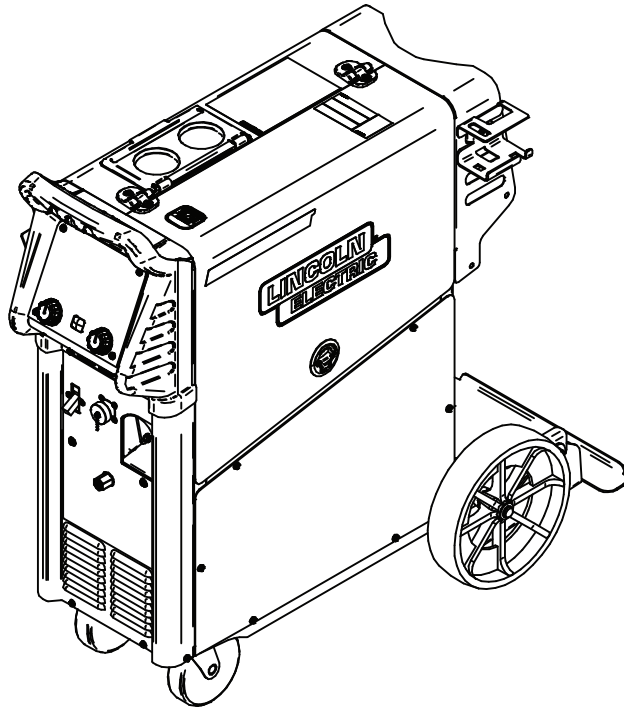




# Operator's Manual

# POWER MIG<sup>®</sup> 262MP



For use with machines having Code Numbers:  
**13419**



**Register your machine:**  
[www.lincolnelectric.com/register](http://www.lincolnelectric.com/register)

**Authorized Service and Distributor Locator:**  
[www.lincolnelectric.com/locator](http://www.lincolnelectric.com/locator)

**Save for future reference**

Date Purchased

Code: (ex: 10859)

Serial: (ex: U1060512345)

# THANK YOU FOR SELECTING A QUALITY PRODUCT BY LINCOLN ELECTRIC.

## PLEASE EXAMINE CARTON AND EQUIPMENT FOR DAMAGE IMMEDIATELY

When this equipment is shipped, title passes to the purchaser upon receipt by the carrier. Consequently, claims for material damaged in shipment must be made by the purchaser against the transportation company at the time the shipment is received.

## SAFETY DEPENDS ON YOU

Lincoln arc welding and cutting equipment is designed and built with safety in mind. However, your overall safety can be increased by proper installation ... and thoughtful operation on your part. **DO NOT INSTALL, OPERATE OR REPAIR THIS EQUIPMENT WITHOUT READING THIS MANUAL AND THE SAFETY PRECAUTIONS CONTAINED THROUGHOUT.** And, most importantly, think before you act and be careful.

### **WARNING**

This statement appears where the information must be followed exactly to avoid serious personal injury or loss of life.

### **CAUTION**

This statement appears where the information must be followed to avoid minor personal injury or damage to this equipment.



## KEEP YOUR HEAD OUT OF THE FUMES.

**DON'T** get too close to the arc. Use corrective lenses if necessary to stay a reasonable distance away from the arc.

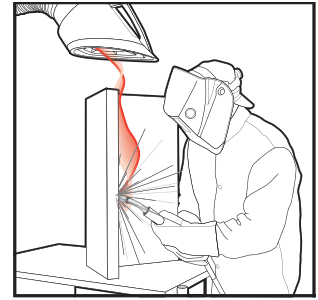
**READ** and obey the Safety Data Sheet (SDS) and the warning label that appears on all containers of welding materials.

**USE ENOUGH VENTILATION** or exhaust at the arc, or both, to keep the fumes and gases from your breathing zone and the general area.

**IN A LARGE ROOM OR OUTDOORS**, natural ventilation may be adequate if you keep your head out of the fumes (See below).

**USE NATURAL DRAFTS** or fans to keep the fumes away from your face.

If you develop unusual symptoms, see your supervisor. Perhaps the welding atmosphere and ventilation system should be checked.



## WEAR CORRECT EYE, EAR & BODY PROTECTION

**PROTECT** your eyes and face with welding helmet properly fitted and with proper grade of filter plate (See ANSI Z49.1).

**PROTECT** your body from welding spatter and arc flash with protective clothing including woolen clothing, flame-proof apron and gloves, leather leggings, and high boots.

**PROTECT** others from splatter, flash, and glare with protective screens or barriers.

**IN SOME AREAS**, protection from noise may be appropriate.

**BE SURE** protective equipment is in good condition.

Also, wear safety glasses in work area **AT ALL TIMES.**



## SPECIAL SITUATIONS

**DO NOT WELD OR CUT** containers or materials which previously had been in contact with hazardous substances unless they are properly cleaned. This is extremely dangerous.

**DO NOT WELD OR CUT** painted or plated parts unless special precautions with ventilation have been taken. They can release highly toxic fumes or gases.

## Additional precautionary measures

**PROTECT** compressed gas cylinders from excessive heat, mechanical shocks, and arcs; fasten cylinders so they cannot fall.

**BE SURE** cylinders are never grounded or part of an electrical circuit.

**REMOVE** all potential fire hazards from welding area.

**ALWAYS HAVE FIRE FIGHTING EQUIPMENT READY FOR IMMEDIATE USE AND KNOW HOW TO USE IT.**



## SECTION A: WARNINGS



### CALIFORNIA PROPOSITION 65 WARNINGS



**WARNING:** Breathing diesel engine exhaust exposes you to chemicals known to the State of California to cause cancer and birth defects, or other reproductive harm.

- Always start and operate the engine in a well-ventilated area.
- If in an exposed area, vent the exhaust to the outside.
- Do not modify or tamper with the exhaust system.
- Do not idle the engine except as necessary.

For more information go to [www.P65warnings.ca.gov/diesel](http://www.P65warnings.ca.gov/diesel)

**WARNING:** This product, when used for welding or cutting, produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code § 25249.5 *et seq.*)



**WARNING:** Cancer and Reproductive Harm  
[www.P65warnings.ca.gov](http://www.P65warnings.ca.gov)

**ARC WELDING CAN BE HAZARDOUS. PROTECT YOURSELF AND OTHERS FROM POSSIBLE SERIOUS INJURY OR DEATH. KEEP CHILDREN AWAY. PACEMAKER WEARERS SHOULD CONSULT WITH THEIR DOCTOR BEFORE OPERATING.**

Read and understand the following safety highlights. For additional safety information, it is strongly recommended that you purchase a copy of "Safety in Welding & Cutting - ANSI Standard Z49.1" from the American Welding Society, P.O. Box 351040, Miami, Florida 33135 or CSA Standard W117.2. A Free copy of "Arc Welding Safety" booklet E205 is available from the Lincoln Electric Company, 22801 St. Clair Avenue, Cleveland, Ohio 44117-1199.

**BE SURE THAT ALL INSTALLATION, OPERATION, MAINTENANCE AND REPAIR PROCEDURES ARE PERFORMED ONLY BY QUALIFIED INDIVIDUALS.**



### FOR ENGINE POWERED EQUIPMENT.

- Turn the engine off before troubleshooting and maintenance work unless the maintenance work requires it to be running.
- Operate engines in open, well-ventilated areas or vent the engine exhaust fumes outdoors.
- Do not add the fuel near an open flame welding arc or when the engine is running. Stop the engine and allow it to cool before refueling to prevent spilled fuel from vaporizing on contact



with hot engine parts and igniting. Do not spill fuel when filling tank. If fuel is spilled, wipe it up and do not start engine until fumes have been eliminated.

- Keep all equipment safety guards, covers and devices in position and in good repair. Keep hands, hair, clothing and tools away from V-belts, gears, fans and all other moving parts when starting, operating or repairing equipment.
- In some cases it may be necessary to remove safety guards to perform required maintenance. Remove guards only when necessary and replace them when the maintenance requiring their removal is complete. Always use the greatest care when working near moving parts.
- Do not put your hands near the engine fan. Do not attempt to override the governor or idler by pushing on the throttle control rods while the engine is running.
- To prevent accidentally starting gasoline engines while turning the engine or welding generator during maintenance work, disconnect the spark plug wires, distributor cap or magneto wire as appropriate.
- To avoid scalding, do not remove the radiator pressure cap when the engine is hot.
- Using a generator indoors CAN KILL YOU IN MINUTES.
- Generator exhaust contains carbon monoxide. This is a poison you cannot see or smell.
- NEVER use inside a home or garage, EVEN IF doors and windows are open.
- Only use OUTSIDE and far away from windows, doors and vents.
- Avoid other generator hazards. READ MANUAL BEFORE USE.



### ELECTRIC AND MAGNETIC FIELDS MAY BE DANGEROUS



- Electric current flowing through any conductor causes localized Electric and Magnetic Fields (EMF). Welding current creates EMF fields around welding cables and welding machines
- EMF fields may interfere with some pacemakers, and welders having a pacemaker should consult their physician before welding.
- Exposure to EMF fields in welding may have other health effects which are now not known.
- All welders should use the following procedures in order to minimize exposure to EMF fields from the welding circuit:
  - Route the electrode and work cables together - Secure them with tape when possible.
  - Never coil the electrode lead around your body.
  - Do not place your body between the electrode and work cables. If the electrode cable is on your right side, the work cable should also be on your right side.
  - Connect the work cable to the workpiece as close as possible to the area being welded.
  - Do not work next to welding power source.



## ELECTRIC SHOCK CAN KILL.



- 3.a. The electrode and work (or ground) circuits are electrically “hot” when the welder is on. Do not touch these “hot” parts with your bare skin or wet clothing. Wear dry, hole-free gloves to insulate hands.
- 3.b. Insulate yourself from work and ground using dry insulation. Make certain the insulation is large enough to cover your full area of physical contact with work and ground.

**In addition to the normal safety precautions, if welding must be performed under electrically hazardous conditions (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, if there is a high risk of unavoidable or accidental contact with the workpiece or ground) use the following equipment:**

- Semiautomatic DC Constant Voltage (Wire) Welder.
  - DC Manual (Stick) Welder.
  - AC Welder with Reduced Voltage Control.
- 3.c. In semiautomatic or automatic wire welding, the electrode, electrode reel, welding head, nozzle or semiautomatic welding gun are also electrically “hot”.
  - 3.d. Always be sure the work cable makes a good electrical connection with the metal being welded. The connection should be as close as possible to the area being welded.
  - 3.e. Ground the work or metal to be welded to a good electrical (earth) ground.
  - 3.f. Maintain the electrode holder, work clamp, welding cable and welding machine in good, safe operating condition. Replace damaged insulation.
  - 3.g. Never dip the electrode in water for cooling.
  - 3.h. Never simultaneously touch electrically “hot” parts of electrode holders connected to two welders because voltage between the two can be the total of the open circuit voltage of both welders.
  - 3.i. When working above floor level, use a safety belt to protect yourself from a fall should you get a shock.
  - 3.j. Also see Items 6.c. and 8.



## ARC RAYS CAN BURN.



- 4.a. Use a shield with the proper filter and cover plates to protect your eyes from sparks and the rays of the arc when welding or observing open arc welding. Headshield and filter lens should conform to ANSI Z87.1 standards.
- 4.b. Use suitable clothing made from durable flame-resistant material to protect your skin and that of your helpers from the arc rays.
- 4.c. Protect other nearby personnel with suitable, non-flammable screening and/or warn them not to watch the arc nor expose themselves to the arc rays or to hot spatter or metal.



## FUMES AND GASES CAN BE DANGEROUS.

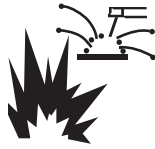


- 5.a. Welding may produce fumes and gases hazardous to health. Avoid breathing these fumes and gases. When welding, keep your head out of the fume. Use enough ventilation and/or exhaust at the arc to keep fumes and gases away from the breathing zone. **When welding hardfacing (see instructions on container or SDS) or on lead or cadmium plated steel and other metals or coatings which produce highly toxic fumes, keep exposure as low as possible and within applicable OSHA PEL and ACGIH TLV limits using local exhaust or mechanical ventilation unless exposure assessments indicate otherwise. In confined spaces or in some circumstances, outdoors, a respirator may also be required. Additional precautions are also required when welding on galvanized steel.**
- 5.b. The operation of welding fume control equipment is affected by various factors including proper use and positioning of the equipment, maintenance of the equipment and the specific welding procedure and application involved. Worker exposure level should be checked upon installation and periodically thereafter to be certain it is within applicable OSHA PEL and ACGIH TLV limits.
- 5.c. Do not weld in locations near chlorinated hydrocarbon vapors coming from degreasing, cleaning or spraying operations. The heat and rays of the arc can react with solvent vapors to form phosgene, a highly toxic gas, and other irritating products.
- 5.d. Shielding gases used for arc welding can displace air and cause injury or death. Always use enough ventilation, especially in confined areas, to insure breathing air is safe.
- 5.e. Read and understand the manufacturer’s instructions for this equipment and the consumables to be used, including the Safety Data Sheet (SDS) and follow your employer’s safety practices. SDS forms are available from your welding distributor or from the manufacturer.
- 5.f. Also see item 1.b.






## WELDING AND CUTTING SPARKS CAN CAUSE FIRE OR EXPLOSION.



- 6.a. Remove fire hazards from the welding area. If this is not possible, cover them to prevent the welding sparks from starting a fire. Remember that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas. Avoid welding near hydraulic lines. Have a fire extinguisher readily available.
- 6.b. Where compressed gases are to be used at the job site, special precautions should be used to prevent hazardous situations. Refer to "Safety in Welding and Cutting" (ANSI Standard Z49.1) and the operating information for the equipment being used.
- 6.c. When not welding, make certain no part of the electrode circuit is touching the work or ground. Accidental contact can cause overheating and create a fire hazard.
- 6.d. Do not heat, cut or weld tanks, drums or containers until the proper steps have been taken to insure that such procedures will not cause flammable or toxic vapors from substances inside. They can cause an explosion even though they have been "cleaned". For information, purchase "Recommended Safe Practices for the Preparation for Welding and Cutting of Containers and Piping That Have Held Hazardous Substances", AWS F4.1 from the American Welding Society (see address above).
- 6.e. Vent hollow castings or containers before heating, cutting or welding. They may explode.
- 6.f. Sparks and spatter are thrown from the welding arc. Wear oil free protective garments such as leather gloves, heavy shirt, cuffless trousers, high shoes and a cap over your hair. Wear ear plugs when welding out of position or in confined places. Always wear safety glasses with side shields when in a welding area.
- 6.g. Connect the work cable to the work as close to the welding area as practical. Work cables connected to the building framework or other locations away from the welding area increase the possibility of the welding current passing through lifting chains, crane cables or other alternate circuits. This can create fire hazards or overheat lifting chains or cables until they fail.
- 6.h. Also see item 1.c.
- 6.i. Read and follow NFPA 51B "Standard for Fire Prevention During Welding, Cutting and Other Hot Work", available from NFPA, 1 Batterymarch Park, PO box 9101, Quincy, MA 022690-9101.
- 6.j. Do not use a welding power source for pipe thawing.



## CYLINDER MAY EXPLODE IF DAMAGED.

- 7.a. Use only compressed gas cylinders containing the correct shielding gas for the process used and properly operating regulators designed for the gas and pressure used. All hoses, fittings, etc. should be suitable for the application and maintained in good condition. 
- 7.b. Always keep cylinders in an upright position securely chained to an undercarriage or fixed support.
- 7.c. Cylinders should be located:
  - Away from areas where they may be struck or subjected to physical damage.
  - A safe distance from arc welding or cutting operations and any other source of heat, sparks, or flame.
- 7.d. Never allow the electrode, electrode holder or any other electrically "hot" parts to touch a cylinder.
- 7.e. Keep your head and face away from the cylinder valve outlet when opening the cylinder valve.
- 7.f. Valve protection caps should always be in place and hand tight except when the cylinder is in use or connected for use.
- 7.g. Read and follow the instructions on compressed gas cylinders, associated equipment, and CGA publication P-1, "Precautions for Safe Handling of Compressed Gases in Cylinders," available from the Compressed Gas Association, 14501 George Carter Way Chantilly, VA 20151.



## FOR ELECTRICALLY POWERED EQUIPMENT.



- 8.a. Turn off input power using the disconnect switch at the fuse box before working on the equipment.
- 8.b. Install equipment in accordance with the U.S. National Electrical Code, all local codes and the manufacturer's recommendations.
- 8.c. Ground the equipment in accordance with the U.S. National Electrical Code and the manufacturer's recommendations.

**Refer to**  
**<http://www.lincolnelectric.com/safety>**  
**for additional safety information.**

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<b>CONTENT/DETAILS MAY BE CHANGED OR UPDATED WITHOUT NOTICE. FOR MOST CURRENT INSTRUCTION</b>	
<b>MANUALS, GO TO PARTS.LINCOLNELECTRIC.COM</b>	

## TECHNICAL SPECIFICATIONS – POWER MIG® 262MP

INPUT-SINGLE PHASE ONLY									
Input Voltage ± 10%					Effective Input Amperes*				
208/230/460/575 Volts 60 Hz					49.1/44/22.1/17.6				
RATED OUTPUT									
Input Voltage/ Phase/Frequency	GMAW			GTAW-DC			SMAW		
	40%	60%	100%	40%	60%	100%	40%	60%	100%
208/230/460/575/ 1/60 Hz	300	230	145	300	275	150	260	200	115
	Amps	Amps	Amps	Amps	Amps	Amps	Amps	Amps	Amps
	29	26.5	21.5	22	21	16	30.4	28	24.6
	Volts	Volts	Volts	Volts	Volts	Volts	Volts	Volts	Volts
OUTPUT									
Welding Current Range (Continuous)			Maximum Open Circuit Voltage			Welding Voltage Range			
4 A - 300 A			90 V			5 V - 45 V			
RECOMMENDED INPUT WIRE AND FUSE - SINGLE PHASE									
Input Voltage/Frequency (Hz)	Maximum Input Ampere and Duty Cycle*		Fast Acting Fuse or Breaker Size		Type S, S0, ST, STO or extra hard usage input cord AWG (IEC) Sizes**				
208/1/60	76.6 A, 40%		80 A		6 (16 mm <sup>2</sup> )				
230/1/60	68.8 A, 40%		70 A		8 (16 mm <sup>2</sup> )***				
460/1/60	34.5 A, 40%		40 A		12 (2.5 mm <sup>2</sup> )				
575/1/60	27.5 A, 40%		30 A		12 (2.5 mm <sup>2</sup> )				
WIRE SPEED RANGE									
Wire Speed 30-700 IPM (1.27-17.8 m/minute)									
PHYSICAL DIMENSIONS									
Height	Width			Depth			Weight		
37.5 Inches	18 Inches			37.5 Inches			250 lbs		
TEMPERATURE RANGES									
OPERATING TEMPERATURE RANGE					STORAGE TEMPERATURE RANGE				
-4°F to 104°F (-20°C to 40°C)					-40°F to 185°F (-40°C to 85°C)				

\* With 115V receptacle loaded to 15 Amps.

\*\* Machine is supplied with 8 AWG input cord and plug intended for use with 230V input voltage only. Customer to supply their own input cord for all other input voltages according to this table.

\*\*\* Machine is supplied with 8 AWG input cord for 230V operation. If simultaneously loading the 115V duplex receptacle supplied with the machine while also welding, then either reduce maximum output rating to 28V/280A/40% for GMAW processes, or use a 6 AWG input cord instead.

See Auxiliary Power Receptacles section for additional information.

# INSTALLATION

Read entire installation section before starting installation.

## Safety Precautions

### WARNING

#### ELECTRIC SHOCK can kill.

- Do not touch electrically live parts or electrode with skin or wet clothing.
- Insulate yourself from work and ground.
- Always wear dry insulating gloves.
- Do not use AC welder if your clothing, clothes or work area is damp or if working on, under or inside work piece.



Use the following equipment:

- Semiautomatic DC constant voltage (wire) welder.
- DC manual (stick) welder.
- AC welder with reduced voltage control.
- Do not operate with panels removed.
- Disconnect input power before servicing.

#### FUMES AND GASES can be dangerous.

- Keep your head out of fumes.
- Use ventilation or exhaust to remove fumes from breathing zone and general area.



#### WELDING SPARKS can cause fire or explosion.

- Keep flammable material away.
- Do not weld on closed containers.



#### ARC RAYS can burn eyes and skin.

- Wear eye, ear and body protection.



Observe all safety information throughout this manual.

## UNCRATING THE POWER MIG® 262MP

Cut banding and lift off cardboard carton. Cut banding holding the machine to the skid. Remove foam and corrugated packing material. Untape accessories from Gas Bottle Platform. Unscrew the two wood screws (at the Gas Bottle Platform) holding the machine to the skid. Securely lift and remove the machine from the skid.

## LOCATION

Locate the welder in a dry location where there is free circulation of clean air into the louvers in the back and the louvers out the front. A location that minimizes the amount of smoke and dirt drawn into the rear louvers reduces the chance of dirt accumulation that can block air passages and cause overheating.

## TILTING

Each machine must be placed on a secure, level surface, either directly or on a recommended cart. The machine may topple over if this precaution is not followed.

## OUTPUT POLARITY CONNECTIONS

The welder, as shipped from the factory, is connected for electrode positive (+) polarity. This is the normal polarity for GMAW.

If negative (-) polarity is required, interchange the connection of the two cables located in the wire drive compartment near the front panel. The electrode cable, which is attached to the wire drive, is to be connected to the negative (-) labeled terminal and the work lead, which is attached to the work clamp, is to be connected to the positive (+) labeled terminal.

## INPUT POWER, GROUNDING AND CONNECTION DIAGRAM

### WARNING

#### ELECTRIC SHOCK can kill.

- Do not touch electrically live parts such as output terminals or internal wiring.
- All input power must be electrically disconnected before proceeding.



The POWER MIG® 262MP is not equipped with 460/575 volt 60 Hz plug, an input cable or a receptacle.

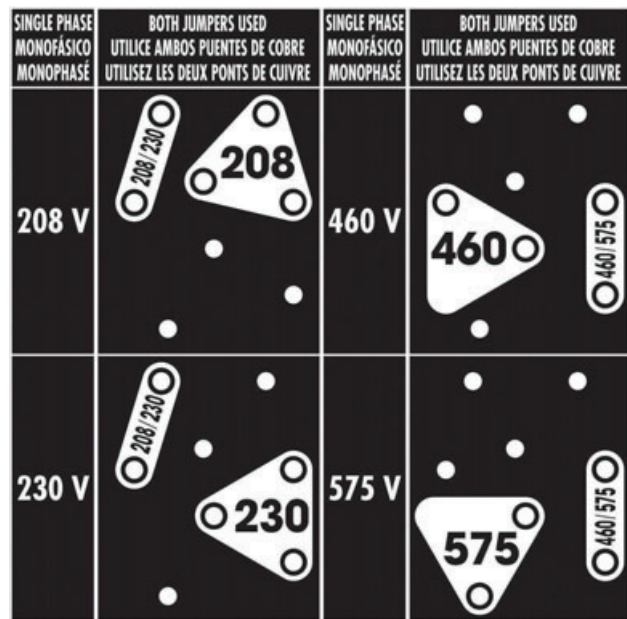
1. Before starting the installation, check with the local power company if there is any question about whether your power supply is adequate for the voltage, amperes, phase, and frequency specified on the welder rating plate. Also be sure the planned installation will meet the U.S. National Electrical Code and local code requirements. This welder may be operated from a single phase source or from two lines of a three phase source.
2. POWER MIG® 262MP has multiple input voltages specified on the nameplate. The unit is shipped connected for the 230 voltage. If the welder is to be operated on 208 voltage, it must be reconnected according to the instructions in Figure A.1. For higher voltage (460 & 575) reconnect per Figure A.1. Install appropriate input cable per local and national electrical code.

### WARNING

Make certain that the input power is electrically disconnected before removing the screw on the reconnect panel access cover.



FIGURE A.1



3. The POWER MIG® 262MP is shipped with a 10 ft. NEMA R Type 6-50N three prong plug and cable connected to the welder. Obtain a receptacle and mount it in a suitable location. Be sure it can be reached by the plug on the input cable attached to the welder. Mount with the grounding terminal at the top to allow the power cable to hang down without bending.



## GUN AND CABLE INSTALLATION

The Magnum® PRO 250L gun and cable provided with the POWER MIG® 262MP is factory installed with a liner for .035-.045" (0.9-1.1 mm) electrode and an .035" (0.9 mm) contact tip. Install the .045" tip (also provided) if this wire size is being used.

### WARNING

Turn the welder power switch off before installing gun and cable.

(See Figure A.4 and A.5)

1. Lay the cable out straight.
2. Unscrew the Hand Screw on the drive unit front end (inside wire feed compartment - Item 3) until tip of screw no longer protrudes into Gun Adapter (Item 2) opening as seen from front of machine.
3. Insert the male end of gun cable into the Gun Adapter (Item 2) through the opening in front panel. Make sure connector is fully inserted and tighten Hand Screw.
4. Connect the Gun Trigger Connector from the gun and cable to the mating Receptacle inside the compartment located on the Front Panel (Item 1). Make sure that the keyways are aligned, insert and tighten retaining ring.
5. A Coil Claw™ (Item 5) and tool holder are included with POWER MIG® 262MP. To remove/reposition the tool holder, remove the screw and insert. Reposition into desired slot on the gas bottle upper bracket.

FIGURE A.5

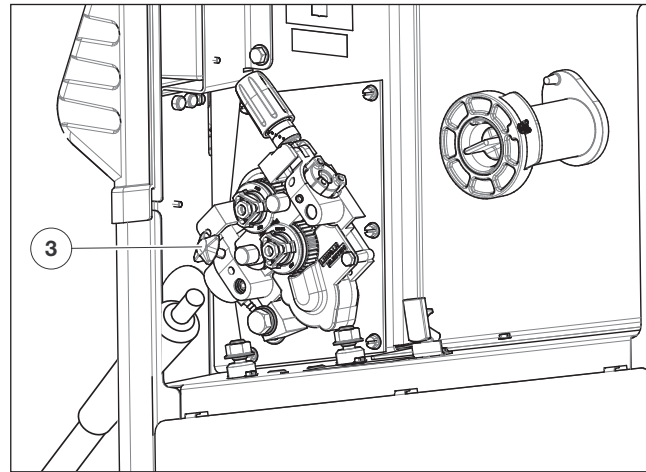
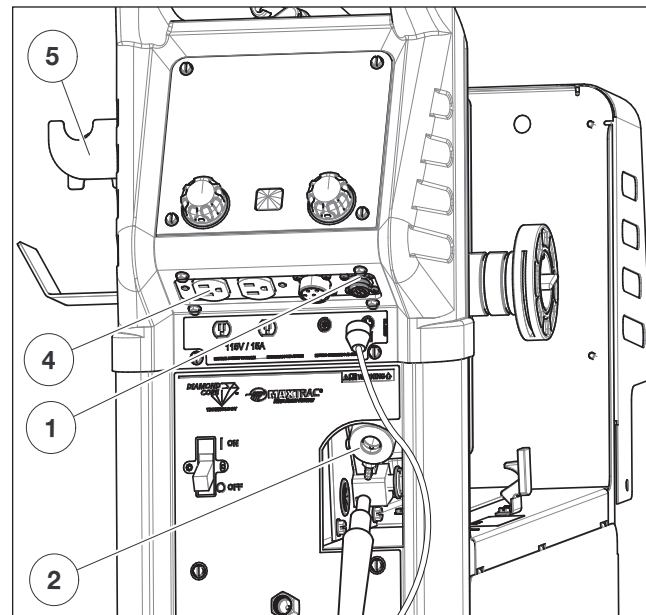


FIGURE A.4



**SHIELDING GAS**

For necessary processes.

Customer must provide cylinder of appropriate type shielding gas for the process being used.

A gas flow regulator, for Argon blend gas, an inlet gas hose, and a regulator adapter are factory provided with the POWER MIG® 262MP. When using 100% CO<sub>2</sub>, the regulator adapter will be required to connect the regulator to the gas bottle. Maximum inlet pressure is 100 psi (6.9 bar).

**! WARNING****CYLINDER may explode if damaged.**

- Gas under pressure is explosive. Always keep gas cylinders in an upright position and always keep chained to undercarriage or stationary support.



See American National Standard Z49.1, “Safety in Welding and Cutting” published by the American Welding Society.

Install shielding gas supply as follows:

1. Set gas cylinder on rear platform of POWER MIG® 262MP. Hook chain in place to secure cylinder to rear of welder.
2. Remove the cylinder cap. Inspect the cylinder valves and regulator for damaged threads, dirt, dust, oil or grease. Remove dust and dirt with a clean cloth.  
**DO NOT ATTACH THE REGULATOR IF OIL, GREASE OR DAMAGE IS PRESENT!** Inform your gas supplier of this condition. Oil or grease in the presence of high pressure oxygen is explosive.
3. Stand to one side away from the outlet and open the cylinder valve for an instant. This blows away any dust or dirt which may have accumulated in the valve outlet.

**! WARNING**

**Be sure to keep your face away from the valve outlet when “cracking” the valve.**

4. Attach the flow regulator to the cylinder valve and tighten the union nut(s) securely with a wrench.  
**NOTE:** If connecting to 100% CO<sub>2</sub> cylinder, the regulator adapter provided must be installed between the regulator and cylinder valve.
5. Attach one end of the inlet gas hose to the outlet fitting of the flow regulator, the other end to the POWER MIG® 262MP rear fitting marked “Feeder” and tighten the union nuts securely with a wrench.
6. Before opening the cylinder valve, turn the regulator adjusting knob counterclockwise until the adjusting spring pressure is released.
7. Standing to one side, open the cylinder valve slowly a fraction of a turn. When the cylinder pressure gauge pointer stops moving, open the valve fully.

**! WARNING**

**Never stand directly in front of or behind the flow regulator when opening the cylinder valve. Always stand to one side.**

8. The flow regulator is adjustable. Adjust it to the flow rate recommended for the procedure and process being used before making the weld.

**AUXILIARY POWER RECEPTACLES**

This machine is equipped with 15Amp 120V receptacle with 15Amp Circuit Breaker. The receptacle is UL and CSA approved.

# OPERATION

## SAFETY PRECAUTIONS

Read this entire section of operating instructions before operating the machine.

### WARNING

#### ELECTRIC SHOCK can kill.

- Do not touch electrically live parts or electrode with skin or wet clothing. Insulate yourself from work and ground.
- Always wear dry insulating gloves.



#### FUMES AND GASES can be dangerous.

- Keep your head out of fumes.
- Use ventilation or exhaust to remove fumes from breathing zone.



#### WELDING SPARKS can cause fire or explosion.

- Keep flammable material away.
- Do not weld on containers that have held combustibles.



#### ARC RAYS can burn.

- Wear eye, ear, and body protection.



## PRODUCT DESCRIPTION

The POWER MIG® 262MP is a complete, semiautomatic multi-process DC arc welding machine offering CV and CC DC welding built to meet NEMA specifications. The standard machine is equipped to weld CC-Stick, CC-GTAW, CV-FCAW, and synergic and non-synergic CV-GMAW. GMAW-P, and Pulsed TIG welding processes.

Other features include a 7" Digital User Interface with synergic controls and memory capability, a 2" (51mm) O.D. wire reel spindle with adjustable brake, integral gas cylinder mounting undercarriage, an adjustable CO2 or Argon blend flow regulator with cylinder pressure gauge and inlet hose, a 15 ft. (4.6m) Magnum PRO 250L gun and cable, a 10 ft. (3.1m) power cable and NEMA R Type 6-50N three prong plug and a 10 ft. (3.1m) work cable and clamp.

The POWER MIG® 262MP features built in timer functions that provide a spot function, a selectable 4-step trigger interlock, and an adjustable 'Run-In' for wire starting optimization. ARCFX™ technology comes standard and provides a way to graphically communicate instant feedback of how the end user settings affect the weld outcome when adjusting wire feed speed and voltage.

## WELDING CAPABILITY

The POWER MIG® 262MP is rated at 300 amps @ 29 volts, at a 40% duty cycle based on a ten minute cycle time for GMAW processes. It is capable of higher duty cycles at lower output currents and capable of up to 300 Amps at lower duty cycles.

The machine will actively limit it's output voltage while welding to not significantly exceed it's equivalent maximum rated output power.

## LIMITATIONS

POWER MIG® 262MP WILL NOT operate satisfactorily if powered with a portable or in-plant generating system. The Power MIG® 262MP is not dual procedure compatible.

The POWER MIG® 262MP is not recommended for use with the Cougar Push-Pull gun (K2704-2 or -3).

## SETTING THE POWER MIG® 262MP MACHINE TO WELD

Power up the machine using the switch on the front of the machine (See Item 8 of Figure B.1).

Allow machine to go through its booting stage. This will take approximately 20 seconds.

The machine will take you to the Home Screen and display the settings that were last input by the user.

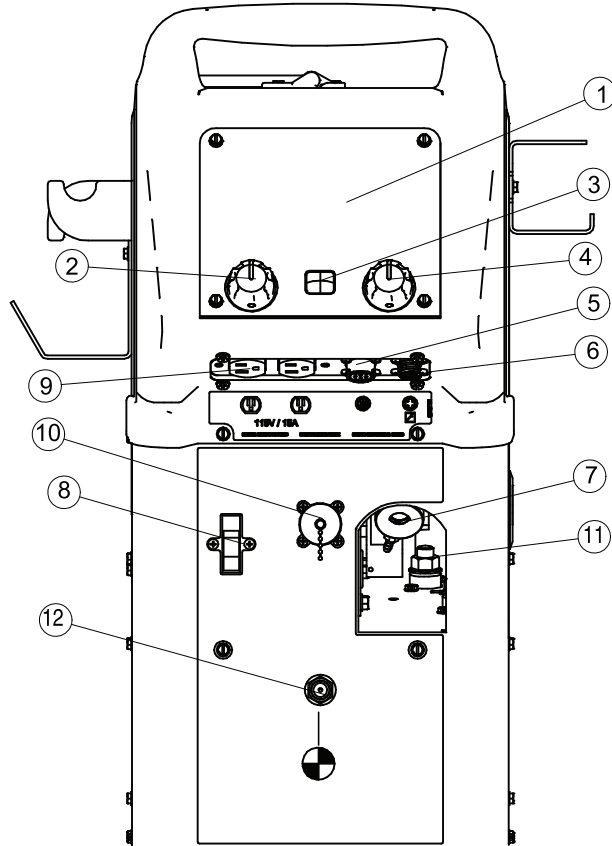
To select a new welding process, press the middle Select Process button.

By turning the right knob, select the desired welding process from the list. Press the right knob to make selection.

**NOTE:** Selecting the weld process can conclude in welding voltage being presented at the output studs without the user "triggering" the output on, such as in SMAW mode, or as in GTAW mode (without a remote control connected). GMAW and FCAW modes require the user to trigger output through a welding gun before welding voltage is presented at the output studs.

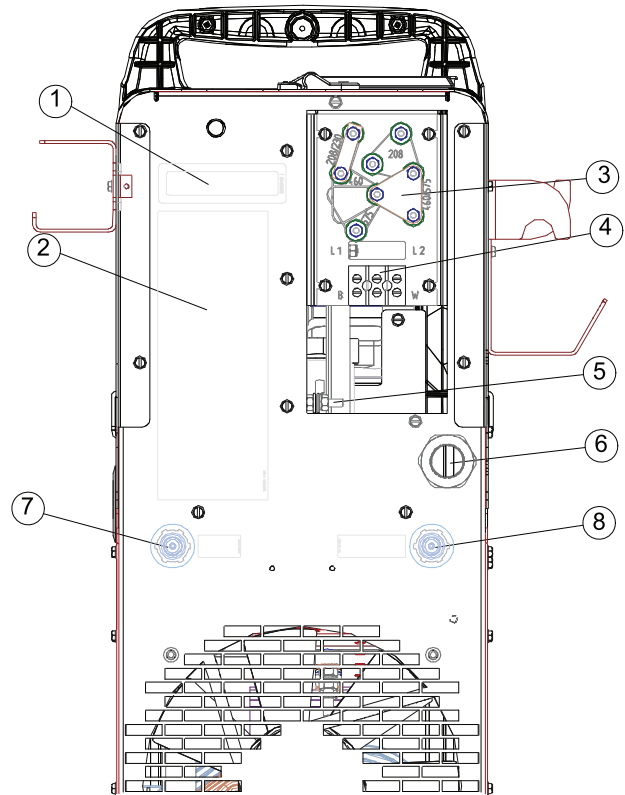
## CASE FRONT CONTROLS

FIGURE B.1



## CASE BACK CONTROLS

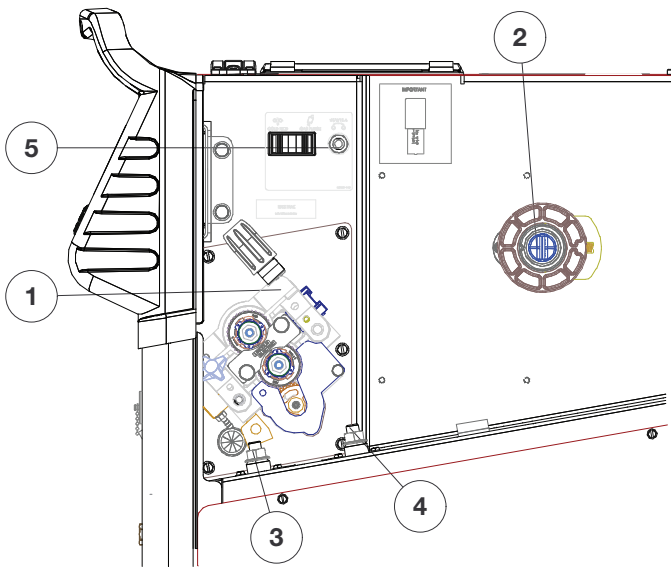
FIGURE B.2



1. **Color LED Screen** – Permits visualization of welding process and parameters. The screen features a replaceable screen shield for protecting against dust & dirt.
  2. **Back Button/Knob** – Rotate adjusts value, push to move back to previous selection
  3. **Home Button** – Returns the user to the Home Screen. At the Home Screen, the user can select a welding process or the display settings can be configured.
  4. **Select Button/Knob** – Rotate adjusts value, push confirms the selected value or choice
  5. **Twelve Pin Connector** – For attaching optional remote control equipment. Includes auto-sensing remote control circuit.
  6. **Four Pin Trigger Receptacle** – Permits triggering the machine for MIG/FCAW or aluminum MIG. Connect the 4-pin connector present on the welding gun to the receptacle.
  7. **Gun Connection** – Permits attachment of a MIG welding gun. Ensure the gun is fully seated into the brass receptacle.
  8. **Power Switch** – Permits turning the machine on or off.
  9. **115V receptacle**
  10. **Six Pin Connector** - Permits connecting a remote or TIG pedal.
  11. **Output Studs** - Used to connect work and electrode leads.
  12. **TIG/Spool Gun Gas Connector** - Used to connect gas to TIG torch or a spool gun.
1. **Decal** – Serial number.
  2. **Decal** – Input supply connection diagram
  3. **Reconnect Panel Assembly**
  4. **Input Cable Connecting Block**
  5. **Grounding** – Input cable ground cable connector
  6. **Input power cord**
  7. **Spool Gun/TIG Gas Solenoid Connector**
  8. **MIG/Push-Pull Gas Solenoid Connector** – Connection to gas hose

## INTERNAL CONTROLS

FIGURE B.3



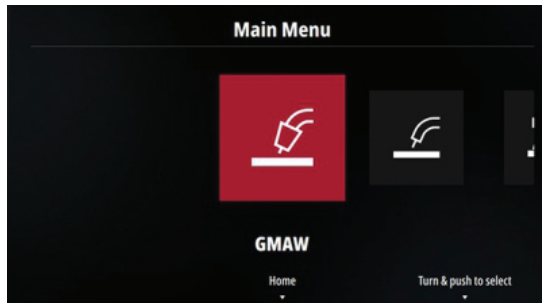
1. **Wire Drive Tension Pressure Adjustment** – Permits increasing or decreasing the pressure applied to the top drive roll.
2. **Wire Drive Spindle** – Supports a 4-inch or 8-inch spool of wire. The center wing-nut can be adjusted to increase tension on the wire.
3. **Negative Output Receptacle** – Permits attaching a work lead, electrode stinger, or the center wire drive polarity lead to DC negative polarity. Rotate connector clockwise to lock into place.
4. **Positive Output Receptacle** – Permits attaching a work lead, electrode stinger or the center wire drive polarity lead to DC positive polarity. Rotate clockwise to lock into place.
5. **Thermal Breaker** – The POWER MIG® 262MP features a resettable 15 amp circuit breaker. If the current conducted through the breaker exceeds 15 amps for an extended period of time, the breaker will open and require manual reset.



**READY.SET.WELD™**

The POWER MIG® 262MP comes equipped with Ready.Set.Weld™ which allows the user to easily select the correct welding procedure per their application.

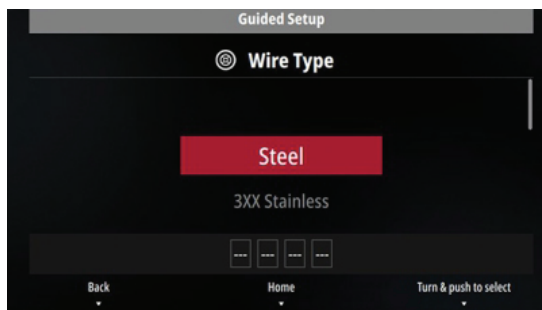
**Select Process**



**Select Guided Setup**

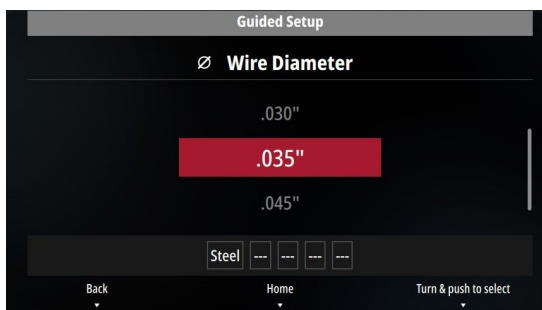


**Select Wire Type**

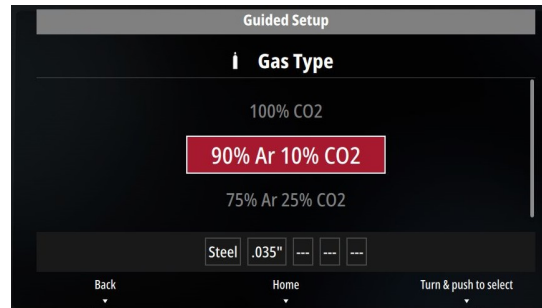


**Select Wire Diameter**

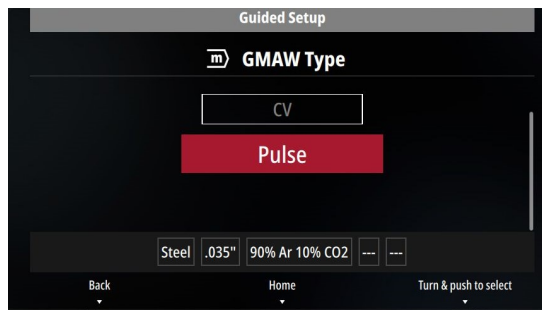
Ensure contact tip, liner, and drive rolls match wire size



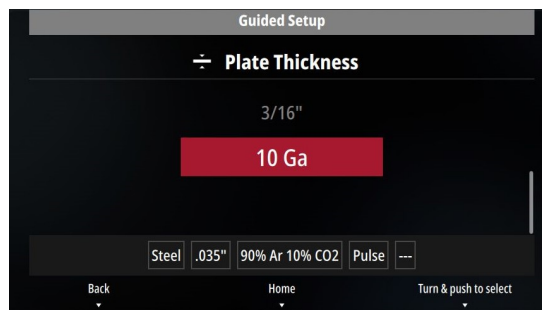
**Select Gas Type (If Applicable)**



**Select Wave Form Type (If Applicable)**



**Select Plate Thickness**

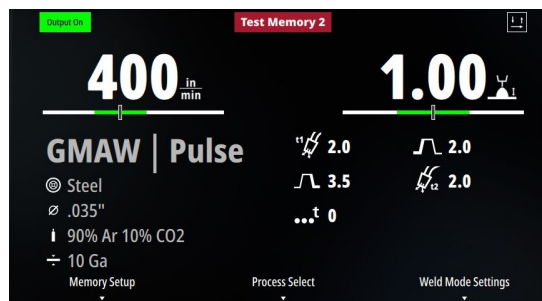


**Confirm Polarity (Not Pictured)**

Turn off machine before changing polarity

**Adjust Wire Feed Speed and Voltage/Trim accordingly**

- Note: The green section indicates the ideal range for the input welding parameters



---

## WELDING PROCESSES MENU

### MIG (GMAW) / Flux Core (FCAW-S) / Gas Shielded Flux Core (FCAW-G)

Follow Ready.Set.Weld™ prompts and insert parameters per your application.

Once on the home screen, use the left selector knob to adjust the wire feed speed.

For CV processes, use the right selector knob to adjust voltage.

For pulse processes, use the right selector knob to adjust trim.

Trim adjusts the arc length and ranges from 0.50 to 1.50 with a nominal value of 1.00. Trim values greater than 1.00 increase the arc length, while values less than 1.00 decrease the length.

Access Pulse via the Weld Settings menu. See Special Welding Processes section for further details.

Spool Gun or Push-Pull Gun settings can be selected and configured under the Weld Settings menu.

12-Pin GMAW/FCAW Gun toggle setting must be set to off if not using a gun connected to the 12-pin connector. See GUN SETTINGS section for more information.

### TIG (GTAW)

Follow Ready.Set.Weld™ prompts and insert parameters per your application.

Use the right selector knob to adjust the weld current.

Note: The green section indicates the ideal range for the input welding parameters.

If no foot pedal is connected, welding output will automatically be enabled once you finish the Guided Setup. Output can be disabled in the Weld Settings menu.

If a foot pedal is connected, pressing the foot pedal turns on the welding output, and releasing the pedal turns off the output.

Access TIG Pulse via the Weld Settings menu. See Special Welding Processes section for further details.

### Stick (SMAW)

Select between Soft or Crisp arc


Soft: Has a less penetrating arc characteristic. For low hydrogen types of electrodes (E7018, E8018, E9018, etc) a softer arc is usually desirable.

Crisp: Has a higher energy arc characterized by more penetration. For cellulosic types of electrodes (E6010, E7010, E6011, etc) a higher energy arc is required to maintain arc stability. This is usually indicated when the electrode sticks to the work-piece or when the arc pops-out during manipulative technique.








Welding output will automatically be enabled once you finish the Guided Setup. Output can be disabled in the Weld Settings menu.







**WELD SETTINGS**

The POWER MIG® 262MP allows the user to make adjustments to the advanced weld parameters via the Weld Settings screen.

Access the Weld Settings screen from the Home Screen by pressing the right selector knob. Scroll right to the “more settings” icon . The options available are dependent on the weld process that has been selected. The following section lists the weld settings that may available to adjust.

Any settings that have deviated from the default setting will be highlighted on the right side of Home Screen.

-  **ULTIMARC**- Adjusts the focus or shape of the arc and resultant weld bead size.
-  **ARC FORCE**- Controls penetration profile from soft arc to crisp arc.
-  **CRATER TIME**- Ability to set an endpoint for WFS and Voltage that will be reached over a specified time period.
-  **FREQUENCY**- Adjusts the frequency from 0-300 Hz. Pulse TIG is off when the frequency is set to zero.
-  **HOT START**- Increases amperage at arc start initialization.
-  **PINCH**- Increasing the pinch control results in a crisper arc while decreasing the pinch control provides a softer arc.
-  **POSTFLOW**- Allows a time to be selected for shielding gas to continue to flow after the trigger is released and out current is turned off.

-  **PREFLOW**- Allows a time to be selected for shielding gas to flow after the trigger is pulled, prior to establishing an arc.
-  **RUN-IN**- Adjusts initial wire feed speed for smooth arc starting.
-  **SPOT TIMER**- Adjusts arc time for tack and spot welds.
-  **START**- This machine provides the option of setting a Starting Procedure to start the weld, and from there, to ramp to the welding procedure over a specified amount of time.
-  **BACKGROUND**- Adjusts the background current between 15% and 85% of the current set point. Lower background settings often require higher current set points.
-  **TRIGGER INTERLOCK**- Toggles between 2 step and 4 step trigger activation.

The table below lists the weld process and which weld settings are available to change.

Weld Settings

	Arc Control	Crater	Hot Start	Preflow/Postflow	Run In	Spot	Start
CC-Stick	Yes	----	Yes	----	----	----	Yes
CC-GTAW	Pulse	----	----	Postflow Only	----	----	Yes
CV-FCAW	Yes	Yes	----	----	Yes	Yes	Yes
CV-GMAW	Yes	Yes	----	Yes	Yes	Yes	Yes

## ARC CONTROL

The POWER Mig® 262MP allows the user to make adjustments to the welding arc via the Weld Settings screen. Options available are dependent on the welding process you have selected. The table below lists the arc controls available per welding process.

PROCESS	ARC CONTROL SYNONYM	SETTING	APPLICATION AND RESULT
SMAW (STICK)	Arc Force	Lower (-1 to -10) for low hydrogen types of electrodes. Higher (+1 to +10) for cellulosic and other types.	Negative settings are soft and buttery for low hydrogen electrodes. Positive settings are harsh and digging for other types of electrodes.
Short circuiting metal transfer	Pinch Control	Setting -1 to -10 for softer higher energy arc. Setting +1 to +10 for a crisper lower energy arc.	Negative settings result in a more fluid puddle and larger droplet size. The positive settings reduce the droplet size and reduce energy to the arc.
Vertical Up, Pulse,	Pulsed frequency control	Negative settings reduces frequency. Positive settings increase frequency.	Negative settings result in a wider bead with more distinct ripples. Positive settings narrow the resultant bead and the ripples are less distinct.
Pulse	Arc Control	Negative settings widen the arc cone. Positive settings focus the arc cone.	Negative settings result in a wider bead with more distinct ripples. Positive settings narrow the resultant arc and weld bead.

## Loading Memories


The POWER MIG® 262MP enables the user to save the Ready.Set.Weld™ and Weld Setting parameters they input in order to quickly access in the future.

To save your weld settings, access the Memory Setup from the Home Screen by pressing the left selector knob. Use the right selector knob to scroll to an empty slot. Press and hold the right knob to assign current weld settings to this slot.

To access the saved weld settings, from the home screen, press the left selector knob to access Memory Setup. Then use the right selector knob to scroll to the desired memory setting and press the right selector knob again to select it.

To delete saved weld settings from a memory location, use the right selector knob to scroll to memory location, press and hold the right selector knob until the delete icon (trash can) is activated, and use the right selector knob to scroll to and push to select the delete icon.

To overwrite weld settings in an existing memory location, follow the same steps as deleting, except select the save icon (floppy disk) instead of the delete icon (trash can).

**Note:** Memories may also be accessed from the "more settings" icon. 

## Configurations

**REMOTE CONTROL RANGE** - Set the minimum and maximum setpoints for a remote control (if connected).

**DISPLAY UNITS AND WELD SET UNITS** - Units of measure and wire feed speed can be displayed in Imperial or Metric. Default units are imperial.

**LANGUAGE** - The language of the text present in the user interface software can be modified. The available language options are English, French and Spanish. The default language is English.

**FACTORY RESET** - The user interface software settings can be reset to the original factory settings.

**SOFTWARE VERSIONS** - Information regarding the software revision of the user interface and the software revision of the control board is present under the Advanced Settings menu.

**SCREEN LAYOUT** - Layout of homescreen and memory tiles can be chosen by user. Layout can be selected as Simplified or Advanced. Advanced layout will display all Start/End Settings on homescreen and memory tiles. Simplified layout will omit these settings from display.

## SPECIAL WELDING PROCESSES

### PULSE WELDING

The pulsed-arc process is a spray transfer process wherein spray transfer occurs in pulses at regularly spaced intervals. In the time between pulses, the welding current is reduced and no metal transfer occurs.

Pulsed-arc transfer is obtained by operating a power source between low and high current levels. The high current level or "pulse" forces an electrode drop to the workpiece. The low current level or "background" maintains the arc between pulses.

### PULSED MIG

Pulsed MIG is accessible as a "GMAW Type" in GMAW guided setups. Pulsed MIG is an advanced form of welding that takes the best of all the other forms of transfer while minimizing or eliminating their disadvantages. Unlike short circuit, pulsed MIG does not create spatter or run the risk of cold lapping. The welding positions in pulsed MIG are not limited as they are with globular or spray and its wire use is definitely more efficient. Unlike the spray arc process, pulsing offers controlled heat input that allows better welding on thin materials, lower wire feed speeds and leads to less distortion and improved overall quality and appearance. This is especially important with stain- less, nickel and other alloys that are sensitive to heat input.

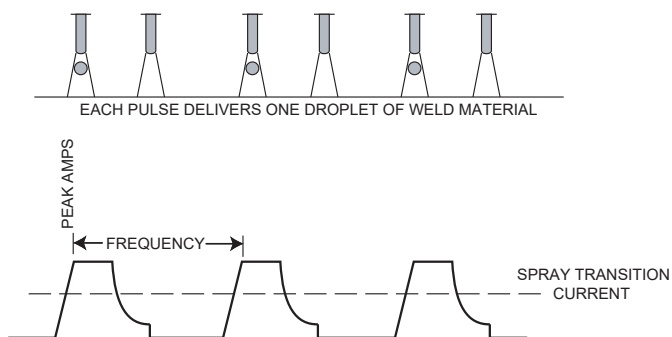
In Pulse MIG mode, the Ultimarc parameter adjusts the background current and frequency of the wave. It can be set from -10 to 10, with zero being the default value. When Ultimarc is set above zero, the frequency increases thus increasing the droplet transfer rate. This results in a narrower bead with more penetration which is typically referred to as "crisp" welding performance. Setting Ultimarc below zero results in the opposite and provides a wider bead with lower penetration, typically referred to as "soft" welding performance.

### PULSE TIG

Pulse in TIG mode (GTAW) automatically switches the current between the set point current on the main welding screen and the background current. This feature can be used to reduce heat input and warping of parts. Low pulse frequencies can help with weld consistency, whereas higher pulse frequencies can increase travel speed and prevent burn through on holes, edges and thin materials.

The frequency parameter adjusts the pulse frequency from 0-300 Hz. Pulse TIG is off when the frequency is set to zero. The background parameter adjusts the background current between 15% and 85% of the current set point. Lower background settings often require higher current set points. The pulse % on-time is fixed at 50%.

**FIGURE B.5**





## DRIVE ROLLS

The drive rolls installed with the POWER MIG® 262MP have two grooves one for .035" (0.9mm) wire Solid Steel electrode and the other for .045" (1.1mm) wire. Drive roll size is stenciled on each side of the drive roll. If feeding problems occur, check to make sure that the wire size and the drive roll size matches. See "Procedure for Changing Drive Roll" in this section. This information also appears on the Procedure Decal on the door inside the wire compartment.

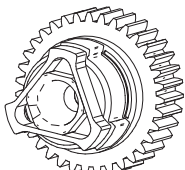
## WIRE SIZE CONVERSION PARTS

The drive roll kits and Magnum® PRO 250L gun and cable parts are available to feed different sizes and types of electrodes. See Accessories section.

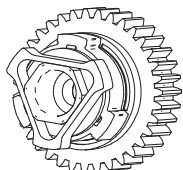
## PROCEDURE FOR CHANGING DRIVE AND IDLE ROLL SETS

1. Turn off the power source.
2. Release the pressure on the idle roll by swinging the adjustable pressure arm down toward the back of the machine. Lift the cast idle roll assembly and allow it to sit in an upright position.
3. Remove the outside wire guide retaining plate by loosening the two large knurled screws.
4. Twist the drive roll retaining mechanism to the unlocked position as shown below and remove the drive roll. (See Figure B.2)

FIGURE B.2



UNLOCKED POSITION



LOCKED POSITION

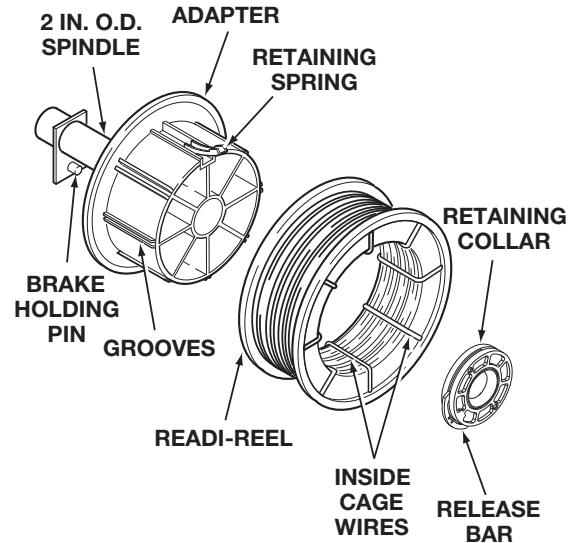
5. Remove the inside wire guide plate.
6. Replace the drive and idle rolls and inside wire guide with a set marked for the new wire size. NOTE: Be sure that the gun liner and contact tip are also sized to match the selected wire size.
7. Manually feed the wire from the wire reel, over the drive roll groove and through the wire guide and then into the brass bushing of the gun and cable assembly.
8. Replace the outside wire guide retaining plate by tightening the two large knurled screws. Reposition the adjustable pressure arm to its original position to apply pressure. Adjust pressure as necessary.

## WIRE REEL LOADING - READI REELS, SPOOLS OR COILS

To Mount a 30 Lb. (14 kg) REDI-Reel Package (Using the Molded Plastic K363-P REDI-Reel Adapter:)

(See Figure B.3)

FIGURE B.3



1. Open the Wire Drive Compartment Door.
2. Depress the Release Bar on the Retaining Collar and remove it from the spindle.
3. Place the Optional Adapter on the spindle.
4. Re-install the Retaining Collar. Make sure that the Release Bar "pops up" and that the collar retainers fully engage the retaining ring groove on the spindle.
5. Rotate the spindle and adapter so the retaining spring is at the 12 o'clock position.
6. Position the REDI-Reel so that it will rotate in a direction when feeding so as to be de-reeled from top of the coil.
7. Set one of the REDI-Reel inside cage wires on the slot in the retaining spring tab.
8. Lower the REDI-Reel to depress the retaining spring and align the other inside cage wires with the grooves in the molded adapter.
9. Slide cage all the way onto the adapter until the retaining spring "pops up" fully.

## CAUTION

**CHECK TO BE SURE THE RETAINING SPRING HAS FULLY RETURNED TO THE LOCKING POSITION AND HAS SECURELY LOCKED THE READI-REEL CAGE IN PLACE. RETAINING SPRING MUST REST ON THE CAGE, NOT THE WELDING ELECTRODE.**

10. To remove REDI-Reel from Adapter, depress retaining spring tab with thumb while pulling the REDI-Reel cage from the molded adapter with both hands. Do not remove adapter from spindle.

To Mount 10 to 44 Lb. (4.5-20 kg) Spools (12"/300 mm Diameter) or 14Lb.(6 Kg) Innershield Coils:

(For 13-14 lb. (6 Kg) Innershield coils, a K435 Coil Adapter must be used).

(For 10 lb.(4.5 Kg) 8 inch(203mm) diameter spools, a K468 spindle adapter must be used).

1. Open the Wire Drive Compartment Door.
2. Depress the Release Bar on the Retaining Collar and remove it from the spindle.
3. Place the spool on the spindle making certain the spindle brake pin enters one of the holes in the back side of the spool (Note: an arrow mark on the spindle lines up with the brake holding pin to assist in lining up a hole). Be certain the wire comes off the reel in a direction so as to de-reel from the top of the coil.
4. Re-install the Retaining Collar. Make sure that the Release Bar "pops up" and that the collar retainers fully engage the retaining ring groove on the spindle.

### TO START THE WELDER

Turn the "Power Switch" switch to "ON". With the desired voltage and wire speed selected, operate the gun trigger for welder output and to energize the wire feed motor.

### FEEDING WIRE ELECTRODE

#### WARNING

When triggering, the electrode and drive mechanism are electrically "hot" relative to work and ground and remain "hot" several seconds after the gun trigger is released.

NOTE: Check that drive rolls, guide plates and gun parts are proper for the wire size and type being used. Refer to Table C.1 in Accessories section.

1. Turn the Readi-Reel or spool until the free end of the electrode is accessible.
2. While securely holding the electrode, cut off the bent end and straighten the first six inches. (If the electrode is not properly straightened, it may not feed properly through the wire drive system).
3. Release the pressure on the idle roll by swinging the adjustable pressure arm down toward the back of the machine. Lift the cast idle roll assembly and allow it to sit in an upright position. Leave the outer wire guide plate installed. Manually feed the wire through the incoming guide bushing and through the guide plates (over the drive roll groove). Push a sufficient wire length to assure that the wire has fed into the gun and cable assembly without restriction. Reposition the adjustable pressure arm to its original position to apply pressure to the wire.
4. Press gun trigger to feed the electrode wire through the gun.

### IDLE ROLL PRESSURE SETTING

#### WARNING

#### ELECTRIC SHOCK can kill.

- Turn the input power OFF at the welding power source before installation or changing drive rolls and/or guides.
- Do not touch electrically live parts.
- When inching with the gun trigger, electrode and drive mechanism are "hot" to work and ground and could remain energized several seconds after the gun trigger is released.
- Only qualified personnel should perform maintenance work.

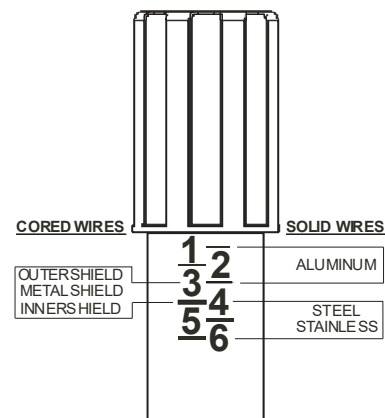


The pressure arm controls the amount of force the drive rolls exert on the wire. Proper adjustment of the pressure arm gives the best welding performance.

Set the pressure arm as follows (See Figure B.4):

Aluminum wires            between 1 and 3  
Cored wires                between 3 and 4  
Steel, Stainless wires    between 4 and 6

FIGURE B.4



## WIRE DRIVE CONFIGURATION

### CHANGING THE GUN RECEIVER BUSHING

Tools required:

- 1/4" hex key wrench.

Note: Some gun bushings do not require the use of the thumb screw.

1. Turn power off at the welding power source.
2. Remove the welding wire from the wire drive.
3. Remove the thumb screw from the wire drive.
4. Remove the welding gun from the wire drive.
5. Loosen the socket head cap screw that holds the connector bar against the gun bushing.
 

Important: Do not attempt to completely remove the socket head cap screw.
6. Remove the outer wire guide, and push the gun bushing out of the wire drive. Because of the precision fit, light tapping may be required to remove the gun bushing.
7. Disconnect the shielding gas hose from the gun bushing, if required.
8. Connect the shielding gas hose to the new gun bushing, if required.
9. Rotate the gun bushing until the thumb screw hole aligns with the thumb screw hole in the feed plate. Slide the gun receiver bushing into the wire drive and verify the thumb screw holes are aligned.
10. Tighten the socket head cap screw.
11. Insert the welding gun into the gun bushing and tighten the thumb screw.

## MAKING A WELD

1. Check that the electrode polarity is correct for the process being used, then turn the power switch ON.
2. Set desired arc voltage and wire speed for the particular electrode wire, material type and thickness, and gas (for GMAW) being used.
3. Select the desired procedure as described in "Description of Controls" Section.
4. Press the trigger to feed the wire electrode through the gun and cable and then cut the electrode within approximately 3/8" (10 mm) of the end of the contact tip [3/4" (20 mm) Outershield®].

NOTE: If set for slow run-in when the trigger is pulled, the wire feeder feeds wire at low speed regardless of the set wire feed speed until the welding arc starts or 1 second has elapsed. This feature enhances starting and makes it easier to set the stickout. The 1 second limit permits high speed loading of the gun and cable. To change run-in mode, see "Run-In Mode" in Description of Controls Section.

5. If welding gas is to be used, turn on the gas supply and set the required flow rate (typically 25-35 CFH; 12-16 liters/min).
6. When using Innershield electrode, the gas nozzle may be removed from the insulation on the end of the gun and replaced with the gasless nozzle. This will give improved visibility and eliminate the possibility of the gas nozzle overheating.
7. Connect work cable to metal to be welded. Work clamp must make good electrical contact to the work. The work must also be grounded as stated in "Arc Welding Safety Precautions".



## WARNING

**When using an open arc process, it is necessary to use correct eye, head, and body protection.**

8. Position electrode over joint. End of electrode may be lightly touching the work.
9. Lower welding helmet, close gun trigger, and begin welding. Hold the gun so the contact tip to work distance is about 3/8" (10 mm) [3/4" (20 mm) for Outershield].
10. To stop welding, release the gun trigger and then pull the gun away from the work after the arc goes out.
11. When no more welding is to be done, close valve on gas cylinder (if used), momentarily operate gun trigger to release gas pressure, and turn off POWER MIG® 262MP.

---

## AVOIDING WIRE FEEDING PROBLEMS

Wire feeding problems can be avoided by observing the following gun handling procedures:

- Do not kink or pull cable around sharp corners.
- Keep the gun cable as straight as possible when welding or loading electrode through cable.
- Do not allow dolly wheels or trucks to run over cables.
- Keep cable clean by following maintenance instructions.
- Use only clean, rust-free electrode. The Lincoln electrodes have proper surface lubrication.
- Replace contact tip when the arc starts to become unstable or the contact tip end is fused or deformed.
- Keep wire reel spindle brake tension to minimum required to prevent excess reel over-travel which may cause wire "loop-offs" from coil.
- Use proper drive rolls and wire drive idle roll pressure for wire size and type being used.

---

## FAN CONTROL

The fan is designed to come on automatically when a weld arc is established. The fan will also stay on when the machine's welding and feeding are disabled during thermostatic over temperature protection. (See Welding Thermal Overload Protection)

---

## INPUT LINE VOLTAGE

Low Line Voltage — You may not be able to get maximum output from the machine if the line voltage is less than rated input. The unit will continue to weld, but the output may be less than what is set.

---

## WIRE FEED OVERLOAD PROTECTION

The POWER MIG® 262MP has solid state overload protection of the wire drive motor. If the motor becomes overloaded, the protection circuitry turns off the wire feed speed weld output and gas solenoid. Check for proper size tip, liner, and drive rolls, for any obstructions or bends in the gun cable, and any other factors that would impede the wire feeding.

To resume welding, simply pull the trigger. There is no circuit breaker to reset, as the protection is done with reliable solid state electronics.

---

## WELDING THERMAL OVERLOAD PROTECTION

The POWER MIG® 262MP has built-in protective thermostats that respond to excessive temperature. They open the wire feed and welder output circuits if the machine exceeds the maximum safe operating temperature because of a frequent overload, or high ambient temperature plus overload. The thermostats automatically reset when the temperature reaches a safe operating level and welding and feeding are allowed again, when gun is retriggered.

---

## GUN SETTINGS

The Gun Settings menu is accessed through the Weld Mode Settings -> More Settings -> System Menu. Use this menu to enable/disable Trigger Memory Recall or to configure a spool gun or push pull gun connected through the 12-pin connector.

**Trigger Memory Recall-** When toggled on, the user can quickly recall a memory setting by tapping the gun trigger the same number of times as the memory location number. For example, when in GMAW mode, tapping the trigger 3 times will recall memory location "GMAW 3". The one exception is for memory location 1: the user must tap the trigger 11 times instead of 1 time.

**12-Pin GMAW/FCAW Gun Toggle-** Turn this toggle on in order to use a gun connected through the 12-pin connector. When toggled on, the user will have access to a Gun Selection menu, Push Pull Pot menu, and Gun Calibration menu. When the toggle is turned on, the push-pull or spool gun icon will display on the home screen. Be sure to turn the toggle off when using any other kind of welding process as it can interfere with the desired machine operation.

**Gun Selection-** use this menu to select which type of gun is connected to the 12-pin connector.

**Push Pull Pot-** use this menu to enable/disable remote wire feed speed control through the potentiometer on the push-pull or spool gun connected to the 12-pin connector. When disabled, the user will control the WFS directly from the UI. When enabled, the user will control the WFS directly from the potentiometer (knob or wheel) on the gun.

**Gun Calibration-** After selecting the type of push-pull or spool gun from the Gun Selection menu, the user should calibrate their gun with the machine. The push-pull and spool gun should be calibrated any time the gun is disconnected and reconnected, a new wire size and type is used, or if a new gun is being used. Before starting the calibration, be sure that the wire is fed through the gun entirely. Once Gun Calibration is selected, the user interface will ask the user if they would like to start the calibration. Follow the prompts on the user interface to complete calibration. **NOTE:** Be sure to hold the trigger during the entire calibration to avoid interrupting the calibration process.

# OPTIONS / ACCESSORIES

## DRIVE ROLL KITS

Refer to Table C.1 for various drive roll kits that are available for the POWER MIG® 262MP. The item in Bold is supplied standard with the POWER MIG® 262MP.

**TABLE C.1**

Wire	Wire Size	Drive Roll Kit
Solid Steel	.023"-.030" (0.6-0.8 mm)	KP1696-030S
	.035" (0.9 mm)	KP1696-035S
	.045" (1.1 mm)	KP1696-045S
	.035"-.045" (0.9-1.1mm)	KP1696-1
	.040" (1.0mm)	KP1696-2
Cored	.035" (0.9 mm)	KP1697-035C
	.045" (1.1 mm)	KP1697-045C
Aluminum	3/64" (1.2 mm)	KP1695-3/64A
	.035" (0.9 mm)	KP1695-035A

K3675-1 Canvas Cover

K1738-1 Spool Gun Holder for POWER MIG® - provide neat storage of spool gun cable, and gas hose for POWER MIG®. Also provide hardware for routing gas inside POWER MIG® when using a Prince XL gun. (Note: included in K1809-1 and K2310-1)

K468 Spindle Adapter - for 8" (203.2mm) O.D. spool.

K363P READI-REEL™ ADAPTER - The K363P Readi-Reel Adapter mounts to the 2" spindle. It is needed to mount the 22-30 lb. Readi-Reels.

K435 Spindle Adapter for 14 lbs. coils - the K435 spindle adapter allows 14lbs. (6kg.) Innershield coils to be mounted on 2" (51mm) O.D. spindle.

K3676-1 Dual Cylinder Mounting Kit - Used to hold two gas bottle

## ALTERNATIVE MAGNUM GMAW GUN AND CABLE ASSEMBLIES

The following Magnum® PRO 250L gun and cable assembly is separately available for use with the POWER MIG® 262MP. Each is rated 200 amps 60% duty cycle (or 250 amps 40% duty) and is equipped with the integrated connector, twist-lock trigger connector, fixed nozzle and insulator, and includes a liner, diffuser, and contact tips for the wire sizes specified:

Length	Part No.	English Wire Size <sup>1</sup>	Metric Wire Size
15' (4.6 m)	K3081-2	.035 – .045"	0.9 – 1.2 mm

<sup>1</sup> Optional liners for different wire diameters are sold separately, see table D.1 Maintenance Section.

20' and 25' Magnum® PRO 250L Guns -

K2951-3 Magnum® PRO Curve 300, 20'\*

K2951-4 Magnum® PRO Curve 300, 25'\*

\* Requires K466-6 adapter and KP44-3545-25 liner

\*\*Not compatible with dual procedure guns

## MAGNUM GUN CONNECTION KIT (OPTIONAL K466-6)

Using the optional K466-6 Magnum® Connection kit for the POWER MIG permits use of standard Magnum® 200, 300 or 400 gun and cable assemblies.

## SPOOL GUN

The POWER MIG® 262MP provides direct connection and use of the Spool Gun (with remote speed control).

It also provides gun trigger switch transfer between the machine's use with its feeder gun or the spool gun for same polarity welding with different wire and gas processes.

K2490-1 Magnum® 250LX

K487-25 Magnum® SG Spool Gun (requires K2445-1 Cable Adapter)

K2910-1 12M to 7F Adapter may be needed to connect some push pull and spool guns to the POWER MIG® 262MP's 12-pin connector.

## DUAL PROCEDURE

The Power MIG 262MP is not dual procedure compatible.



# MAINTENANCE

## Safety Precautions

### WARNING

#### ELECTRIC SHOCK can kill.

- Have an electrician install and service this equipment.
- Turn the input power OFF at the fuse box before working on equipment
- Do not touch electrically hot parts.



### WARNING

Remove all input power to the POWER MIG® 262MP before proceeding.

See additional warning information throughout this Operator's Manual

## GENERAL MAINTENANCE

In extremely dusty locations, dirt may clog the air passages causing the welder to run hot. Blow dirt out of the welder with low-pressure air at regular intervals to eliminate excessive dirt and dust build-up on internal parts.

The fan motors have sealed ball bearings which require no service.

## DRIVE ROLLS AND GUIDE PLATES

After every coil of wire, inspect the wire drive mechanism. Clean it as necessary by blowing with low pressure compressed air. Do not use solvents for cleaning the idle roll because it may wash the lubricant out of the bearing.

All drive rolls are stamped with the wire sizes they will feed. If a wire size other than that stamped on the roll is used, the drive roll must be changed.

For instructions on replacing or changing drive roll, see "Wire Drive Rolls" in Operation section.

## CONTACT TIP AND GAS NOZZLE INSTALLATION

1. Choose the correct size contact tip for the electrode being used (wire size is stenciled on the side of the contact tip) and seat it snugly into the gas diffuser.
2. Screw the appropriate fixed gas nozzle fully onto the diffuser. Either the standard .50" (12.7 mm) flush nozzle or other optional flush or recessed (spray arc) nozzle sizes may be used. (Refer to [www.lincolnelectric.com](http://www.lincolnelectric.com))
3. If using optional adjustable slip-on nozzles. (Refer to [www.lincolnelectric.com](http://www.lincolnelectric.com))
  - Be sure the nozzle insulator is fully screwed onto the gun tube and does not block the gas holes in the diffuser.
  - Slip the appropriate gas nozzle onto the nozzle insulator. Either a standard .50" (12.7 mm) or optional .62" (15.9 mm) I.D. slip-on gas nozzle may be used and should be selected based on the welding application.
  - Adjust the gas nozzle as appropriate for the GMAW process to be used. Typically, the contact tip end should be flush to .12" (3.2 mm) extended for the short-circuiting transfer process and .12" (3.2 mm) recessed for spray transfer.

## GUN TUBES AND NOZZLES

1. Replace worn contact tips as required.
2. Remove spatter from inside of gas nozzle and from tip after each 10 minutes of arc time or as required.

## GUN CABLE CLEANING

To help prevent feeding problems, clean cable liner after using approximately 300 pounds (136 kg) of electrode. Remove the cable from the wire feeder and lay it out straight on the floor. Remove the contact tip from the gun. Using an air hose and only partial pressure, gently blow out the cable liner from the gas diffuser end.

### CAUTION

Excessive pressure at the beginning of the cleaning procedure may cause the dirt to form a plug.

Flex the cable over its entire length and again blow out the cable. Repeat this procedure until no further dirt comes out. If this has been done and feed problems are experienced, try liner replacement, and refer to trouble shooting section on rough wire feeding.

## LINER REMOVAL, INSTALLATION AND TRIMMING

(See Figure D.1)

NOTE: The variation in cable lengths prevents the interchangeability of liners between guns. Once a liner has been cut for a particular gun, it should not be installed in another gun unless it can meet the liner cutoff length requirement. Liners are shipped with the jacket of the liner extended the proper amount.

1. Remove the gas nozzle.
2. Remove the gas diffuser from the gun tube.
3. Lay gun and cable out straight on a flat surface. Loosen set screw of the connector on the back end of the gun.
4. Insert the untrimmed Liner into the back end of the gun.
5. Seat Liner bushing into back of gun. Secure Liner by tightening set screw. Do not install the gas diffuser at this time.
6. Lay the cable straight and trim Liner to 9/16". Remove burrs.
7. Install insulator and secure the gas diffuser into the tube.

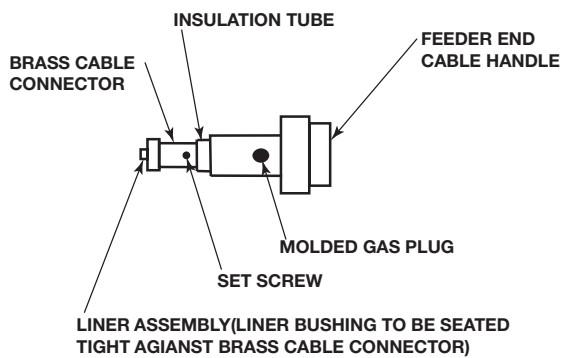
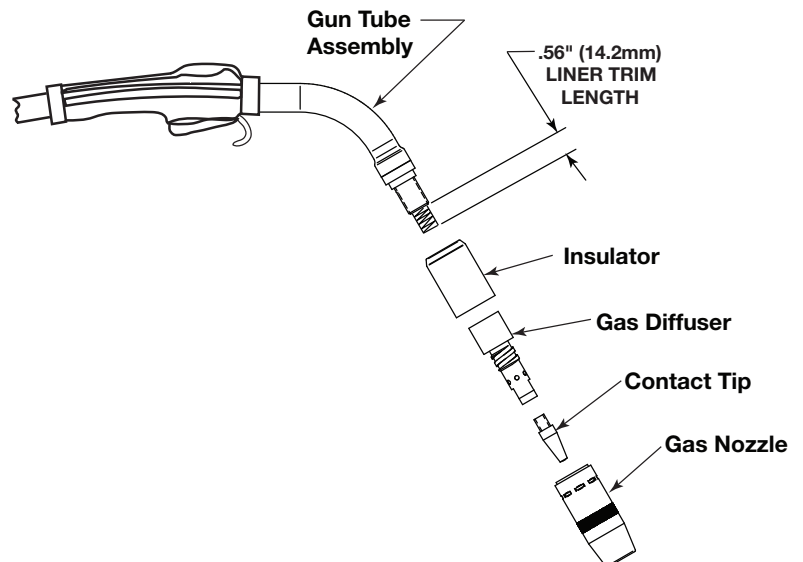


FIGURE D.1



## Spool/Push-Pull Gun Calibration

### Checking Calibration

A variety of factors affect the calibration of the Spool and Push-Pull Gun. Therefore, it is important to check the gun's calibration whenever the machine's input voltage is changed, or a new gun is connected to the machine.

**See the Gun Calibration procedure in the Gun Settings section for more information.**

# TROUBLESHOOTING

## HOW TO USE TROUBLESHOOTING GUIDE



### WARNING

Service and Repair should only be performed by Lincoln Electric Factory Trained Personnel. Unauthorized repairs performed on this equipment may result in danger to the technician and machine operator and will invalidate your factory warranty. For your safety and to avoid Electrical Shock, please observe all safety notes and precautions detailed throughout this manual.

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This Troubleshooting Guide is provided to help you locate and repair possible machine malfunctions. Simply follow the three-step procedure listed below.

#### Step 1. LOCATE PROBLEM (SYMPTOM).

Look under the column labeled "PROBLEM (SYMPTOMS)". This column describes possible symptoms that the machine may exhibit. Find the listing that best describes the symptom that the machine is exhibiting.

#### Step 2. POSSIBLE CAUSE.

The second column labeled "POSSIBLE CAUSE" lists the obvious external possibilities that may contribute to the machine symptom.

#### Step 3. RECOMMENDED COURSE OF ACTION

This column provides a course of action for the Possible Cause, generally it states to contact your local Lincoln Authorized Field Service Facility.

If you do not understand or are unable to perform the Recommended Course of Action safely, contact your local Lincoln Authorized Field Service Facility.



If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your Lincoln Authorized Service Facility for technical troubleshooting assistance before you proceed.

[WWW.LINCOLNELECTRIC.COM/LOCATOR](http://WWW.LINCOLNELECTRIC.COM/LOCATOR)

Observe all Safety Guidelines detailed throughout this manual

PROBLEMS (SYMPTOMS)	POSSIBLE AREAS OF MISADJUSTMENTS(S)	RECOMMENDED COURSE OF ACTION
<b>OUTPUT PROBLEMS</b>		
Major physical or electrical damage is evident.	Do not plug in machine or turn it on. Contact your local Lincoln Authorized Field Service Facility.	If all recommended possible areas of misadjustment have been checked and the problem persists, Contact your local Lincoln Authorized Field Service Facility.
No wire feed, Weld output or gas flow when gun trigger is pulled. Fans does NOT operate.	1. Make sure correct voltage is applied to the machine.	
	2. Make certain that the power switch is in ON position.	
	3. Make sure circuit breaker is reset.	
No wire feed, Weld output or gas flow when gun trigger is pulled. Fans operate normally.	1. The thermostat may be tripped due to overheating. Let machine cool. Weld at lower duty cycle.	
	2. Check for obstructions in air flow. Check gun trigger connections. See installation section.	
	3. Gun trigger may be faulty.	
Arc is unstable – Poor starting.	1. Check for correct input voltage to machine.	
	2. Check machine reconnect panel is configured properly for the applied voltage.	
	3. Check gun tip for wear or damage and proper size – Replace.	
	4. Check for proper gas and flow rate for process.	
	5. Check work cable or loose or faulty connections.	
	6. Check gun for damage or breaks.	
	7. Check for proper drive roll orientation and alignment.	
	8. Check liner for proper size.	



If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your Lincoln Authorized Service Facility for technical troubleshooting assistance before you proceed.

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Observe all Safety Guidelines detailed throughout this manual

PROBLEMS (SYMPTOMS)	POSSIBLE AREAS OF MISADJUSTMENTS(S)	RECOMMENDED COURSE OF ACTION
Output voltage and wire feed is present when gun trigger is not pulled (not activated).	<ol style="list-style-type: none"> <li>1. Remove gun assembly from machine. If problem is solved, gun assembly is faulty. Repair or replace.</li> <li>2. If problem persists when gun assembly is removed from machine, then the problem is within the POWER MIG® 262MP.</li> </ol>	If all recommended possible areas of misadjustment have been checked and the problem persists, Contact your local Lincoln Authorized Field Service Facility.
Machine output is low. Welds are “cold”, weld bead is rounded or bumped up demonstrating poor wetting into plate.	<ol style="list-style-type: none"> <li>1. Check input voltage. Make sure input voltage matches nameplate rating and reconnect panel configuration.</li> <li>2. Make sure settings for wire feed speed and voltage are correct for the process being used.</li> <li>3. Make sure output polarity is correct for process being used.</li> <li>4. Check welding cables and gun assembly for loose or faulty connections.</li> </ol>	
<b>FEEDING PROBLEMS</b>		
No wire feed when gun trigger is pulled. Fans run, gas flows and machine has correct open circuit voltage (60 VDC) – weld output.	<ol style="list-style-type: none"> <li>1. If the wire drive motor is running, make sure that the correct drive rolls are installed in the machine.</li> <li>2. Check for clogged cable liner or contact tip.</li> <li>3. Check for proper size cable liner and contact tip.</li> <li>4. Check if the spool gun mode is selected on the screen.</li> <li>5. Check wire spindle for ease of rotation and adjust break tension knob if necessary.</li> </ol>	If all recommended possible areas of misadjustment have been checked and the problem persists, Contact your local Lincoln Authorized Field Service Facility.



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PROBLEMS (SYMPTOMS)	POSSIBLE AREAS OF MISADJUSTMENTS(S)	RECOMMENDED COURSE OF ACTION
The wire feed stops while welding. When trigger is released and pulled again the wire feed starts.	1. Check the wire feed drive rolls and motor for smooth operation.	
	2. Check for restrictions in the wire feed path.	
	3. Make sure gun liner and tip are correct for wire size being used.	
	4. Check spindle for ease of rotation.	
	5. Make sure drive rolls and guide plates are clean and the correct size.	
No control of wire feed speed. Other machine functions are normal.	1. The wire feed speed control may be dirty. Rotate several times and check if problem is resolved.	
<b>GAS FLOW PROBLEMS</b>		
Gas does not flow when gun trigger is pulled.	1. Make sure gas supply is connected properly and turned "ON".	If all recommended possible areas of misadjustment have been checked and the problem persists, Contact your local Lincoln Authorized Field Service Facility.
	2. If the gas solenoid does not actuate (click) when the gun trigger is pulled, there may be a restriction in the gas supply line.	
	3. The gun cable assembly may be faulty. Check or replace.	
	4. If gas solenoid does not operate when gun trigger is pulled, the problem is within the POWER MIG® 262MP.	
	5. Make sure the gun is pushed all the way into gun mount and is properly seated.	
<b>SCREEN PROBLEMS</b>		
Error code 213 is displayed on screen	1. Communication between display P.C. board and power control board.	<b>1. Cycle power to machine.</b>
ERROR CODE 36, Thermal trip	1. Machine is overloaded	1. Welding duty should not exceed machine rating
	2. Poor airflow	2. Not enough space behind the back of the machine
ERROR CODE 81, Main motor overload	1. Drive rolls don't match wire size or wire type	1. Check drive rolls
	2. Bad gun liner	2. Try different gun
ERROR 95, Gun motor overload	1. Drive rolls don't match wire size or wire type	1. Check drive rolls
	2. Bad gun liner	2. Try different gun
ERROR CODE 213, Control board offline	No communication between UI & Control PCB	1. Check UI & Control board connection
		2. Replace Control PCB



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Observe all Safety Guidelines detailed throughout this manual

PROBLEMS (SYMPTOMS)	POSSIBLE CAUSE	RECOMMENDED COURSE OF ACTION
<b>PUSH PULL WIRE FEEDING PROBLEMS</b>		
<p>While loading wire, the rear drive rolls stop while pushing wire through the torch.</p>	<ol style="list-style-type: none"> <li>1. Check torch cable for kinks. Torch cable should be laid out relatively straight.</li> <li>2. Check the wire at the spool. Make sure wire is not crossed and is de-reeling properly.</li> <li>3. Increase wire feed speed to 350-400 ipm.</li> </ol>	<p>If all recommended possible areas of misadjustment have been checked and the problem persists, <b>Contact your local Lincoln Authorized Field Service Facility.</b></p>
<p>While loading wire, the wire bird nests before the wire gets all the way through the torch.</p>	<ol style="list-style-type: none"> <li>1. Check torch cable for kinks. Torch cable should be laid out relatively straight.</li> <li>2. Make sure liner conduit is inserted all the way into the rear wire drive so that it is up against the inner black plastic wire guide.</li> <li>3. Inner black plastic wire guide is worn out. Replace guide.</li> <li>4. Slow down wire feed speed while pushing wire up through the liner. Recommended setting = 350MP ipm.</li> <li>5. Clean or replace contact tip.</li> </ol>	

**⚠ CAUTION**

If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your **Local Lincoln Authorized Field Service Facility** for technical troubleshooting assistance before you proceed.

Observe all Safety Guidelines detailed throughout this manual

PROBLEMS (SYMPTOMS)	POSSIBLE CAUSE	RECOMMENDED COURSE OF ACTION
<b>PUSH PULL WIRE FEEDING PROBLEMS</b>		
<p>While loading wire the wire bird nests if the wire misses the outlet guide while shooting the gap in the torch.</p>	<ol style="list-style-type: none"> <li>1. Straighten the first six inches of the wire before feeding it into the rear wire drive.</li> <li>2. Make sure the torch drive rolls are tightened slightly to help the wire jump the gap.</li> <li>3. Slow down wire feed speed while pushing wire through torch liner. Recommend setting = 350 ipm.</li> </ol>	<p>If all recommended possible areas of misadjustment have been checked and the problem persists, <b>Contact your local Lincoln Authorized Field Service Facility.</b></p>
<p>Arc length varies while welding (arc length is not constant).</p>	<ol style="list-style-type: none"> <li>1. POWER MIG® 262MP drive rolls set too tight. The tension arm should be set at 1 to 1-1/2.</li> <li>2. Clean or replace contact tip.</li> </ol>	

** CAUTION**

If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your **Local Lincoln Authorized Field Service Facility** for technical troubleshooting assistance before you proceed.

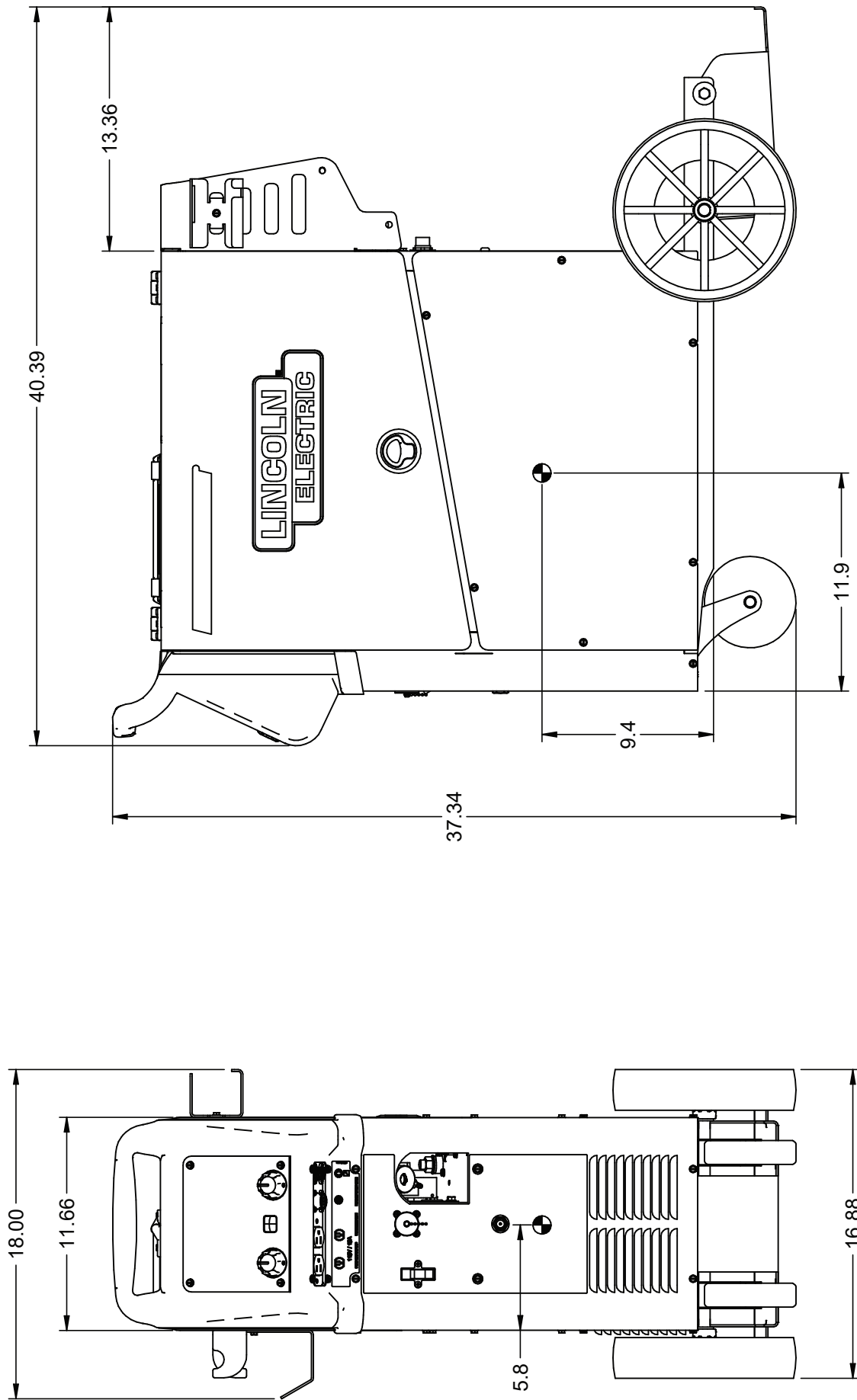
Observe all Safety Guidelines detailed throughout this manual

PROBLEMS (SYMPTOMS)	POSSIBLE CAUSE	RECOMMENDED COURSE OF ACTION
<b>PUSH PULL WIRE FEEDING PROBLEMS</b>		
<p>During Welding the wire continues to burn back to the tip.</p>	<ol style="list-style-type: none"> <li>1. Check to see that the spindle brake is not set too tight. There should be an aluminum spacer behind the spindle brake. Refer to the push-pull connection kit for this spacer.</li> <li>2. POWER MIG® 262MP drive rolls set too tight. The tension arm should be set at 1 to 1-1/2.</li> <li>3. Push-Pull torch drive rolls set too tight. Refer to owners manual for proper setting.</li> <li>4. If pulse welding the trim value may be set too high.</li> <li>5. Clean or replace contact tip.</li> </ol>	<p>If all recommended possible areas of misadjustment have been checked and the problem persists, <b>Contact your local Lincoln Authorized Field Service Facility.</b></p>
<p>Wire bird nests while welding.</p>	<ol style="list-style-type: none"> <li>1. Torch liner conduit not inserted all the way so that it is touching the inner black plastic wire guide.</li> <li>2. Inner black plastic wire guide is worn out. Replace guide.</li> <li>3. Push-Pull torch drive rolls set too tight. Refer to owners manual for proper setting.</li> </ol>	

 **CAUTION**

If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your **Local Lincoln Authorized Field Service Facility** for technical troubleshooting assistance before you proceed.







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<b>WARNING</b>	<ul style="list-style-type: none"> <li>Do not touch electrically live parts or electrode with skin or wet clothing.</li> <li>Insulate yourself from work and ground.</li> </ul>	<ul style="list-style-type: none"> <li>Keep flammable materials away.</li> </ul>	<ul style="list-style-type: none"> <li>Wear eye, ear and body protection.</li> </ul>
Spanish <b>AVISO DE PRECAUCION</b>	<ul style="list-style-type: none"> <li>No toque las partes o los electrodos bajo carga con la piel o ropa mojada.</li> <li>Aíslese del trabajo y de la tierra.</li> </ul>	<ul style="list-style-type: none"> <li>Mantenga el material combustible fuera del área de trabajo.</li> </ul>	<ul style="list-style-type: none"> <li>Protéjase los ojos, los oídos y el cuerpo.</li> </ul>
French <b>ATTENTION</b>	<ul style="list-style-type: none"> <li>Ne laissez ni la peau ni des vêtements mouillés entrer en contact avec des pièces sous tension.</li> <li>Isolez-vous du travail et de la terre.</li> </ul>	<ul style="list-style-type: none"> <li>Gardez à l'écart de tout matériel inflammable.</li> </ul>	<ul style="list-style-type: none"> <li>Protégez vos yeux, vos oreilles et votre corps.</li> </ul>
German <b>WARNUNG</b>	<ul style="list-style-type: none"> <li>Berühren Sie keine stromführenden Teile oder Elektroden mit Ihrem Körper oder feuchter Kleidung!</li> <li>Isolieren Sie sich von den Elektroden und dem Erdboden!</li> </ul>	<ul style="list-style-type: none"> <li>Entfernen Sie brennbares Material!</li> </ul>	<ul style="list-style-type: none"> <li>Tragen Sie Augen-, Ohren- und Körperschutz!</li> </ul>
Portuguese <b>ATENÇÃO</b>	<ul style="list-style-type: none"> <li>Não toque partes elétricas e electrodos com a pele ou roupa molhada.</li> <li>Isole-se da peça e terra.</li> </ul>	<ul style="list-style-type: none"> <li>Mantenha inflamáveis bem guardados.</li> </ul>	<ul style="list-style-type: none"> <li>Use proteção para a vista, ouvido e corpo.</li> </ul>
Japanese <b>注意事項</b>	<ul style="list-style-type: none"> <li>通電中の電気部品、又は溶材にヒフやぬれた布で触れないこと。</li> <li>施工物やアースから身体が絶縁されている様にして下さい。</li> </ul>	<ul style="list-style-type: none"> <li>燃えやすいものの側での溶接作業は絶対にしてはなりません。</li> </ul>	<ul style="list-style-type: none"> <li>目、耳及び身体に保護具をして下さい。</li> </ul>
Chinese <b>警告</b>	<ul style="list-style-type: none"> <li>皮肤或湿衣物切勿接触带电部件及焊条。</li> <li>使你自已与地面和工件绝缘。</li> </ul>	<ul style="list-style-type: none"> <li>把一切易燃物品移离工作场所。</li> </ul>	<ul style="list-style-type: none"> <li>佩戴眼、耳及身体劳动保护用具。</li> </ul>
Korean <b>위험</b>	<ul style="list-style-type: none"> <li>전도체나 용접봉을 젖은 헝겍 또는 피부로 절대 접촉치 마십시오.</li> <li>모재와 접지를 접촉치 마십시오.</li> </ul>	<ul style="list-style-type: none"> <li>인화성 물질을 접근시키지 마십시오.</li> </ul>	<ul style="list-style-type: none"> <li>눈, 귀와 몸에 보호장구를 착용하십시오.</li> </ul>
Arabic <b>تحذير</b>	<ul style="list-style-type: none"> <li>لا تلمس الاجزاء التي يسري فيها التيار الكهربائي أو الألكترود بجسد الجسم أو بالملابس المبللة بالماء.</li> <li>ضع عازلا على جسمك خلال العمل.</li> </ul>	<ul style="list-style-type: none"> <li>ضع المواد القابلة للاشتعال في مكان بعيد.</li> </ul>	<ul style="list-style-type: none"> <li>ضع أدوات وملابس واقية على عينيك وأذنيك وجسمك.</li> </ul>

**READ AND UNDERSTAND THE MANUFACTURER'S INSTRUCTION FOR THIS EQUIPMENT AND THE CONSUMABLES TO BE USED AND FOLLOW YOUR EMPLOYER'S SAFETY PRACTICES.**

**SE RECOMIENDA LEER Y ENTENDER LAS INSTRUCCIONES DEL FABRICANTE PARA EL USO DE ESTE EQUIPO Y LOS CONSUMIBLES QUE VA A UTILIZAR, SIGA LAS MEDIDAS DE SEGURIDAD DE SU SUPERVISOR.**

**LISEZ ET COMPRENEZ LES INSTRUCTIONS DU FABRICANT EN CE QUI REGARDE CET EQUIPMENT ET LES PRODUITS A ETRE EMPLOYES ET SUIVEZ LES PROCEDURES DE SECURITE DE VOTRE EMPLOYEUR.**

**LESEN SIE UND BEFOLGEN SIE DIE BETRIEBSANLEITUNG DER ANLAGE UND DEN ELEKTRODENEINSATZ DES HERSTELLERS. DIE UNFALLVERHÜTUNGSVORSCHRIFTEN DES ARBEITGEBERS SIND EBENFALLS ZU BEACHTEN.**

			
<ul style="list-style-type: none"> <li>● Keep your head out of fumes.</li> <li>● Use ventilation or exhaust to remove fumes from breathing zone.</li> </ul>	<ul style="list-style-type: none"> <li>● Turn power off before servicing.</li> </ul>	<ul style="list-style-type: none"> <li>● Do not operate with panel open or guards off.</li> </ul>	<b>WARNING</b>
<ul style="list-style-type: none"> <li>● Los humos fuera de la zona de respiración.</li> <li>● Mantenga la cabeza fuera de los humos. Utilice ventilación o aspiración para gases.</li> </ul>	<ul style="list-style-type: none"> <li>● Desconectar el cable de alimentación de poder de la máquina antes de iniciar cualquier servicio.</li> </ul>	<ul style="list-style-type: none"> <li>● No operar con panel abierto o guardas quitadas.</li> </ul>	Spanish <b>AVISO DE PRECAUCION</b>
<ul style="list-style-type: none"> <li>● Gardez la tête à l'écart des fumées.</li> <li>● Utilisez un ventilateur ou un aspirateur pour ôter les fumées des zones de travail.</li> </ul>	<ul style="list-style-type: none"> <li>● Débranchez le courant avant l'entretien.</li> </ul>	<ul style="list-style-type: none"> <li>● N'opérez pas avec les panneaux ouverts ou avec les dispositifs de protection enlevés.</li> </ul>	French <b>ATTENTION</b>
<ul style="list-style-type: none"> <li>● Vermeiden Sie das Einatmen von Schweißrauch!</li> <li>● Sorgen Sie für gute Be- und Entlüftung des Arbeitsplatzes!</li> </ul>	<ul style="list-style-type: none"> <li>● Strom vor Wartungsarbeiten abschalten! (Netzstrom völlig öffnen; Maschine anhalten!)</li> </ul>	<ul style="list-style-type: none"> <li>● Anlage nie ohne Schutzgehäuse oder Innenschutzverkleidung in Betrieb setzen!</li> </ul>	German <b>WARNUNG</b>
<ul style="list-style-type: none"> <li>● Mantenha seu rosto da fumaça.</li> <li>● Use ventilação e exaustão para remover fumo da zona respiratória.</li> </ul>	<ul style="list-style-type: none"> <li>● Não opere com as tampas removidas.</li> <li>● Desligue a corrente antes de fazer serviço.</li> <li>● Não toque as partes elétricas nuas.</li> </ul>	<ul style="list-style-type: none"> <li>● Mantenha-se afastado das partes moventes.</li> <li>● Não opere com os painéis abertos ou guardas removidas.</li> </ul>	Portuguese <b>ATENÇÃO</b>
<ul style="list-style-type: none"> <li>● ヒュームから頭を離すようにして下さい。</li> <li>● 換気や排煙に十分留意して下さい。</li> </ul>	<ul style="list-style-type: none"> <li>● メンテナンス・サービスに取りかかる際には、まず電源スイッチを必ず切して下さい。</li> </ul>	<ul style="list-style-type: none"> <li>● パネルやカバーを取り外したまま機械操作をしないで下さい。</li> </ul>	Japanese <b>注意事項</b>
<ul style="list-style-type: none"> <li>● 頭部遠離煙霧。</li> <li>● 在呼吸區使用通風或排風器除煙。</li> </ul>	<ul style="list-style-type: none"> <li>● 維修前切斷電源。</li> </ul>	<ul style="list-style-type: none"> <li>● 儀表板打開或沒有安全罩時不準作業。</li> </ul>	Chinese <b>警告</b>
<ul style="list-style-type: none"> <li>● 얼굴로부터 용접가스를 멀리하십시오.</li> <li>● 호흡지역으로부터 용접가스를 제거하기 위해 가스제거기나 통풍기를 사용하십시오.</li> </ul>	<ul style="list-style-type: none"> <li>● 보수전에 전원을 차단하십시오.</li> </ul>	<ul style="list-style-type: none"> <li>● 판넬이 열린 상태로 작동치 마십시오.</li> </ul>	Korean <b>위험</b>
<ul style="list-style-type: none"> <li>● ابعد رأسك بعيداً عن الدخان.</li> <li>● استعمل التهوية أو جهاز ضغط الدخان للخارج لكي تبعد الدخان عن المنطقة التي تتنفس فيها.</li> </ul>	<ul style="list-style-type: none"> <li>● أقطع التيار الكهربائي قبل القيام بأية صيانة.</li> </ul>	<ul style="list-style-type: none"> <li>● لا تشغيل هذا الجهاز اذا كانت الاغطية الحديدية الواقية ليست عليه.</li> </ul>	Arabic <b>تحذير</b>

**LEIA E COMPREENDA AS INSTRUÇÕES DO FABRICANTE PARA ESTE EQUIPAMENTO E AS PARTES DE USO, E SIGA AS PRÁTICAS DE SEGURANÇA DO EMPREGADOR.**

使う機械や溶材のメーカーの指示書をよく読み、まず理解して下さい。そして貴社の安全規定に従って下さい。

請詳細閱讀並理解製造廠提供的說明以及應該使用的銀焊材料，並請遵守貴方的有關勞動保護規定。

이 제품에 동봉된 작업지침서를 숙지하시고 귀사의 작업자 안전수칙을 준수하시기 바랍니다.

اقرأ بتمعن وافهم تعليمات المصنع المنتج لهذه المعدات والمواد قبل استعمالها واتبع تعليمات الوقاية لصاحب العمل.

## **CUSTOMER ASSISTANCE POLICY**

The business of Lincoln Electric is manufacturing and selling high quality welding equipment, automated welding systems, consumables, and cutting equipment. Our challenge is to meet the needs of our customers, who are experts in their fields, and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or technical information about their use of our products. Our employees respond to inquiries to the best of their ability based on information and specifications provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment, or to provide engineering advice in relation to a specific situation or application. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or communications. Moreover, the provision of such information or technical information does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or technical information, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose or any other equivalent or similar warranty is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the definition of specifications, and the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

## **WELD FUME CONTROL EQUIPMENT**

The operation of welding fume control equipment is affected by various factors including proper use and positioning of the equipment, maintenance of the equipment and the specific welding procedure and application involved. Worker exposure level should be checked upon installation and periodically thereafter to be certain it is within applicable OSHA PEL and ACGIH TLV limits.



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