to the welding properties. As an example, incorrect cable management can lead to higher welding circuit inductance which can result in limited current rise affecting welding performance.

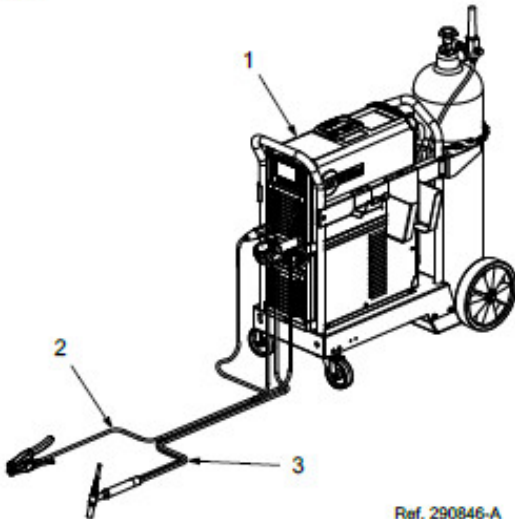
Do not coil excess cables. Use cables that are the appropriate length for the application. Whenever using long weld cables [longer than 50 ft (15 m)] try to arrange positive and negative weld cables together to reduce the magnetic field surrounding the cables.

Better



Ref. 290846-A

Best



Ref. 290846-A

4-12. Electrical Service Guide



Failure to follow these electrical service guide recommendations could create an electric shock or fire hazard. These recommendations are for an individual branch circuit sized for the rated output and duty cycle of one welding power source. In individual branch circuit installations, the National Electrical Code (NEC) allows the receptacle or conductor rating to be less than the rating of the circuit protection device. All components of the circuit must be physically compatible. See NEC articles 210.21, 630.11, and 630.12.

NOTICE – Actual input voltage should not be 10% less than minimum and/or 10% more than maximum input voltages listed in table. If actual input voltage is outside this range, output may not be available.

	50/60 Hz 1-Phase	50/60 Hz 1-Phase
Rated Supply Voltage (V)	120	240
Rated Maximum Supply Current I_{max} (A)	A 15 ampere individual branch circuit protected by time-delay fuses or circuit breaker is required. See Sections 4-13 .	23
Rated Effective Supply Current I_{eff} (A)		14
Maximum Recommended Standard Fuse Rating In Amperes ¹		30
Time Delay Fuses ²		
Normal Operating Fuses ³		40
Maximum Recommended Supply Conductor Length In Feet (Meters) ⁴		51 (16)
Raceway Installation		
Minimum Supply Conductor Size In AWG (mm ²) ⁵		14 (2.5)
Minimum Grounding Conductor Size In AWG (mm ²) ⁵		14 (2.5)

Reference: 2023 National Electrical Code (NEC)
(including article 630)

1 If a circuit breaker is used in place of a fuse, choose a circuit breaker with time-current curves comparable to the recommended fuse.

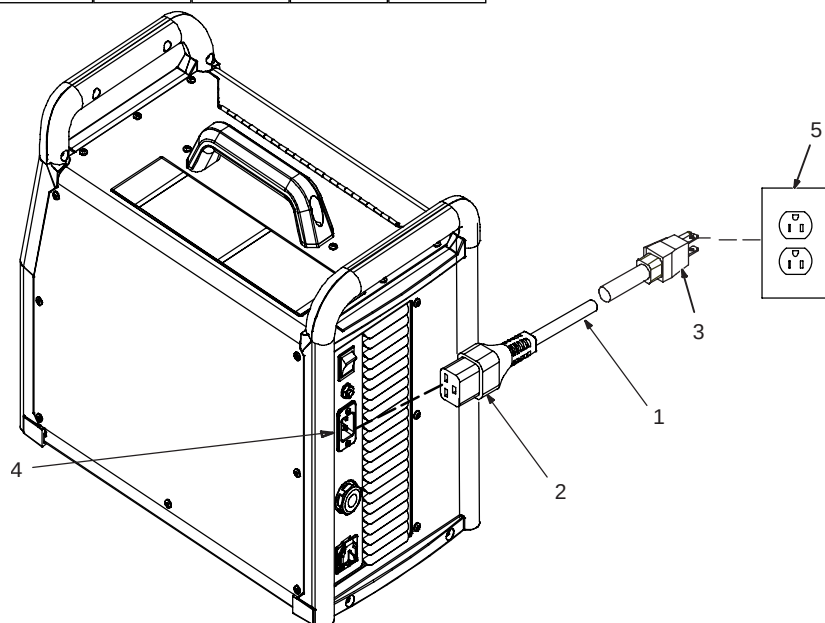
2 "Time-Delay" fuses are UL class "RK5" . See UL 248.

3 "Normal Operating" (general purpose - no intentional delay) fuses are UL class "K5" (up to and including 60 amps), and UL class "H" (65 amps and above). See UL 248.

4 Maximum total length of copper supply conductors in entire installation, raceway and/or flexible cord.

5 Raceway conductor data in this section specifies conductor size (excluding flexible cord or cable) between the panelboard and the equipment per NEC Table 310.16 and is based on allowable ampacities of insulated copper conductors having a temperature rating of 75°C (167°F) with not more than three single current-carrying conductors in a raceway.

4-13. Connecting 120 VAC Input Power



- ⚠ Installation must meet all National and Local Codes—have only qualified persons make this installation.
- ⚠ Special installation may be required where gasoline or volatile liquids are present - see NEC Article 511 or CEC Section 20.
- ⚠ Do not use power cord to lift or carry welding power source.
- ⚠ Remove power cord from receptacle on the back of the welding power source before transporting or storing the unit. Failure to remove power cord may result in damage to the cord.
- ⚠ Do not wrap cord around welding power source or cord may be damaged.

👉 The Auto-Line circuitry in this unit automatically links the power source to the primary voltage being applied, either 120 or 240 VAC.

NOTICE – Do not modify the power cord. The power cord plugs will work with standard NEMA receptacles. Use only the power cords supplied with this unit. Modifying the power cord(s) and/or plugs, or using cords not intended for use with this product will void warranty.

For 120 volts AC input power, a 15 ampere individual branch circuit protected by time-delay fuses or circuit breaker is required.

1 Power Cord, 120 VAC

120 VAC cord with NEMA type 5-15P plug.

2 Plug - IEC/EN 60320–1 C19

Pull back on red tab to remove from receptacle.

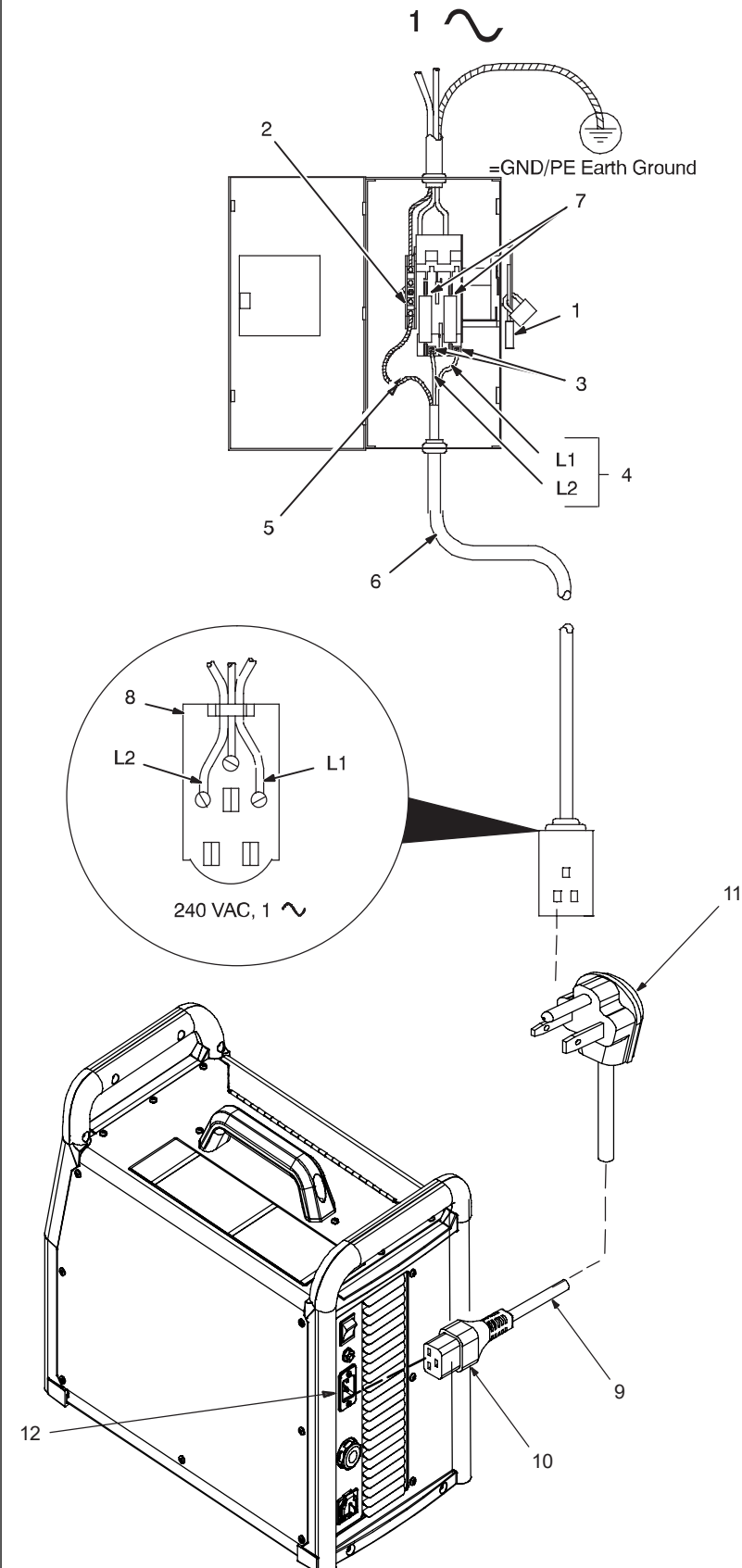
3 Plug - NEMA Type 5-15P

4 Receptacle - IEC/EN 60320–1 C20

5 Receptacle - NEMA Type 5-15R

Connect plug (3) to receptacle (5).

4-14. Connecting 1-Phase 240 VAC Input Power



- ⚠ Installation must meet all National and Local Codes—have only qualified persons make this installation.**
- ⚠ Disconnect and lockout/tagout input power before connecting input conductors from unit. Follow established procedures regarding the installation and removal of lockout/tagout devices.**
- ⚠ Always connect green or green/yellow conductor to supply grounding terminal first, and never to a line terminal.**

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

- 1 Disconnect Device (switch shown in the OFF position)
- 2 Disconnect Device Grounding Terminal
- 3 Disconnect Device Line Terminals
- 4 Black And White Input Conductor (L1 And L2)
- 5 Green Or Green/Yellow Grounding Conductor
- 6 Input Power Cord

Connect green or green/yellow grounding conductor to disconnect device grounding terminal first.

Connect input conductors L1 and L2 to disconnect device line terminals.

7 Over-Current Protection

Select type and size of over-current protection using Electrical Service Guide (fused disconnect switch shown).

8 Receptacle (NEMA 6-50R) Customer Supplied

Close and secure door on disconnect device. Follow established lockout/tagout procedures to put unit in service.

9 Power Cord

240 VAC cord with NEMA type 6-50P plug.

10 Plug — IEC/EN 60320–1 C19

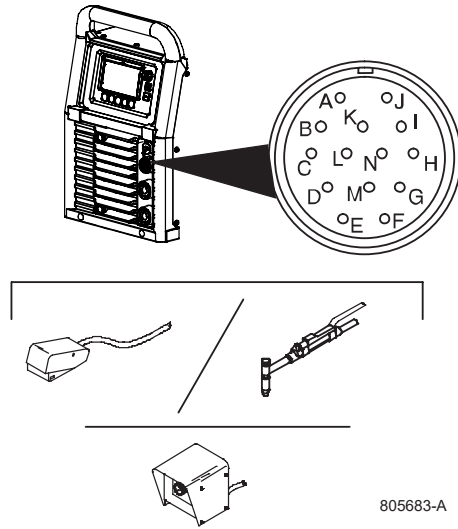
Pull back on red tab to remove from receptacle.

11 Plug — NEMA Type 6–50P

12 Receptacle — IEC/EN 60320–1 C20

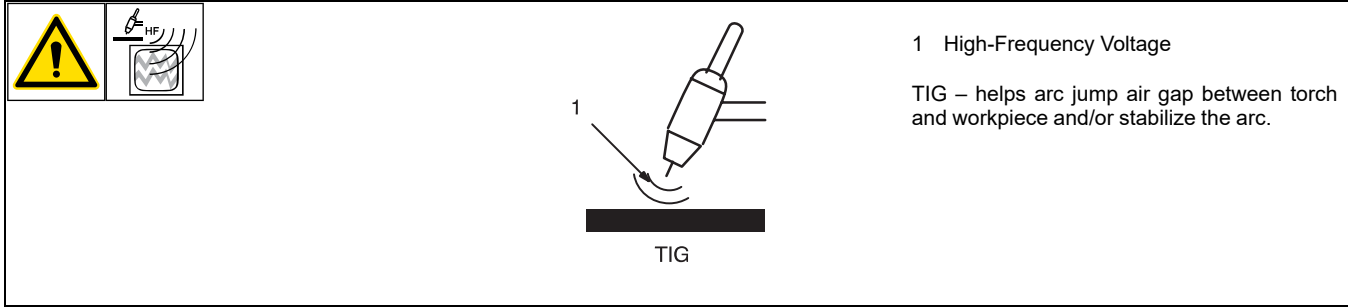


4-15. Remote 14 Receptacle Information

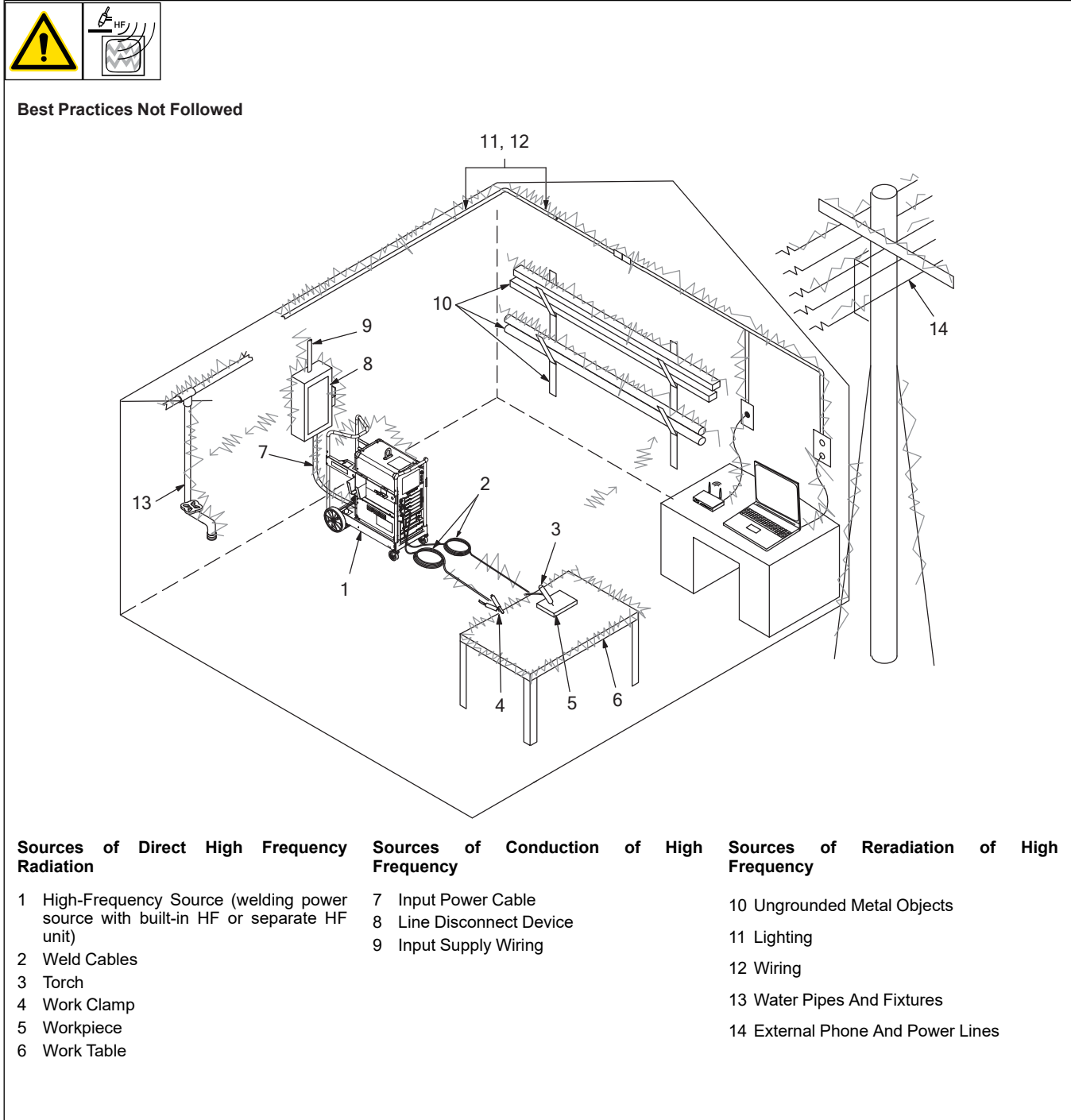
	Remote 14	Socket	Socket Information
	15 Volts DC Output Contactor	A	Contact control +15 volts DC, referenced to D.
		B	Contact closure to A completes 15 volts DC contactor control circuit and enables output.
	Remote Output Control	C	Output to remote control; +10 volts DC output to remote control.
		D	Remote control circuit common.
		E	0 to +10 volts DC input command signal from remote control.
	Chassis	K	Chassis

SECTION 5 – HIGH FREQUENCY

5-1. Welding Processes Requiring High Frequency



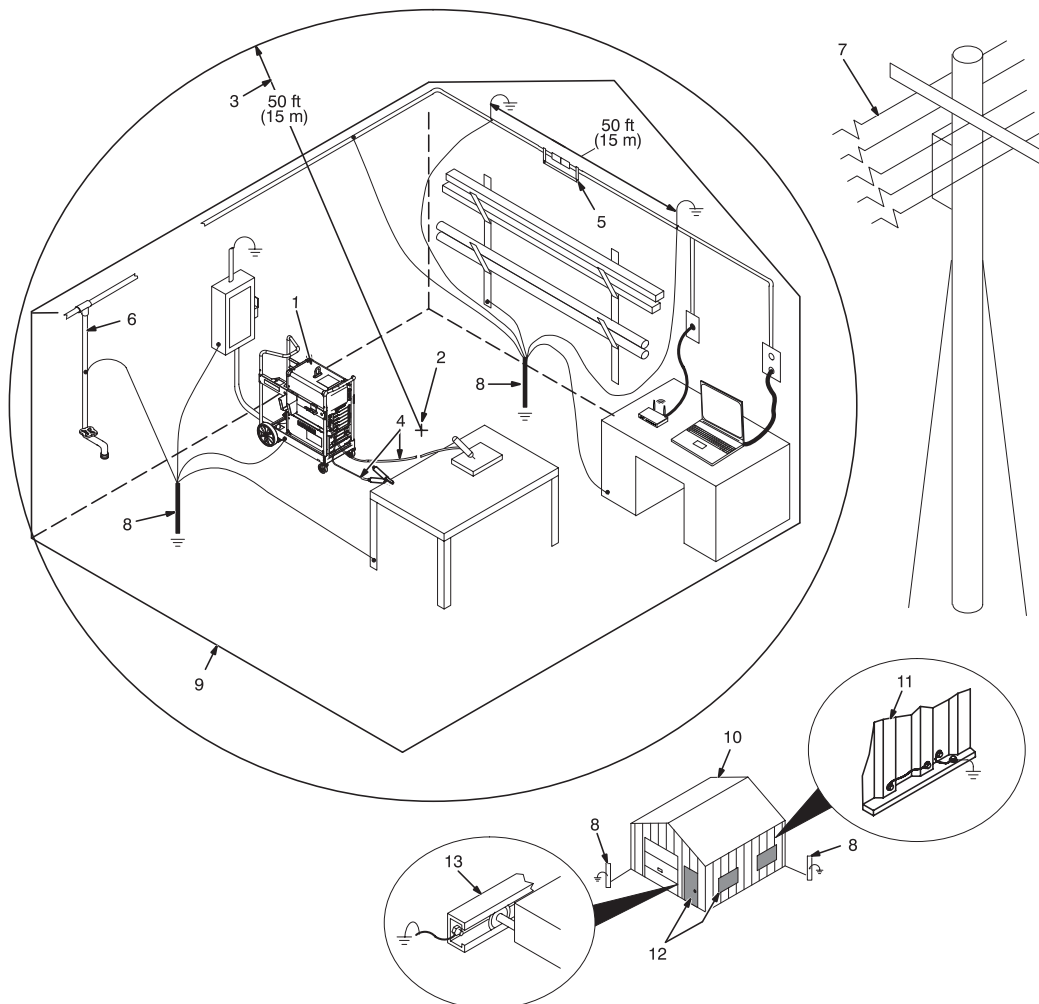
5-2. Installation Showing Possible Sources Of HF Interference



5-3. Recommended Installation To Reduce HF Interference



Best Practices Followed



- 1 High-Frequency Source (welding power source with built-in HF or separate HF unit)

Ground metal machine case (clean paint from around hole in case, and use case screw), work output terminal, line disconnect device, input supply, and worktable.

- 2 Center Point Of Welding Zone

Midpoint between high-frequency source and welding torch.

- 3 Welding Zone

A circle 50 ft (15 m) from center point in all directions.

- 4 Weld Output Cables

Keep cables short and close together.

- 5 Conduit Joint Bonding and Grounding

Electrically join (bond) all conduit sections using copper straps or braided wire. Ground conduit every 50 ft (15 m).

- 6 Water Pipes and Fixtures

Ground water pipes every 50 ft (15 m).

- 7 External Power or Telephone Lines

Locate high-frequency source at least 50 ft (15 m) away from power and phone lines.

- 8 Grounding Rod

Consult the National Electrical Code for specifications.

Ground all metal objects and all wiring in welding zone using #12 AWG wire.

Ground workpiece if required by codes.

- 9 Nonmetal Building

Metal Building Requirements

- 10 Metal Building

- 11 Metal Building Panel Bonding Methods

Bolt or weld building panels together, install copper straps or braided wire across seams, and ground frame.

- 12 Windows and Doorways

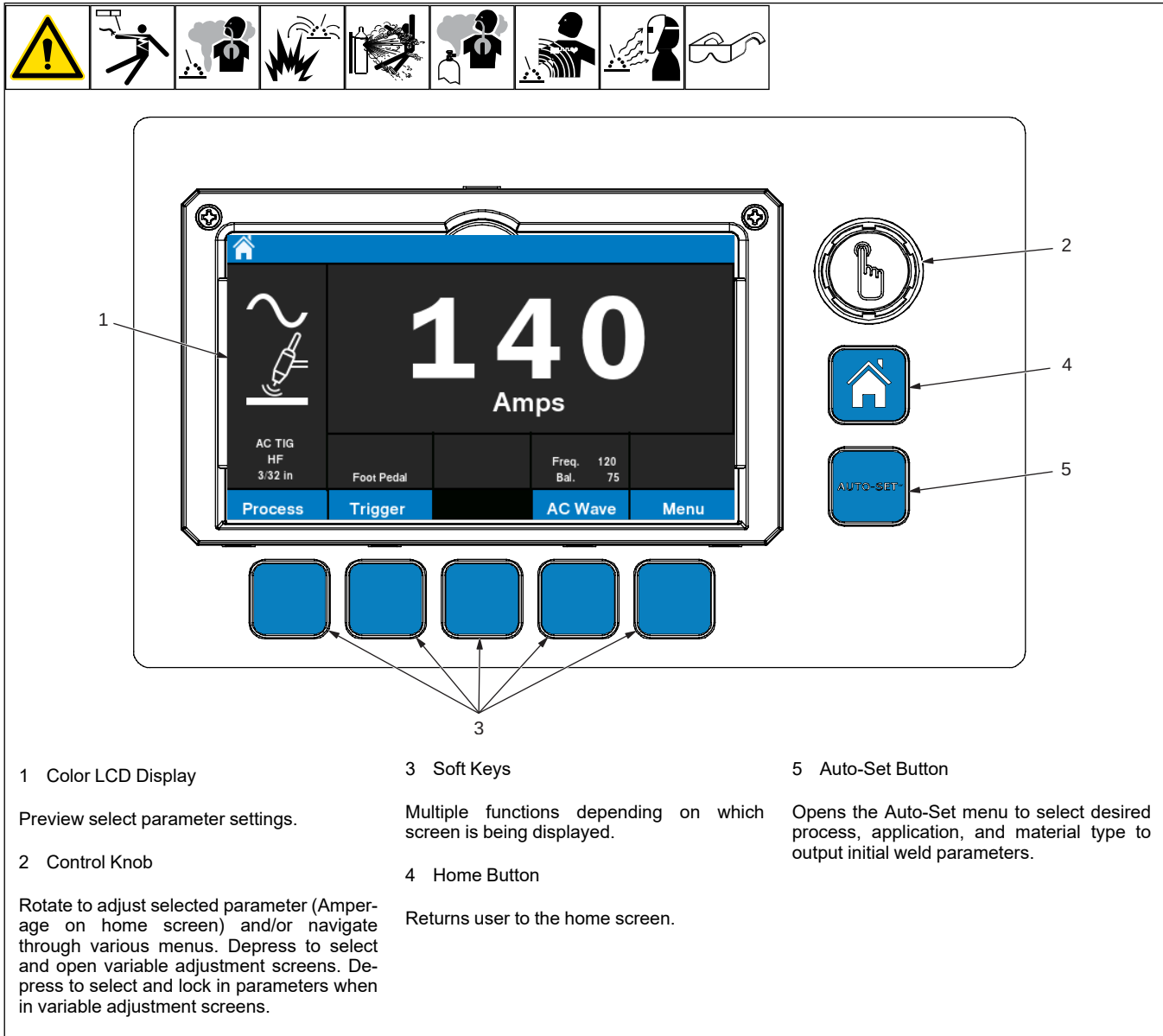
Cover all windows and doorways with grounded copper screen of not more than 1/4 in (6.4 mm) mesh.

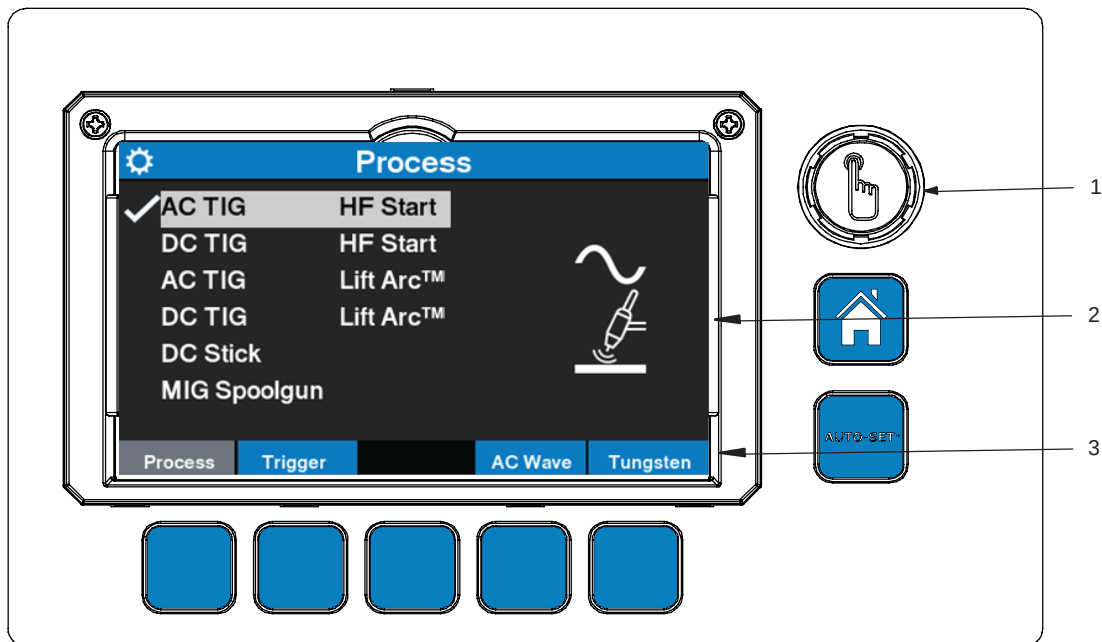
- 13 Overhead Door Track

Ground the track.

SECTION 6 – OPERATION

6-1. Home Screen - Primary





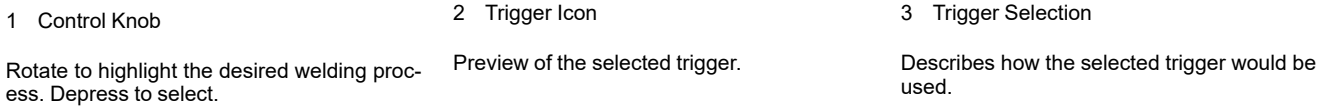
- ## 2 Process Icon

- ### 3 Tungsten Menu

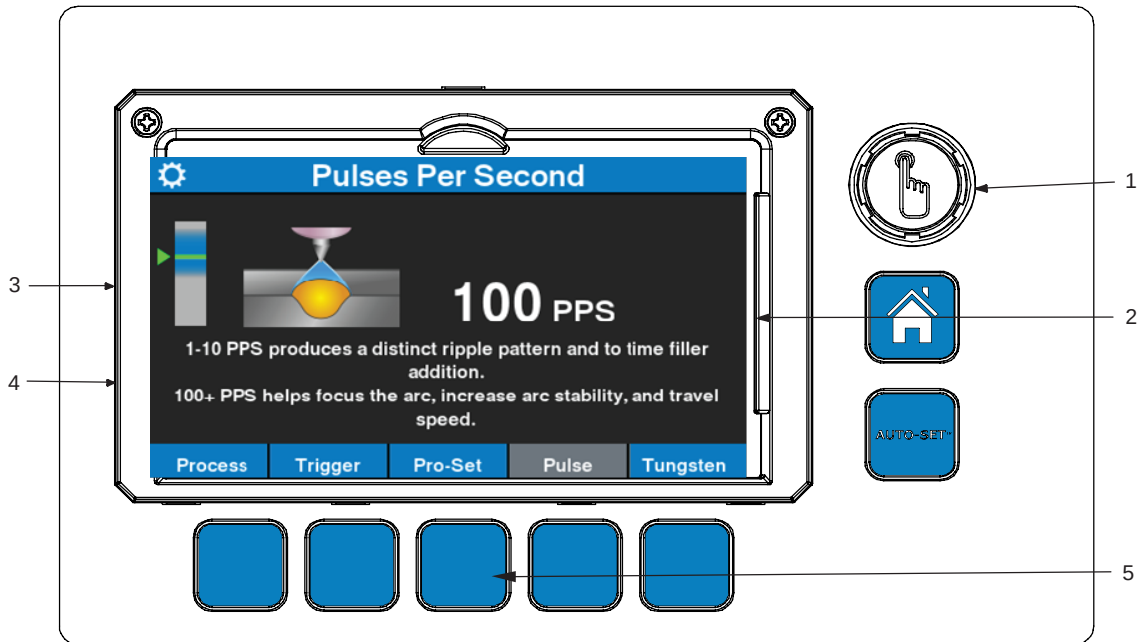
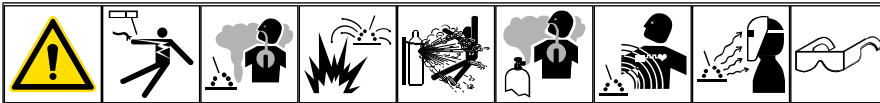
Rotate to highlight the desired welding process. Depress to select.

Displays the IEC symbol for the highlighted process.

Select Tungsten diameter to optimize arc starting.



6-4. Pulse Menu



1 Control Knob

Rotate to adjust desired Pulse Per Second setting.

2 Parameter Value

Shows the current selected value.

3 Dynamic Visualization

Provides a generalized representation of what the user might expect to happen under normal operating conditions.

Accuracy of representation will vary based on other parameter selections.

4 Text Descriptions

Describes how different pulse ranges can be used.

5 Pro-Set Soft Key

Depress to return to the recommended pulse setting.

****Pulse will not operate below a commanded amperage of 30 amps.*

6-5. AC Waveform Selection





AC Wave

AC Frequency

120 Hz

AC Balance

75 %

Process

Trigger

AC Wave

Tungsten



1

2

3

4

1 Control Knob

Rotate to highlight the desired parameter. Depress to select and enter parameter adjustment screen.

2 Parameter Value

Shows the current selected value.

3 AC Frequency Control

Controls the width of the arc cone. Increasing the AC Frequency provides a more focused arc and increased directional control. Decreasing the AC Frequency softens the arc and broadens the weld puddle for a wider weld.

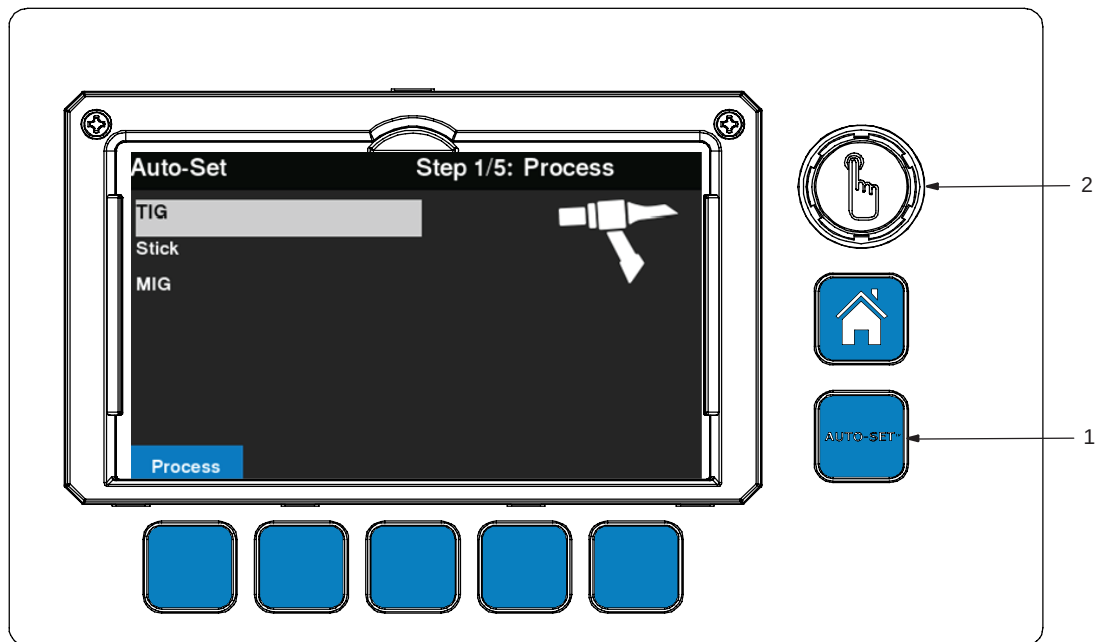
4 AC Balance Control

Controls arc cleaning action. Adjusting the % EN of the AC wave controls the width of the etching zone surrounding the weld.

Set the AC Balance control for adequate arc cleaning (etching) action at the sides and in front of the weld puddle. AC Balance should be fine-tuned according to the amount of etching desired.

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6-6. Auto-Set Selection (1 of 3)



1 Auto Set Menu

Select Auto-Set soft key to enter Auto Set menu.

2 Control Knob

Rotate to highlight the desired Auto-Set input. Depress to select and move to the next screen.

Auto-Set is continued on the following pages.

6-7. Auto-Set Selection (2 of 3)



Auto-Set

Page 1/2

Selections

Process	TIG
Material	Steel
Thickness	20 ga
Joint	Lap
Tungsten	1/16 in

Restart

Next



1

1

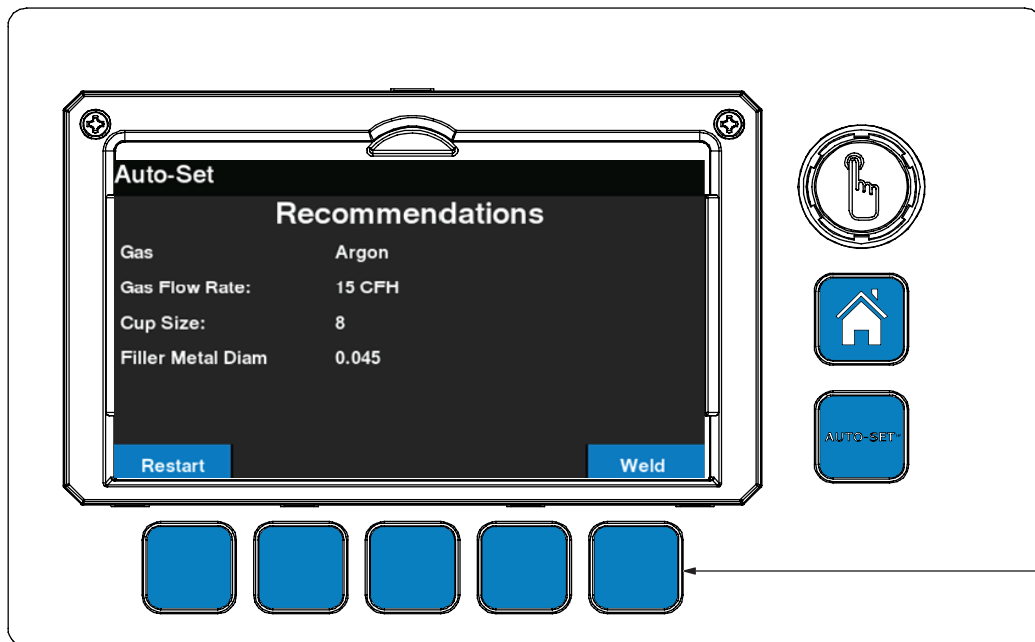
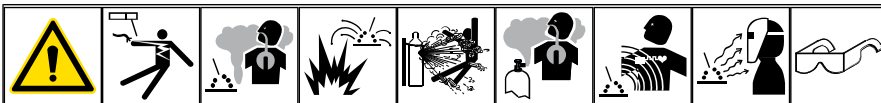
Next/Weld Soft Key

Depress this key to move through the Auto-Set outputs and enter weld parameters to the machine.

Auto-Set is continued on the following page.

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6-8. Auto-Set Selection (3 of 3)



1 Next/Weld Soft Key

Depress this key to move through the Auto-Set outputs and enter weld parameters to the machine.

6-9. Tech Menu



2

3

4

5

Menu

System Information

Postflow

Languages

Cooler Power Supply

Menu

1

1 Control Knob

Factory reset, System software numbers, arc counter,

All display text will change based on selection.

2 System Information

3 Post Flow

4 Languages

5 Cooler Power Supply

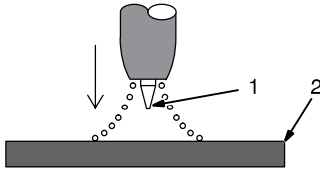
Set the cooler power supply to Auto, On (continuous), Off.

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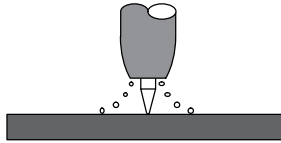
6-10. Lift-Arc And HF TIG Start Procedures



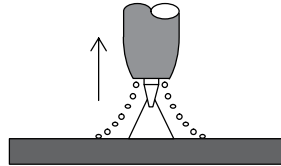
Lift-Arc Start Method



“Touch” 1–2 Seconds



Do NOT Strike Like A Match!



Lift-Arc Start

When Lift-Arc button is selected, start arc as follows:

- 1 TIG Electrode
- 2 Workpiece

Touch tungsten electrode to workpiece at weld start point, enable output and shielding gas with torch trigger, foot control, or hand control. **Hold electrode to workpiece for 1–2 seconds**, and slowly lift electrode. Arc is formed when electrode is lifted.

Normal open-circuit voltage is not present before tungsten electrode touches workpiece; only a low sensing voltage is present between electrode and workpiece. The solid-state output contactor does not energize until after electrode is touching workpiece. This allows a properly prepared electrode (see Section 7) to touch workpiece without overheating, sticking, or getting contaminated.

Application:

Lift-Arc is used for the DCEN or AC GTAW process when HF Start method is not permitted, or to replace the scratch method.

HF Start

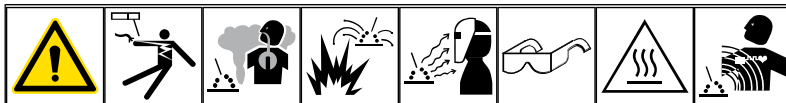
When HF Start button is selected, start arc as follows:

High frequency turns on to start arc when output is enabled. High frequency turns off when arc is started, and turns on whenever arc is broken to help restart arc.

Application:

HF start is used for the DCEN GTAW, or the AC GTAW process when a non-contact arc starting method is required.

6-11. Electrode And Amperage Selection Chart



ELECTRODE	DIAMETER	AMPERAGE RANGE									
		50	100	150	200	250	300	350	400	450	
6010 & 6011	3/32										
	1/8										
	5/32										
	3/16										
	7/32										
	1/4										
6013	1/16										
	5/64										
	3/32										
	1/8										
	5/32										
	3/16										
	7/32										
	1/4										
7014	3/32										
	1/8										
	5/32										
	3/16										
	7/32										
7018	1/4										
	3/32										
	1/8										
	5/32										
	3/16										
7024	7/32										
	1/4										
	3/32										
	1/8										
	5/32										
Ni-CI	3/16										
	7/32										
	1/4										
308L	3/32										
	1/8										
	5/32										

ELECTRODE	DC*	AC	POSITION	PENETRATION	USAGE
6010	EP		ALL	DEEP	MIN. PREP, ROUGH HIGH SPATTER
6011	EP	✓	ALL	DEEP	
6013	EP,EN	✓	ALL	LOW	GENERAL
7014	EP,EN	✓	ALL	MED	SMOOTH, EASY, FAST
7018	EP	✓	ALL	MED	LOW HYDROGEN, STRONG
7024	EP,EN	✓	FLAT HORIZ*	LOW	SMOOTH, EASY, FASTER
NI-CL	EP	✓	ALL	LOW	CAST IRON
308L	EP	✓	ALL	LOW	STAINLESS

*EP = ELECTRODE POSITIVE (REVERSE POLARITY)
EN = ELECTRODE NEGATIVE (STRAIGHT POLARITY)

SECTION 7 – SELECTING AND PREPARING A TUNGSTEN FOR DC OR AC WELDING WITH INVERTER MACHINES

7-1. Selecting Tungsten Electrode



Whenever possible and practical, use DC weld output instead of AC weld output.

NOTICE – Wear clean gloves to prevent contamination of tungsten.

A. Select Tungsten Electrode

Amperage Range By Gas Type* And Polarity		
Electrode Diameter (2% Ceriated or 1.5% Lanthanum Alloy Tungstens)	DCEN – Argon Direct Current Electrode Negative (For Use With Mild Or Stainless Steel)	AC – Argon Unbalanced Wave (75% EN Balance) (For Use With Aluminum)
0.010 in. (0.25 mm)	Up to 15	Up to 15
0.020 in. (0.50 mm)	5–20	5–20
0.040 in. (1 mm)	15–80	15–80
1/16 in. (1.6 mm)	70–150	70–150
3/32 in. (2.4 mm)	150–200	140–235
1/8 in. (3.2 mm)	250–400	225–325
5/32 in. (4.0 mm)	400–500	300–400
3/16 in. (4.8 mm)	500–750	400–500
1/4 in. (6.4 mm)	750–1000	500–630

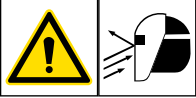
*Typical argon shielding gas flow rates are 10 to 25 CFH (cubic feet per hour).
Figures listed are a guide and are a composite of recommendations from American Welding Society (AWS).

B. Electrode Composition

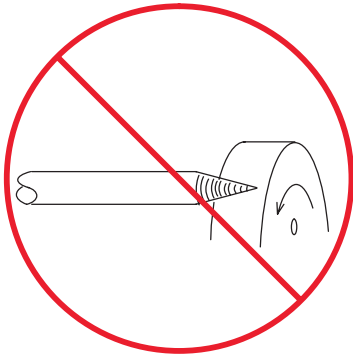
Tungsten Type	Application Notes
2% Cerium (Gray)	Good all-around tungsten for both AC and DC welding.
1.5–2% Lanthanum (Yellow/Blue)	Excellent low amp starts for AC and DC welding.
Pure Tungsten (Green)	Not recommended for inverters! For best results in most applications, use a sharpened cerium or lanthanum electrode for AC or DC welding.

 Not all tungsten electrode manufacturers use the same colors to identify tungsten type. Contact the tungsten electrode manufacturer or reference the product packaging to identify the tungsten you are using.

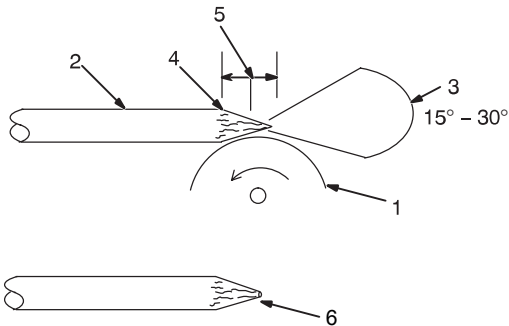
7-2. Preparing Tungsten Electrode For DC Electrode Negative (DCEN) Welding Or AC Welding With Inverter Machines



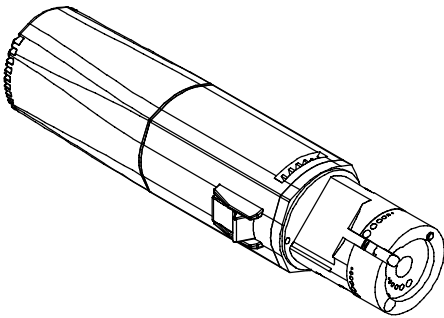
Wrong Tungsten Preparation — Radial Grinding Causes Wandering Arc



Better Tungsten Preparation — Stable Arc



Best Tungsten Preparation — Dedicated Tungsten Grinder



⚠ Grinding the tungsten electrode produces dust and flying sparks which can cause injury and start fires. Use appropriate local exhaust (forced ventilation) at the grinder or wear an approved respirator. Read SDS for safety information. Properly dispose of grinder dust in an environmentally safe way. Wear proper face, hand, and body protection. Keep flammables away.

⚠ Do not use thoriated tungsten. Use tungsten containing ceria, lanthana, or yttria instead of thoria. Grinding dust from thoriated electrodes contains low-level radioactive material.

☞ It is recommended to prepare tungsten with a tungsten grinder designed for that purpose whenever possible.

1 Grinding Wheel

Grind end of tungsten on fine grit, hard abrasive wheel before welding. Do not use wheel for other jobs or tungsten can become contaminated causing lower weld quality.

2 Tungsten Electrode

A 2% ceriated tungsten is recommended.

3 Ideal Grind Angle Range: 15° to 30°

☞ 30 degrees is the recommended electrode grind angle.

4 Straight Ground

Grind lengthwise, not radial.

5 1-1/2 to 4 Times Electrode Diameter

6 Straight Ground Tip

☞ Blunting the tip of the electrode is sometimes done to help maintain consistent geometry and resist tungsten erosion. This is especially helpful in AC when melt-back of the tungsten electrode is common.

SECTION 8 – MAINTENANCE AND TROUBLESHOOTING

8-1. Routine Maintenance

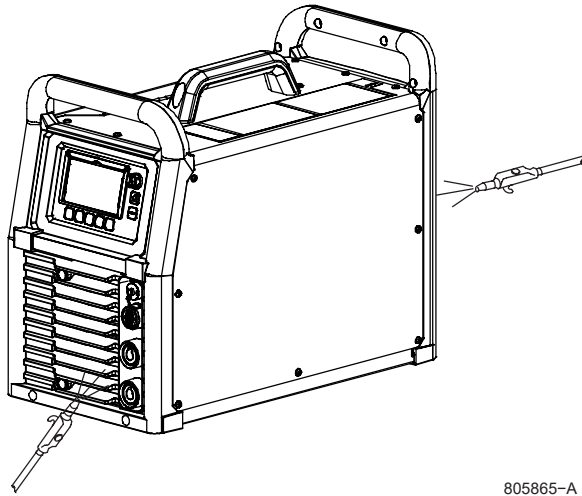
A. Welding Power Source

  Disconnect power before maintaining.  <i>Service equipment more often if used in severe conditions.</i>			
Maintenance Schedule		Every 3 Months	Every 6 Months
Cords and Cables	Visually Check condition of Cables and Cords. Replace if damaged.	•	
Gas Hoses	Visually Check condition of Gas Hoses. Replace if damaged.	•	
Labels	Visually Check condition of Labels. Replace if damaged.	•	
Weld Connections	Visually Check Weld Connections. Clean and Tighten Weld Connections.	•	
External Vent Openings	Blow out inside of External Vent Openings. During heavy service clean monthly. (See Section 8-2)  Do not remove case when blowing out inside of unit.		•

B. Optional Cooler

Maintenance Schedule		Every 3 Months	Every 6 Months	Every 12 Months
Heat Exchanger Fins	Blow out heat exchanger fins.	•		
Coolant Level	Check coolant level. Top off with distilled or deionized water if necessary.	•		
Hoses	Check hoses and replace if damaged.		•	
Labels	Check labels and replace if damaged.		•	
Coolant	Change coolant (if using water)		•	
Coolant	Change coolant (if using Miller coolant)			•

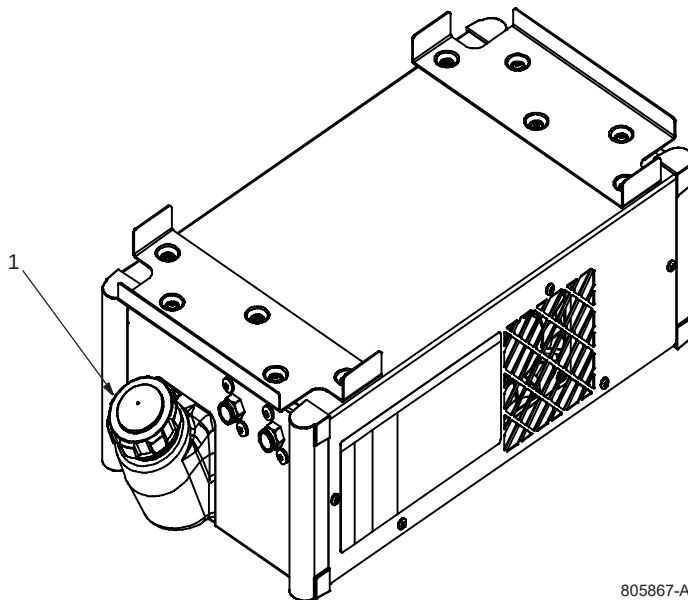
8-2. Blowing Out Inside Of Unit



⚠ Do not remove case when blowing out inside of unit.

To blow out unit, direct airflow through front and back louvers as shown.

8-3. Coolant Maintenance



⚠ Disconnect input power before maintaining.

⚠ Dispose of used coolant according to national, state, and local codes. Do not pour down drain.

NOTICE – Do not run cooler without coolant in tank.

1 Coolant Fill Cap

Changing Coolant

Changing coolant: Drain coolant by removing cap and tipping unit forward, or use suction pump. Fill with clean water and run for 10 minutes. Drain and refill with coolant (see Sections [8-4](#)). Install cap.

NOTICE – If replacing hoses, use hoses compatible with ethylene glycol, such as Buna-n, Neoprene, or Hypalon. Oxy-acetylene hoses are not compatible with any product containing ethylene glycol.

8-4. Coolant Specifications



Do not use conductive coolant.

Application	Coolant
GTAW Or Where High Frequency Current Is Used	Low Conductivity Coolant 043810* Distilled Or Deionized Water Okay Above 32°F (0°C)
GMAW Or Where High Frequency Current Is Not Used	Low Conductivity Coolant 043810* Aluminum Protecting Coolant 043809* Distilled Or Deionized Water Okay Above 32°F (0°C)
Where Coolant Contacts Aluminum Parts	Aluminum Protecting Coolant 043809*
*Coolants 043810 and 043809 protect to -37°F (-38°C) and resist algae growth.	
NOTICE – Use of any coolant other than those listed in the table voids the warranty on any parts that come in contact with the coolant (pump, radiator, etc.).	

8-5. Troubleshooting Table

    	
Trouble	Remedy
No weld output; unit completely inoperative.	Place line disconnect switch in On position (see Section 4-14).
	Check and replace line fuse(s), if necessary, or reset circuit breaker (see Section 4-14).
	Check for proper input power connections (see Section 4-13 or 4-14).
No weld output; meter display On.	If using remote control, be sure correct process is enabled to provide output control at Remote 14 receptacle (see Section 4-15 as applicable).
	Input voltage outside acceptable range of variation (see Section 4-12).
	Check, repair, or replace remote control.
	Unit overheated. Allow unit to cool with fan On (see Section 3-3).
Erratic or improper weld output.	Use proper size and type of weld cable (see Section 4-2).
	Clean and tighten all weld connections (see Section 8-1).
Fan not operating.	Check for and remove anything blocking fan movement.
	Have Factory Authorized Service Agent check fan motor.
Wandering arc.	Use proper size tungsten (see Section 7).
	Use properly prepared tungsten (see Section 7).
	Reduce gas flow rate.
Tungsten electrode oxidizing and not remaining bright after conclusion of weld.	Shield weld zone from drafts.
	Increase postflow time.
	Check and tighten all gas fittings (see Section 8-1).
	Water in torch. Refer to torch manual.
Blank display.	Verify Power to machine.

8-6. Recommended Spare Parts

Recommended Spare Parts

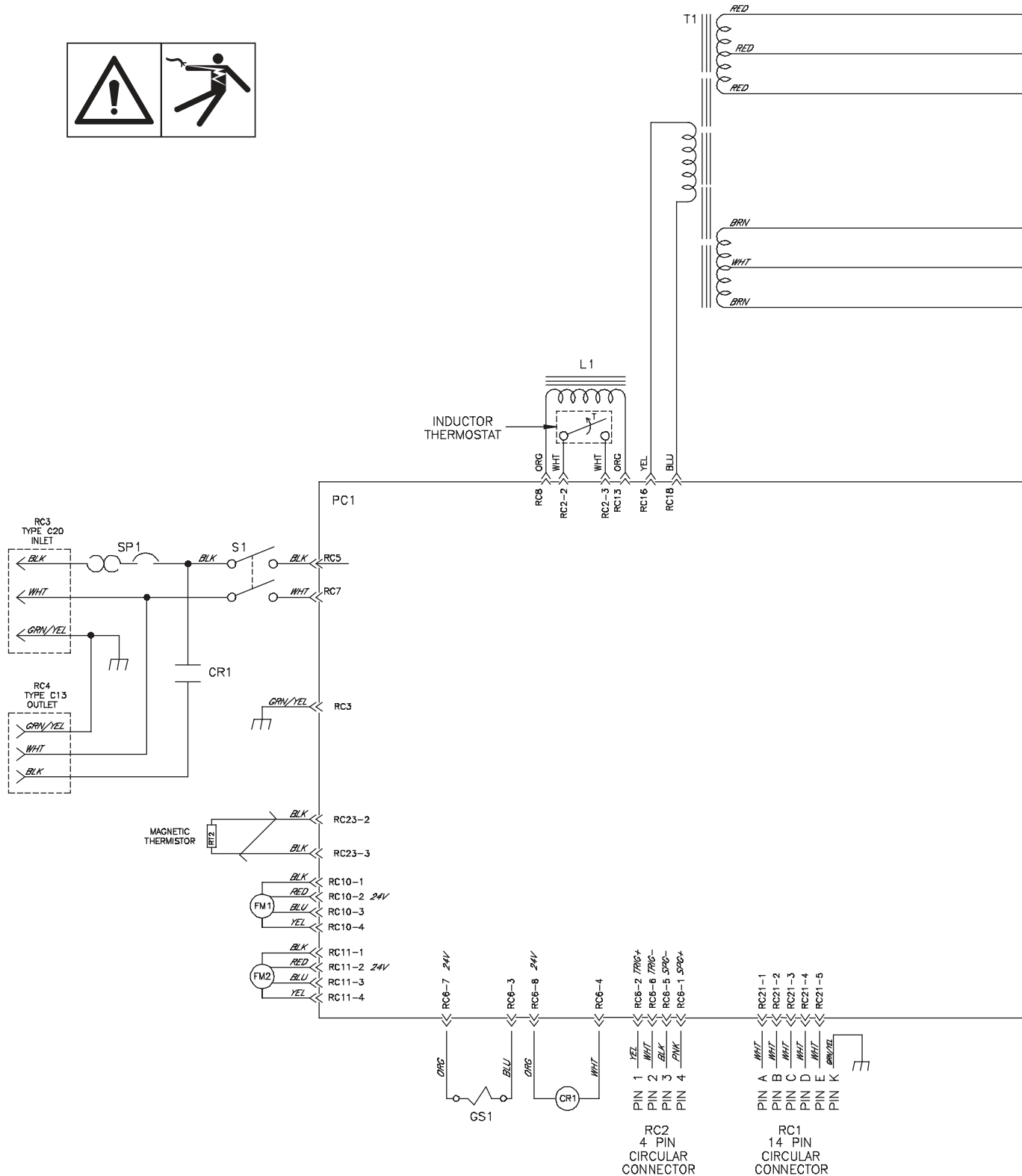
Dia. Mkgs.	Part No.	Description	Quantity
	043810	Coolant	1
	290084	Lens Cover, Replaceable	1
	298527	Cable, Power 2.0M 14GA 3C C19 To 6–50P	1
	297757	Cable, Power 2.0M 14GA 3C C19 To 5–15P	1

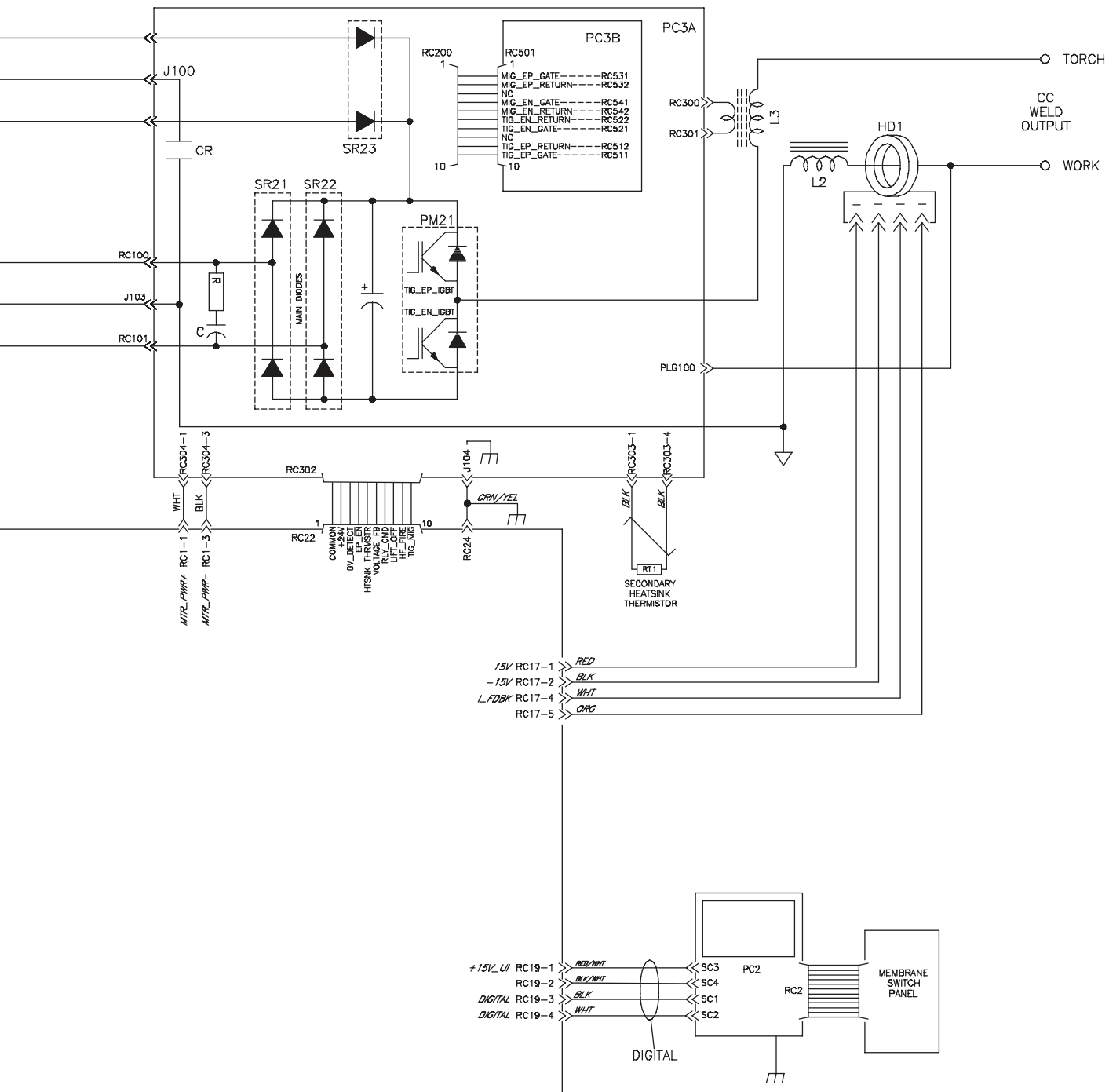
+When ordering a component originally displaying a precautionary label, the label should also be ordered. Labels available separately or as part of label kit.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.

SECTION 9 – ELECTRICAL DIAGRAMS

Circuit Diagram For Syncrowave 212





298765-A

SECTION 10 – REGULATORY/COMPLIANCE INFORMATION

10-1. Serial Number And Rating Label Location

The serial number and rating information for this product is located on the back of unit. 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.

10-2. 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.

10-3. 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.

10-4. Static Characteristics

The static (output) characteristics of the welding power source can be described as *flat* during the GMAW process and *drooping* during the SMAW and GTAW processes. Static characteristics are also affected by control settings (including software), electrode, shielding gas, weldment material, and other factors. Contact the factory for specific information on the static characteristics of the welding power source.

10-5. Environmental Specifications

A. IP Rating

IP Rating
IP21
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)

*Output is derated at temperatures above 104°F (40°C).

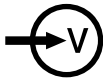
SECTION 11 – DEFINITIONS

11-1. Additional Safety Symbol Definitions

	Warning! Watch Out! There are possible hazards as shown by the symbols.
	Do not remove or paint over (cover) the label.

11-2. Miscellaneous Symbols And Definitions

 Some symbols are found only on CE products.

A	Amperage	I₂	Rated Welding Current		Shielded Metal Arc Welding (SMAW)
	Gas Tungsten Arc Welding (GTAW)	X	Duty Cycle		Protective Earth (Ground)
V	Voltage	=	Direct Current (DC)	1~	Single Phase
	Input Voltage		Line Connection		Gas Metal Arc Welding
	Circuit Breaker	U₂	Conventional Load Voltage	U_p	Rated Peak Voltage
	Remote	U₁	Primary Voltage	U_s	
I	On	IP	Degree of Protection		Home
O	Off	I_{1max}	Rated Maximum Supply Current		Push Button
+	Positive	I_{1eff}	Maximum Effective Supply Current		Work Connection
-	Negative	U₀	Rated No Load Voltage (OCV)		Electrode Connection
~	Alternating Current (AC)	%	Percent		
	Gas Input	Hz	Hertz		

Notes

Notes

Notes



Effective January 1, 2025 (Equipment with a serial number preface of NF 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. 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.

1 5 Years Parts — 3 Years Labor

- Original Main Power Rectifiers Only to Include SCRs, Diodes, and Discrete Rectifier Modules in non-inverter products

2 4 Years Parts (No Labor)

- Auto-Darkening ClearLight 2.0 and 4x Helmet Lenses

3 3 Years — Parts and Labor Unless Specified

- Auto-Darkening Helmet Lenses (No Labor)
- Copilot Collaborative Welding Systems
- Engine and Hydraulic Driven Welder/Generators (Including EnPak) (**NOTE: Engines are Warranted Separately by the Engine Manufacturer.**)
- Handheld Laser Power Sources
- 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

4 2 Years — Parts and Labor

- Auto-Darkening Weld Masks (No Labor)
- Fume Extractors - Filtair 215, Capture 5, Purifier, and Industrial Collector Series

5 1 Year — Parts and Labor Unless Specified

- ArcCapture Camera
- ArcReach Heater
- AugmentedArc, LiveArc, and MobileArc Welding Systems
- Automatic Motion Devices
- Bernard BTB Air-Cooled MIG Guns (No Labor)
- CoolBelt, PAPR Blower, and PAPR Face Shield (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, Standard, Telescopic, and ZoneFlow Extraction Arms and Motor Control Box
- Handheld Laser Torches (No Labor)
- Induction Heating Power Sources, Coolers (**NOTE: Digital Recorders are Warranted Separately by the Manufacturer.**)
- Insight Sensors
- Laser Welding Helmets (No Labor)
- Load Banks
- MDX Series MIG Guns (No Labor)
- Motor-Driven Guns
- Positioners and Controllers
- Racks (For Housing Multiple Power Sources)
- Running Gear/Trailers
- Spoolmate Spoolguns (No Labor)
- Subarc Wire Drive Assemblies
- Supplied Air Respirator (SAR) Boxes and Panels
- TIG Torches (No Labor)
- Tregaskiss Guns (No Labor)
- Venture 150 Battery (Warranted for 1 year or 1000 charge cycles, whichever comes first)
- Water Cooling Systems
- Wireless Remote Foot/Hand Controls and Receivers
- Work Stations/Weld Tables/Weld Booths (No Labor)
- XT Plasma Cutting Torches (No Labor)

6 6 Months — Parts

- 12 Volt Automotive-Style Batteries
- PAPR Batteries

7 90 Days — Parts

- Accessories (Kits)
- ArcReach Heater Quick Wrap and Air Cooled Cables
- Canvas Covers
- Induction Heating Coils and Blankets, Cables, Rolling Inductor, and Non-Electronic Controls
- M-Guns
- Subarc (SAW) Torches and External Cladding Heads
- Remote Controls and RFCS-RJ45
- Replacement Parts (No labor)

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? 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

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
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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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