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WELDING WITH YOUR SP-100

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Be sure to read and understand the warnings on this power source and the written or ARC WELDING SAFETY PRECAUTIONS in the SP-100 Operating Manual.

ADJUST VOLTAGE CONTROL TO ACHIEVE OPTIMUM WELD AT SPECIFIED WIRE SPEED SETTINGS*

ELECTRODE	WELDING GAS	STEEL MATERIAL THICKNESS							
		24 ga. (.004)	22 ga. (.003)	20 ga. (.002)	18 ga. (.0015)	16 ga. (.001)	14 ga. (.0008)	12 ga. (.0005)	
.025 in. (.6 mm) DIA. SOLID STEEL™ WIRE - DC(-) (+)	CO ₂	E-2.5	E-3	F-4	F-4.5	G-5	J-6	N.R.	
	CG or CGE (FERN. APP. 100-1000)	C-2.5*	D-3	E-4	F-5.5	G-6.5	H-7	J-8*	
.030 in. (.8 mm) DIA. SOLID STEEL™ WIRE - DC(-) (+)	CO ₂	N.R.	E-3.0	F-3.5	F-4.0	G-4.5	H-4.5	N.R.	
	CG or CGE (FERN. APP. 100-1000)	N.R.	D-3.0	E-3.5	E-4	F-4.5	G-4.5	J-5.5*	
.035 in. (.9 mm) DIA. INVERSIBLE™ WIRE - DC(-) (+)	NONE	N.R.	N.R.	C-1	D-1.5	E-2	F-2.5*	G-3*	

- * Adjust .025 and .030 inch diameter.
- * Optimum voltage control setting is influenced by input voltage.
- * Maximum output setting — do not use unless connected to a 25 amp branch circuit.
- * These settings may vary as noted on 1-2 and 1-3 pages with multiple passes.
- * Use DC(-) (+) polarity on 1-4 page to reduce burnthrough.

INSTALL SPOOL OF WIRE
TO DEROIL CLOCKWISE

- WIRE SIZE STENCILED ON VISIBLE SIDE OF DRIVE ROLL MUST BE SAME AS WIRE SIZE BEING USED.
- 1. Reverse drive roll per the following instructions:
- 2. Release side rail pressure arm and swing the roll away from drive roll.
- 3. Remove the roller and washer from the drive shaft and slide the drive roll off the drive shaft.
- 4. Insert the drive roll with the required threaded base facing out onto the drive shaft. Key in drive shaft must remain in place. Insert screw and tighten.
- 5. Feed wire through the guide tubes and close side rail. See Operating Manual for side rail pressure setting.

PROCEDURE TO CHANGE ELECTRODE POLARITY (see column under "Electrode" in table above for recommended polarity)

DC(-) (+) • ELECTRODE POSITIVE

Connect the cable from the gun and cable conductor block to the positive (+) output stud, and connect the "work" cable to the negative (-) output stud.

DC(-) (+) • ELECTRODE NEGATIVE

Connect the cable from the gun and cable conductor block to the negative (-) output stud, and connect the "work" cable to the positive (+) output stud.

Because design, fabrication, assembly and welding variables affect the results obtained in applying this type of information, the responsibility of a product or assembly is the responsibility of the manufacturer.

L-1000



Lincoln Welder Model Sp100 Manual

RM Cervero



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