



ITEM# 291

TIG QUICK START GUIDE

180 ST WELDER (NOT RECOMMENDED FOR ALUMINUM)**Forney**
EASY WELD™

1.

**Read user manual**

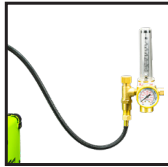
2.

**Select  process**

3.

Connect TIG torch and ground clamp

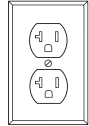
4.

Connect TIG torch lead to gas (100% Argon)

5.

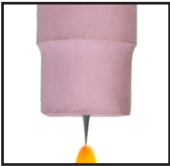
Adjust amperage per material thickness

6.

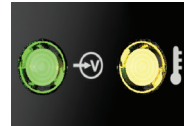
 Connect to Input Power120VAC,
20A outlet,
30A breaker
recommended

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

7.

**Initiate the arc with a scratch or lift technique when in contact with the metal****ELECTRODE IS ALWAYS ELECTRICALLY HOT WHILE IN TIG MODE****FIND TIG WELDING TIPS AT
WWW.ASKFORNEY.COM**

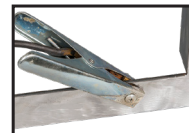
TIG TROUBLESHOOTING TIPS

Both LED lights offVerify machine is plugged in and on.
See manual.**Both LED lights on**

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

 Aluminum welding

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

Workpiece grounding

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

Frequently tripping circuit breaker or exceeding duty cycle

Welder should be the only thing plugged into the circuit.

Low weld output or poor fusion

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

Ask Forney®**QUESTIONS OR TROUBLE? Contact Forney Industries at 1-800-521-6038**
customerservice@forneyind.com • askforney.com • forneyind.com

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ITEM# 291

STICK QUICK START GUIDE

180 ST WELDER (NOT RECOMMENDED FOR ALUMINUM)**Forney**
EASY WELD™

1.

**Read user manual**

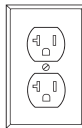
2.

**Select**  **process**

3.

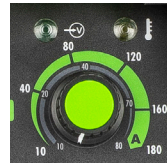
Connect electrode holder and ground clamp according to desired polarityUsually
DCEP -
Electrode
Positive

4.

**Connect to Input Power**120VAC,
20A outlet,
30A breaker
recommended

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

5.

Adjust amperage per settings chart on the welder

6.

Recommended electrodes

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

*Performance may vary by brand

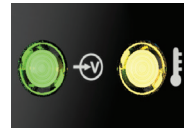
FIND STICK WELDING TIPS AT WWW.ASKFORNEY.COM

STICK TROUBLESHOOTING TIPS

Both LED lights off

Verify machine is plugged in and on.
See manual.

Both LED lights on



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

Aluminum welding

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

Workpiece grounding



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

Frequently tripping circuit breaker or exceeding duty cycle



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



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



Welder should be the only thing plugged into the circuit.

Low weld output or poor fusion

- Usually due to low input power.
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