



ITEM# 280

QUICK START GUIDE

Forney®

1.

**Read User Manual**

2.

Set Polarity

Refer to the electrode manufacturer recommendation for polarity.

Usually DCEP
Ground -
Electrode Holder +

3.

Ground Workpiece

Connect ground clamp to clean, bare metal.



4.

**Connect to 120/240V Input Power**

- Generator Safe: Use power source with 4,000/10,000W of continuous output, no low-idle, 5% THD max.
- Extension Cord: #12 AWG or larger, 25' (8m) or shorter.

5.

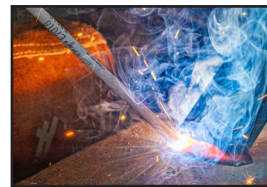
Select Process

6.

Turn the Knob to Adjust the Amperage

Refer to the electrode manufacturer recommendation for amperage.

7.

Begin Welding

STICK TROUBLESHOOTING TIPS

Workpiece Grounding

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

Frequently Tripping Circuit Breaker or Exceeding Duty Cycle

Welder should be the only thing plugged into the circuit.

Incorrect input power. Verify power source is 120V/240V +/- 10%.

**Solid Green AND Yellow Light**

Duty-cycle exceeded or insufficient air flow. Allow machine to cool.

**FIND MORE INFORMATION AT FORNEYIND.COM****QUESTIONS OR TROUBLE?**Contact Forney Industries at 1-800-521-6038 customerservice@forneyind.com forneyind.com



ITEM# 280

QUICK START GUIDE

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1.

**Read User Manual**

2.

Set Polarity

All TIG welding is done electrode negative.

Always DCEN
Ground +
TIG Torch -

* TIG Torch sold separately

3.

Ground Workpiece

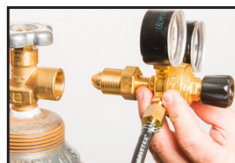
Connect ground clamp to clean, bare metal.



4.

Attach the Gas Line on the Torch to the Shielding Gas

TIG welding requires shielding gas, 100% argon recommended.



5.

Connect to 120/240V Input Power

- Generator Safe: Use power source with 4,000/10,000W of continuous output, no low-idle, 5% THD max.
- Extension Cord: #12 AWG or larger, 25' (8m) or shorter.

6.

Select Process

7.

Adjust Amperage

See Settings Chart in manual for recommended amperages based on material thicknesses.

8.

Open Gas Valve

You must manually control your shielding gas. Be sure to close the gas valve after ending the arc.



9.

Begin Welding

Use a lift arc technique to start the arc.



TIG TROUBLESHOOTING TIPS

**Aluminum welding**

Output is DC only which is not recommended for TIG welding aluminum.

Workpiece Grounding

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

Frequently tripping circuit breaker or exceeding duty-cycle

Welder should be the only thing plugged into the circuit.

Incorrect input power. Verify power source is 120V (240V) +/- 10%.

**Solid Green AND Yellow Light**

Duty-cycle exceeded or insufficient air flow. Allow machine to cool.

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