

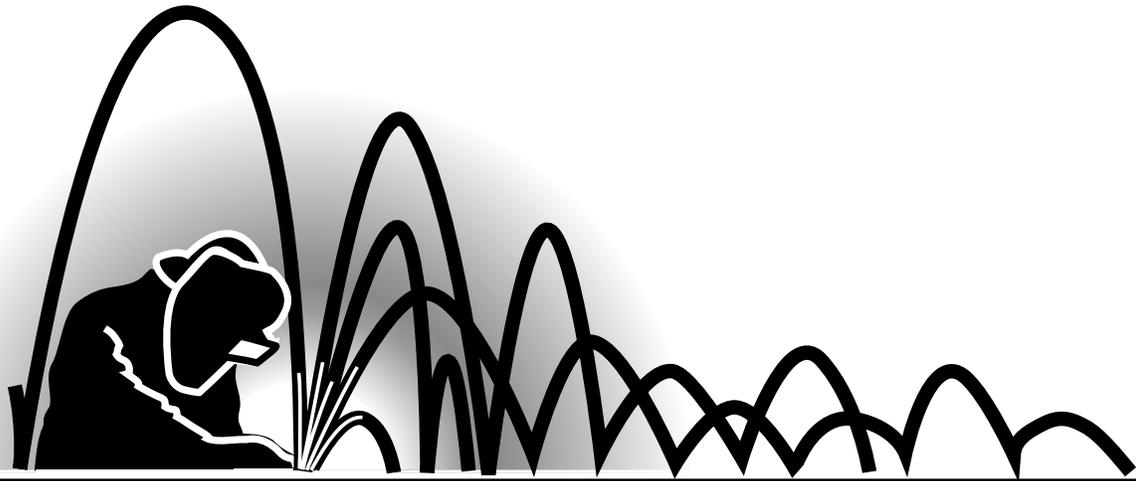
RED-D-ARC

EX350i

IM764

March, 2002

For use with machines having Code Numbers: **10945**



RED-D-ARC

Welderrentals

OPERATOR'S MANUAL

Red-D-Arc Spec-Built Welding Equipment

This **RED-D-ARC** welder is built to **RED-D-ARC Extreme Duty** design specifications by Lincoln Electric.

Safety Depends on You

This welder 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.

1-800-245-3660

North America's Largest Fleet of Welding Equipment

⚠ WARNING

⚠ CALIFORNIA PROPOSITION 65 WARNINGS ⚠

Diesel engine exhaust and some of its constituents are known to the State of California to cause cancer, birth defects, and other reproductive harm.

The Above For Diesel Engines

The engine exhaust from this product contains chemicals known to the State of California to cause cancer, birth defects, or other reproductive harm.

The Above For Gasoline Engines

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 W117.2-1974. 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.

1.a. Turn the engine off before troubleshooting and maintenance work unless the maintenance work requires it to be running.



1.b. Operate engines in open, well-ventilated areas or vent the engine exhaust fumes outdoors.



1.c. 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.

1.d. 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.

1.e. 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.



1.f. 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.

1.g. 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.



1.h. To avoid scalding, do not remove the radiator pressure cap when the engine is hot.



ELECTRIC AND MAGNETIC FIELDS may be dangerous

2.a. Electric current flowing through any conductor causes localized Electric and Magnetic Fields (EMF). Welding current creates EMF fields around welding cables and welding machines

2.b. EMF fields may interfere with some pacemakers, and welders having a pacemaker should consult their physician before welding.

2.c. Exposure to EMF fields in welding may have other health effects which are now not known.

2.d. All welders should use the following procedures in order to minimize exposure to EMF fields from the welding circuit:

2.d.1. Route the electrode and work cables together - Secure them with tape when possible.

2.d.2. Never coil the electrode lead around your body.

2.d.3. 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.

2.d.4. Connect the work cable to the workpiece as close as possible to the area being welded.

2.d.5. Do not work next to welding power source.

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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.

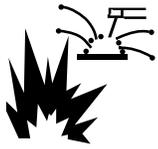
- 4.a. Use a shield with the proper filter and cover plates to protect your eyes from sparks and the rays of the arc when welding or observing open arc welding. Headshield and filter lens should conform to ANSI Z87.1 standards.
- 4.b. Use suitable clothing made from durable flame-resistant material to 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 with electrodes which require special ventilation such as stainless or hard facing (see instructions on container or MSDS) or on lead or cadmium plated steel and other metals or coatings which produce highly toxic fumes, keep exposure as low as possible and below Threshold Limit Values (TLV) using local exhaust or mechanical ventilation. In confined spaces or in some circumstances, outdoors, a respirator may be required. Additional precautions are also required when welding on galvanized steel.**
- 5.b. 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.c. 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.d. Read and understand the manufacturer's instructions for this equipment and the consumables to be used, including the material safety data sheet (MSDS) and follow your employer's safety practices. MSDS forms are available from your welding distributor or from the manufacturer.
- 5.e. Also see item 1.b.

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WELDING 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.



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 1235 Jefferson Davis Highway, Arlington, VA 22202.



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.

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PRÉCAUTIONS DE SÛRETÉ

Pour votre propre protection lire et observer toutes les instructions et les précautions de sûreté spécifiques qui paraissent dans ce manuel aussi bien que les précautions de sûreté générales suivantes:

Sûreté Pour Soudage A L'Arc

1. Protégez-vous contre la secousse électrique:
 - a. Les circuits à l'électrode et à la pièce sont sous tension quand la machine à souder est en marche. Eviter toujours tout contact entre les parties sous tension et la peau nue ou les vêtements mouillés. Porter des gants secs et sans trous pour isoler les mains.
 - b. Faire très attention de bien s'isoler de la masse quand on soude dans des endroits humides, ou sur un plancher métallique ou des grilles métalliques, principalement dans les positions assis ou couché pour lesquelles une grande partie du corps peut être en contact avec la masse.
 - c. Maintenir le porte-électrode, la pince de masse, le câble de soudage et la machine à souder en bon et sûr état de fonctionnement.
 - d. Ne jamais plonger le porte-électrode dans l'eau pour le refroidir.
 - e. Ne jamais toucher simultanément les parties sous tension des porte-électrodes connectés à deux machines à souder parce que la tension entre les deux pinces peut être le total de la tension à vide des deux machines.
 - f. Si on utilise la machine à souder comme une source de courant pour soudage semi-automatique, ces précautions pour le porte-électrode s'appliquent aussi au pistolet de soudage.
2. Dans le cas de travail au dessus du niveau du sol, se protéger contre les chutes dans le cas où on reçoit un choc. Ne jamais enrouler le câble-électrode autour de n'importe quelle partie du corps.
3. Un coup d'arc peut être plus sévère qu'un coup de soleil, donc:
 - a. Utiliser un bon masque avec un verre filtrant approprié ainsi qu'un verre blanc afin de se protéger les yeux du rayonnement de l'arc et des projections quand on soude ou quand on regarde l'arc.
 - b. Porter des vêtements convenables afin de protéger la peau de soudeur et des aides contre le rayonnement de l'arc.
 - c. Protéger l'autre personnel travaillant à proximité au soudage à l'aide d'écrans appropriés et non-inflammables.
4. Des gouttes de laitier en fusion sont émises de l'arc de soudage. Se protéger avec des vêtements de protection libres de l'huile, tels que les gants en cuir, chemise épaisse, pantalons sans revers, et chaussures montantes.
5. Toujours porter des lunettes de sécurité dans la zone de soudage. Utiliser des lunettes avec écrans latéraux dans les

zones où l'on pique le laitier.

6. Eloigner les matériaux inflammables ou les recouvrir afin de prévenir tout risque d'incendie dû aux étincelles.
7. Quand on ne soude pas, poser la pince à un endroit isolé de la masse. Un court-circuit accidentel peut provoquer un échauffement et un risque d'incendie.
8. S'assurer que la masse est connectée le plus près possible de la zone de travail qu'il est pratique de le faire. Si on place la masse sur la charpente de la construction ou d'autres endroits éloignés de la zone de travail, on augmente le risque de voir passer le courant de soudage par les chaînes de levage, câbles de grue, ou autres circuits. Cela peut provoquer des risques d'incendie ou d'échauffement des chaînes et des câbles jusqu'à ce qu'ils se rompent.
9. Assurer une ventilation suffisante dans la zone de soudage. Ceci est particulièrement important pour le soudage de tôles galvanisées plombées, ou cadmiées ou tout autre métal qui produit des fumées toxiques.
10. Ne pas souder en présence de vapeurs de chlore provenant d'opérations de dégraissage, nettoyage ou pistolage. La chaleur ou les rayons de l'arc peuvent réagir avec les vapeurs du solvant pour produire du phosgène (gas fortement toxique) ou autres produits irritants.
11. Pour obtenir de plus amples renseignements sur la sûreté, voir le code "Code for safety in welding and cutting" CSA Standard W 117.2-1974.

PRÉCAUTIONS DE SÛRETÉ POUR LES MACHINES À SOUDER À TRANSFORMATEUR ET À REDRESSEUR

1. Relier à la terre le châssis du poste conformément au code de l'électricité et aux recommandations du fabricant. Le dispositif de montage ou la pièce à souder doit être branché à une bonne mise à la terre.
2. Autant que possible, l'installation et l'entretien du poste seront effectués par un électricien qualifié.
3. Avant de faire des travaux à l'intérieur de poste, la débrancher à l'interrupteur à la boîte de fusibles.
4. Garder tous les couvercles et dispositifs de sûreté à leur place.

Thank You

for selecting a **QUALITY** product by Lincoln Electric. We want you to take pride in operating this Lincoln Electric Company product
•• as much pride as we have in bringing this product to you!

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.

Please record your equipment identification information below for future reference. This information can be found on your machine nameplate.

Model Name & Number _____

Code & Serial Number _____

Date of Purchase _____

Whenever you request replacement parts for or information on this equipment always supply the information you have recorded above.

Read this Operators Manual completely before attempting to use this equipment. Save this manual and keep it handy for quick reference. Pay particular attention to the safety instructions we have provided for your protection. The level of seriousness to be applied to each is explained below:

⚠ 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**.

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TECHNICAL SPECIFICATIONS - RED-D-ARC EX350i

INPUT AC VOLTAGE & DC OUTPUT

Product Name	Ordering Information	Input AC Voltage	Rated DC Output Amps/Volt /Duty Cycle	Output Range (continuous)	Weight with Cord	Dimensions HxWxD Voltage	Open Circuit
EX350i	K1728-2	200 208-230/ 380-400/ 415-460/ 575 1 & 3 Phase 60/50 Hz	350A / 34V / 60% 300A / 32V /100%	AMPS 5-425	(84.0 lbs) (38.0 kg.)	14.8" x 13.3" x (373 x 338 x 27.8")** (373 x 338 x 706*)mm	80 VDC

* Overall Length Including Handle, 27.8" (706mm)

EX350i INPUT CURRENT

Recommended Fuse Sizes Base On The U.S. National Electrical Code And Maximum Machine Outputs

Input 50/60 Hz		Output		Recommended		Notes
Voltage	Phases	300Amps @ 32Volts(100%)	350Amps @ 34Volts(60%)	Line Cord AWG	Fuse size	
200	1	Not Recommended	Not Recommended		---	Note 1
208	1	76	94	2	125A	Note 2
230	1	69	85	4	125A	Note 2
380	1	Not Recommended	Not Recommended		---	Note 1
400	1	Not Recommended	Not Recommended	---	---	Note 1
415	1	41	64	6	80A	Note 2
460	1	36	42	8	70A	
575	1	31	37	8	50A	
200	3	41	50	8	80A	Note 2
208	3	39	50	6	80A	Note 2
230	3	36	42	8	70A	
380	3	23	28	8	50A	
400	3	22	27	8	50A	
415	3	22	26	8	50A	
460	3	19	23	8	50A	
575	3	16	18	8	35A	

Note 1. Not rated is indicated by 4-x's in the box on the rating plate.

Note 2. When operating on these inputs, the line cord should be changed to an input conductor of 6 AWG or larger.

OUTPUT CABLES, CONNECTIONS AND LIMITATIONS

Select The output cable size based upon the following chart.

Cable sizes for Combined Length of Electrode and Work Cable (Copper) 75C rated:

DUTY CYCLE	CURRENT	LENGTH UP TO 200FT.(61m)	200-250 FT. (61-76m)
100%	300	1/0	1/0
60%	350	1/0	2/0

EX350i



SAFETY PRECAUTIONS

⚠ WARNING



ELECTRIC SHOCK can kill.

- **TURN THE INPUT POWER OFF AT THE DISCONNECT SWITCH BEFORE ATTEMPTING TO CONNECT OR DISCONNECT INPUT POWER LINES, OUTPUT CABLES, OR CONTROL CABLES.**
- Only qualified personnel should perform this installation.
- Connect the green/yellow lead of the power cord to ground per U.S.National Electrical Code.

SELECT SUITABLE LOCATION

The Invertec EX350i will operate in harsh environments. Even so, it is important that simple preventative measures are followed in order to assure long life and reliable operation.

- The machine must be located where there is free circulation of clean air such that air movement in the back, out the sides and bottom will not be restricted.
- Dirt and dust that can be drawn into the machine should be kept to a minimum. Failure to observe these precautions can result in excessive operating temperatures and nuisance shutdown.
- Keep machine dry. Shelter from rain and snow. Do not place on wet ground or in puddles.
- **DO NOT MOUNT OVER COMBUSTIBLE SURFACES.**

⚠ CAUTION

Where there is a combustible surface directly under stationary or fixed electrical equipment, that surface shall be covered with a steel plate at least .06"(1.6mm) thick, which shall extend not less than 5.90"(150mm) beyond the equipment on all sides.

STACKING

EX350i cannot be stacked.

TILTING

Place the machine directly on a secure, level surface or on a recommended undercarriage. The machine may topple over if this procedure is not followed.

INPUT AND GROUNDING CONNECTIONS

- Only a qualified electrician should connect the Invertec EX350i. Installation should be made in accordance with the appropriate National Electrical Code, all local codes and the information detailed below.
- When received directly from the factory, multiple voltage machines are internally connected for 460VAC. If 460VAC is the desired input, then the machine may be connected to the power system without any setup required inside the machine.
- Initial 200VAC - 415VAC and 575VAC operation will require an Input voltage panel setup.

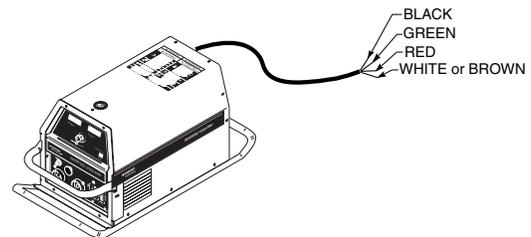
- Open the access panel on the rear of the machine.
- For 200 or 230: Position the large switch to 200-230.
- For higher voltages: Position the large switch to 380-575.
- Move the "A" lead to the appropriate terminal.

POWER CORD CONNECTION

A 25 ft. power cord is provided and wired into the machine. Follow the power cord connection instructions.

⚠ CAUTION

- **Incorrect connection may result in equipment damage.**



Single Phase Input

Connect green lead to ground per National Electrical Code.

Connect black and white or brown leads to power. Wrap red lead with tape to provide 600V insulation.

Three Phase Input

Connect green lead to ground per National Electric Code.

Connect black, red and white leads to power.

CONNECTIONS OF WIRE FEEDERS TO EX350I

LN-25 Connection Instructions

-Not recommended for Pulse Welding with the Advanced Process Kit).

- **Turn the EX350i power switch "off".**
- Connect the electrode cable to the output terminal of polarity required by electrode. Connect the work lead to the other terminal.
- LN-25 with Remote Control options can be used with the EX350i. The 14 pin (K444-2) remote can be connected directly to the 14 pin amphenol. The 42 Volt Remote Voltage and Output Control (K624-1) Kit can be connected to the EX350i 24/42 VAC amphenol using Remote Control Cable assembly K627- []. LN-25s with a K431-1 remote kit can be connected to the 24/42 VAC amphenol using a K432 cable and a K876 adapter. (See connection diagram S19899) to connect it to one of the 14-pin amphenols. Or the K432 cable could be modified with a K867 Universal Adapter Plug (See connection diagram S19405) to connect it to the 24/42 VAC 14-pin amphenol.

EX350i



LN-7 Connection Instructions

- Turn the EX350i power switch "off".
- Connect the K480 control cable from the LN-7 to the EX350i 115 VAC control cable connector. The control cable connector is located at the front of the EX350i.
- Connect the electrode cable to the output terminal of polarity required by electrode. Connect the work lead to the other terminal
- Set the meter polarity switch on the front of the EX350i to coincide with wire feeder polarity used. The wire feeder will now display the welding voltage.
- If K480 is not available, see connection diagram S19404 for modification of K291 or K404 LN-7 input cable with K867 universal adapter plug.

LN-10 Connection Instructions

- Turn the EX350i power switch "off"
- Connect the K1505 control cable from the LN-10 to the EX350i 24/42VAC 14-pin amphenol connector on the front of the EX350i.
- Connect the electrode cable to the output terminal of polarity required by the electrode. Connect the work lead to the other terminal.
- Set the meter polarity switch on the front of the EX350i to coincide with wire feeder polarity used.
- See the LN-10 manual for details on accessing Control DIP Switch

LN-742 Connection Instructions

- Turn the EX350i power switch "off"
- Either a K591 or a K593 Input cable assembly is required to connect the LN-742 to the EX350i.
- Connect the control cable from the LN-742 to the 24/42 VAC 14-pin wire feeder amphenol on the front of the EX350i.
- Connect the electrode cable to the output terminal of the polarity required by electrode. Connect the work lead to the other terminal.
- Set the meter polarity switch on the front of the EX350i to coincide with wire feeder polarity used. The wire feeder will now display the welding voltage.
- If a remote control is to be used with the LN-742, use a K864 adapter to connect the feeder and a K857 remote to the 14-pin wire feeder connector on the front of the EX350i.

Cobramatic Connection Instructions

- Turn the EX350i power switch "off"
- Connect the control cable from the Cobramatic to the 24/42 VAC 14-pin wire feeder amphenol on the front of the EX350i.
- Connect the electrode cable to the output terminal of the polarity required by electrode. Connect the work lead to the other terminal.
- Set the meter polarity switch on the front of the EX350i to coincide with wire feeder polarity used.
- If a remote control is to be used with the Cobramatic, or use a K864 adapter to connect the cobramatic and a K857 remote to the 24/42VAC 14-pin wire feeder amphenol connector on the front of the EX350i.

TIG Module K930-2

The TIG Module connects to the EX350i with a K936-1 (9-14 pin) control cable. Connect the K936-1 to the 115VAC wire feeder amphenol on the front of the EX350i.

General Instructions for Connection of Wire Feeders to EX350i

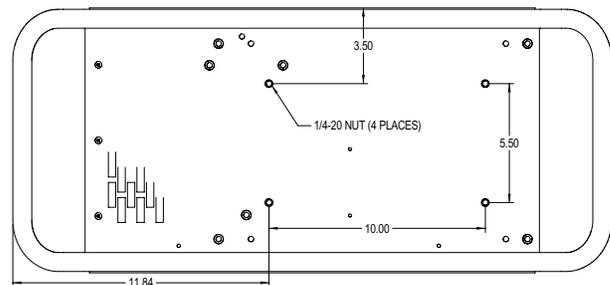
Wire feeders other than LN-7 and LN-25 may be used provided that the auxiliary power supply capacity of the EX350i is not exceeded. K867 universal adapter plug is required. See connection diagram S24985 on page F-4.

REMOTE CONTROL OF INVERTEC

Remote Control K857, Hand Amptrol K963 and Foot Amptrol K870.

UNDERCARRIAGE MOUNTINGS**MOUNTING HOLE LOCATIONS**

NOTE: MOUNTING SCREWS CANNOT PROTRUDE MORE THAN 0.5 INCHES INSIDE THE MACHINE.



EX350i



PARALLEL OPERATION

The EX350i are operable in parallel in CC mode. For best results, the currents of each machine should be reasonably well shared. As an example, with two machines set up in parallel for a 400 amp procedure, each machine should be set to deliver approximately 200 amps, not 300 amps from one and 100 amps from the other. This will minimize nuisance shutdown conditions. In general, more than two machines in parallel will not be effective due to the voltage requirements of procedures in that power range.

To set machine outputs, start with output control pots and arc control pots in identical positions. Use the output control pots to balance the currents and maintain the desired voltage or current. The arc control pots should be kept identical on the two machines.

EX350i

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.



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 closed containers.



ARC RAYS can burn eyes and skin.

- Wear eye, ear and body protection.

See additional warning information at front of this operator's manual.

GENERAL DESCRIPTION

The Invertec EX350i offers multi-process CV, CC, and DC welding and is rated 350 amps, 34 volts at a 60% duty cycle.

DUTY CYCLE

The EX350i is rated at 350 amps, 60% duty cycle (based on a 10 minute cycle). It is also rated at 300 amps, 100% duty cycle.

OPERATIONAL FEATURES and CONTROLS:

UPPER CONTROL PANEL

1. AMPS Meter

- Prior to STICK or TIG operation (current flow), the meter displays preset current value (either 2 amps or +/- 3% (e.g. 3 amps on 100), whichever is greater).
- Prior to CV operation, the meter displays four dashes indicating non-presetable AMPS.
- During welding, this meter displays actual average amps.

- After welding, the meter holds the actual current value for 5 seconds. Output adjustment while in the "hold" period results in the "prior to operation" characteristics stated above. The displays blink indicating that the machine is in the "Hold" period.

2. VOLT METER

- Prior to CV operation (current flow), the meter displays desired preset voltage value (+/- .5V).
- Prior to STICK or TIG operation, the meter displays the Open Circuit Voltage of the Power Source or four dashes if the output has not been turned on.
- During welding, this meter displays actual average volts.
- After welding, the meter holds the actual voltage value for 5 seconds. The displays blink indicating that the machine is in the "Hold" period.
- Output adjustment while in the "hold" period results in the "prior to operation" characteristics stated above.

3. OUTPUT CONTROL

- Output control is conducted via a single turn potentiometer.
- Adjustment is indicated by the meters as stated above.
- When in TIG modes, this control sets the maximum welding current. Full depression of a foot or hand Amptrol results in the preset level of current.

4. WELD TERMINALS-REMOTE / ON

- Two status lights indicate the location of trigger control as determined by the "WELD TERMINALS" push button.
- If trigger control is local "weld terminals on", the ON display will be lit.
- If trigger control is remote "weld terminals remotely controlled", the REMOTE display will be lit.
- The unit will power up in "pre-determined preferred" trigger modes.

STICK = ON

CV = REMOTE

TIG = REMOTE if remote output controls are attached to the machine.

TIG = ON if remote output controls are not attached to the machine.

For all versions, these trigger modes can be over-ridden (switched) with the WELD TERMINALS push button. When changed, the unit will power up in the configuration it was in when it was last powered down.

5. THERMAL

- This status light indicates when the power source has been driven into thermal overload. If the output terminals were "ON", the "ON" light will blink indicating that the output will be turned back on once the unit cools down to an acceptable temperature level. If the unit was operating in the "REMOTE" mode, the trigger will need to be opened before or after the thermal has cleared and closed after the machine has cooled down to an acceptable temperature to establish output.

6. CONTROL-REMOTE / LOCAL

- Two status lights indicate the location of output control as pre-determined by the power sources auto-configure system.
- The LOCAL display will be lit when control is at the power source.
- The REMOTE display will be lit when a remote pot/control is detected.

These Output Control configurations can be overridden (switched) with the CONTROL push button. When changed, the unit will power up in the configuration it was in when it was last powered down.

Hidden Middle Control Panel – Process Set Up Panel

7. WELD MODE SELECT -

The Mode Control button selects from the following welding modes.

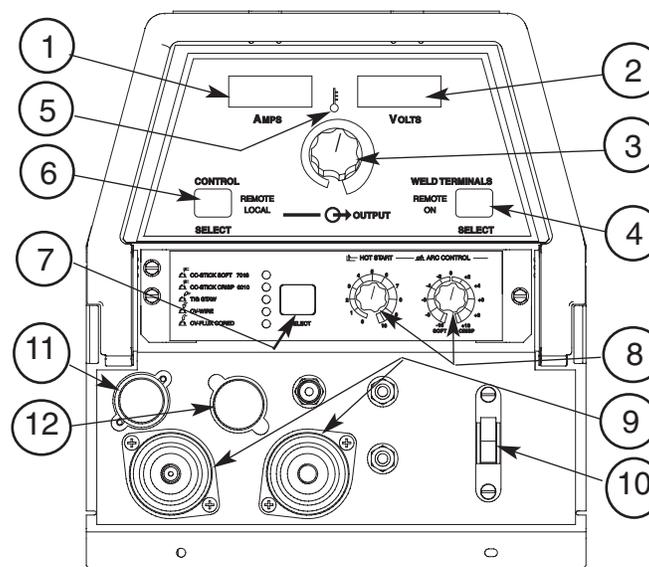
CC-STICK SOFT: The Stick Soft process features continuous control ranging from 5 to 425 amps. This mode was intended for most SMAW applications, and Arc Gouging.

- Arc Gouging: Setting the output of the Stick Soft mode to 425 amps will enable the arc-gouging mode. The actual output current will depend on the size of carbon used. The recommended maximum size carbon is 5/16".
- The Hot Start control regulates the starting current at arc initiation. Hot Start can be adjusted from minimum (0), with no additional current added at arc start, to maximum (10), with double the preset current or 425 amps (max of machine) added for the first second after arc initiation.
- The Arc Control regulates the Arc Force to adjust the short circuit current. The minimum setting (-10) will produce a "soft" arc and will produce minimal spatter. The maximum setting (+10) will produce a "crisp" arc and will minimize electrode sticking.

CC-STICK CRISP: The Stick Crisp mode features continuous control from 5 to 425 amps. This mode was intended primarily for pipe welding applications.

- The Hot Start control regulates the starting current at arc initiation. Hot Start can adjust starting current up or down by 25% of the preset value. The recommended setting for Hot Start is 5 where the initial current is equal to the preset current.
- The Arc Control regulates the Arc Force to adjust the short circuit current. The minimum setting (-10) will produce a "soft" arc and will produce minimal spatter. The maximum setting (+10) will produce a "crisp" arc and will minimize electrode sticking.

FIGURE 1



EX350i



TIG GTAW: The TIG mode features continuous control from 5 to 425 amps. The TIG mode can be run in either the TIG touch start or high frequency (optional equipment required) assisted start mode.

- The Hot Start control selects the starting mode desired. A setting of less than 5, the TIG lift start mode is selected. The OCV is controlled below 10v and the short circuit "TIG touch" current is maintained at 25 amps independent of the preset current.

When the tungsten is lifted, an arc is initiated and the output is regulated at the preset value. Hot start settings between 0 and 5 regulate the arc initiation current. A setting of 5 results in the most positive arc initiation. A setting of 0 reduces hot start.

- Hot Start settings between 5 and 10, select high frequency assisted starting TIG mode. In this range, the OCV of the machine is controlled between 50 and 70 volts. If using the Lincoln K930-1 TIG Module, set the Hot start to 10 for maximum OCV.
- The Arc Control is not used in the TIG mode.

TIG SOLENOID OPTION

The Solenoid only operates when the V350 is in the TIG mode. If the Weld Terminals are in "Remote" then the solenoid will open when the arc start switch is closed. The solenoid will close after the arc switch has been opened and the post flow time expired.

If the Weld Terminals are turned "ON", then the solenoid will open when the electrode is touch to the work. The electrode needs to remain in contact with the work to allow for gas coverage before attempting to start the arc. The solenoid will close after the arc has been broken and the post flow time expired.

CV-WIRE: The CV-WIRE mode features continuous control from 10 to 40 volts. The mode was intended for most GMAW, FCAW, and MCAW applications.

- The Hot Start control is not used in the CV-WIRE mode.
- The Arc Control regulates pinch effect. At the minimum setting (-10), minimizes pinch and results in a soft arc. Low pinch settings are preferable for welding with gas mixes containing mostly inert gases. At the maximum setting (+10), maximizes pinch effect and results in a crisp arc. High pinch settings are preferable for welding FCAW and GMAW with CO₂.

CV-INNERSHIELD: The CV-INNERSHIELD mode features continuous control from 10 to 45 volts. This mode was designed for self-shielded flux cored wires that require tight voltage control.

- The Hot Start control is not used in the CV-FLUX CORED mode.
- The Arc Control regulates pinch effect. At the minimum setting (-10), minimizes pinch and results in a soft arc. At the maximum setting (+10), maximizes pinch effect and results in a crisp arc. Most self-shielded wires work well at an Arc Control setting of 5.

7A. ADVANCED PROCESS PANEL

(See Figure 2)

To program Welding modes. Select knob is used to Scroll through all Welding modes. The Memory button is used to store and access Welding modes into locations M1 thru M8.

Modes:

In addition to the 5 welding modes described in **SECTION 7**, the Advance Process Panel allows you to select the Following additional modes.

• Constant Power mode

In the Power Mode;

The work point will be in the Volts window. The Amp window will have **CP** displayed indicating Constant Power. Once current starts flowing and during the 5 second "Hold" feature the displays will show Volts and Amps respectively.

• Gouge

Air Carbon Arc Cutting (CAC-A) is a physical means of removing base metal or weld metal by using a carbon electrode, an electric arc and compressed air.

• Pulsed Modes

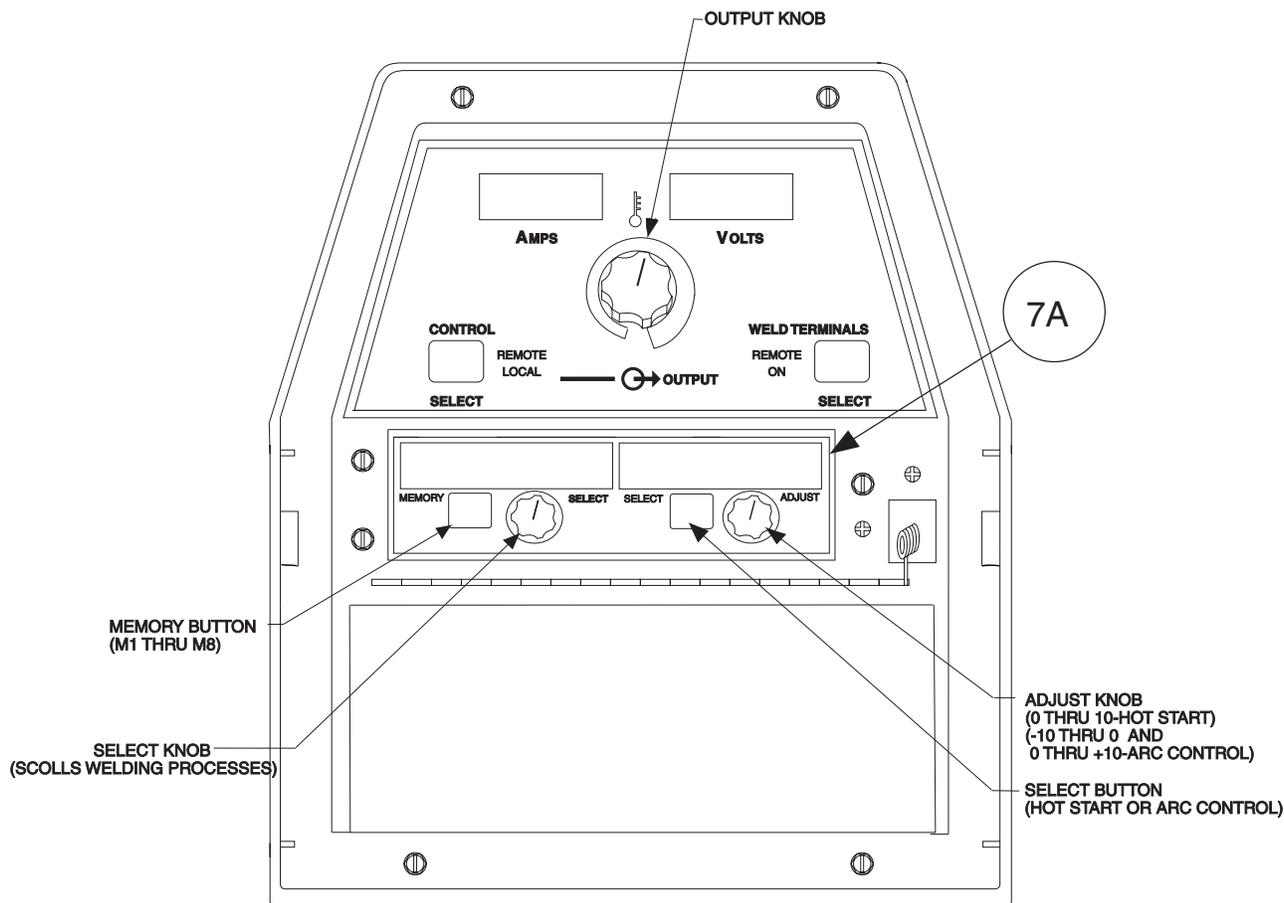
In Pulse Modes;

The work point will be in the Amps window and should be set close to the wire feed speed of the wire feeder in inches per minute. The Volts window will have **SPd** displayed indicating Wire Feed Speed. Once current starts flowing and during the 5 second "Hold" feature the displays will show amps and volts.

Pulse Mode features that are displayed while selecting a Welding pulse mode are listed below;

- Steel - .030, .035, .045, .052 – Argon Blends
- Stainless Steel - .030, .035, .045 – Argon Blends & Helium/Argon Blends
- Aluminum - .035, 3/64, 1/16 – 4043 & 5356
- Metal Core - .045, .052 – Argon Blends
- Nickel - .035, .045 – Argon/Helium blends

FIGURE 2



ADVANCE PROCESS PANEL VERSION

EX350i



CONTROLS: (See Figure 2)

The **MEMORY button** and **SELECT knob** are used together to select a welding process and store it in memory (M1 thru M8). The **SELECT knob** scrolls through the, welding process modes and memory M1 thru M8. The **MEMORY button** stores the welding process in memory.

- **SELECT button** (The right button) selects between the "Hot Start" or "Arc Control". The < will indicate the active feature shown below.

Right Digital Window
 "Hot Start" (-10 to 0 +10)
 "Arc Control" (0 to 10) <

- The **ADJUST knob** adjusts the desired settings for the Hot Start or Arc Control feature that is active.

WELDING PROCESS MODES AVAILABLE

Stick SMAW, TIG GTAW
 Gouge CAG, CV MIG GMAW
 CV Flux Core, Pulse MIG

ELECTRODE MATERIAL

Steel, Metal Core, Stainless, Aluminum, Nickel

EXAMPLE OF SAVING WELDING MODES TO MEMORY

The following example is how to select **Pulse MIG** using .035 steel and store it into memory.

1. Turn the **Select knob** until welding process is displayed.

RIGHT WINDOW	LEFT WINDOW
Pulse MIG	Argon Blends
Steel .035	

2. Wait two seconds and the right window will display Arc Control on the second line on the right side.

Pulse MIG	Argon Blends
Steel .035	Arc Cntrl ### <

3. **SPd** is displayed in the upper right **Volts** window. The left **Amps** window matches the desired wire feed speed that is set on the wire feeder. Adjust the **Output knob** until desired number is displayed.

4. Start welding. If the arc length is too short turn the **Output knob** up. If the arc length is too long turn the **Output knob** down.

The Arc Control which is displayed in the right digital window can be used to fine-tune the arc length and characteristics.

5. After all adjustments have been made press and hold the **Memory button** until the display changes. The right and the left window will display a memory position, lets say M1(or turn knob to select memory of your choice. To store in M1 push the **Memory button** again to save the Pulse Mig mode to memory M1.

6. The display in the digital windows read as follows:

M1	Pulse MIG	Argon Blends
Steel	.035	Arc Cntrl 1.2

7. To save a second welding mode to a memory position of your choice, turn the **Select knob** until the desired welding process mode is displayed in right digital window. Then follow steps 1 thru 6.

8. Adjust the output control to the correct wire feed setting and the EX350i is ready to weld again. (Note: The wire feed speed setting is not stored in memory and will need to be reset.)

9. Adjust the Arc Control and note that the M1 goes away indicating that the EX350i settings no longer match what is stored in memory. Going back to the original settings will not bring the M1 back. You will need to push the **Memory button** to recall the original settings in M1.

Note: After all memory's M1 thru M8 are used and the welder needs to store another welding process, a new welding process will overwrite what was originally in the memory and will read,

Save to MEM
 M1 Overwrite

M1 which stored Pulse Mig is Overwritten with the new welding process.

WELD MODE DETAILS:

Mode	Range	Comments
Stick Soft	5 - 425 amps	The stick soft mode is the best selection for general stick applications. Arc Control = Arc Force Hot Start = Initial hot start current (min = start a match set amps, Max. = greatest hot start current) During hot start, arc force is set at high and is fast response. For gouging applications: Turn current up to 425 amps.
Stick Crisp	5 - 425 amps	The stick crisp mode features an aggressive arc force routine well suited for Exx10, Exx11 series electrodes. Arc Control = Arc Force Hot Start = Initial hot start current (Mid range = welding current and will vary up and down with knob control.) During hot start, arc force is set at high and is fast response. For gouging applications: Turn current up to 425 amps.
GTAW (Tig mode)	5 - 425 amps	The tig mode produces a soft, steady constant current waveform for either touch start or high frequency assisted start DC GTAW applications. Hot Start = Min to Mid range = Touch start with low OCV Mid to Max range = High frequency assisted starting with adjustable OCV up to 70 volts.
GMAW - CV	10 - 45 volts	The GMAW - CV mode is the best selection for general MIG welding, Metal core, and gas shielded applications. Arc Control = Pinch (Min = min pinch, softest arc), (Max = max pinch, crispest arc)
FCAW-SS	10 - 45 volts	The FCAW-SS mode is designed for Self Shielded Innershield products that require tight voltage control. For example; the NR 203 series or NR 207) Arc Control = Pinch (Min = min pinch, softest arc), (Max = max pinch, crispest arc,)
ADVANCED PULSE PANEL WELDING PROGRAMS		
Gouging	60 - 425 amps	The gouging mode is a low power version of other Lincoln welding equipment gouging programs, for example a Power Wave 455.
GMAW - Power	1 - 18 (No Units)	The GMAW - Power mode features good stable short arc performance when welding small diameter (.025 and .030 steel & stainless) wires at low procedures. This mode also performs well welding aluminum in the spray mode. This mode does not allow preset voltage. In the short arc GMAW mode, the set KW will not equal the actual Volts * Amps. The set power is regulated only when an arc is present. During shorting, the output is allowed to increase to clear the short.

PULSE PROGRAMS:

MODE	IMP*	COMMENTS
.030 Steel	65 - 1200	<p>The EX350i pulse programs are non-synergic and allow independent control of the wire feed speed and the arc length. The Output Control Knob on the EX350i, adjusts an "SPD" value. Similar to trim, the "SPD" value indicates the relative arc length setting. The value of "SPD" is meant to be a starting point at which to set the arc length relative to the wire feed speed. Depending on the application, the "SPD" value can be adjusted to obtain the desired arc length.</p> <p>The "SPD" value displayed on the EX350i may not match the actual wire feed speed!</p> <p>The operation of the Arc Control knob on the EX350i is similar to the Power Wave series. As Arc Control is increased, the frequency is increased and the background reduced. Decreasing Arc Control will reduce frequency and increase background current. Arc Control acts to fine tune the arc plasma to the specific application. Preferred gas selections:</p> <p>Steel Argon Blends = Argon with CO2 additions from 2 to 20 % or Oxygen additions from 2 to 5%.</p> <p>Stainless Argon Blends = Argon with Oxygen additions up to 2%.</p> <p>Stainless He Ar CO2 = ~ 90% Helium, 7 1/2 % Argon 2 1/2 CO2</p> <p>Aluminum 100% Argon</p>
.035 Steel	55 - 800	
.045 Steel	50 - 700	
.052 Steel	75 - 550	
.045 Metal Core	50 - 650	
.052 Metal Core	50 - 500	
.030 Stainless Ar Blends	85 - 770	
.030 Stainless He Ar CO2	110 - 770	
.035 Stainless Ar Blends	65 - 770	
.035 Stainless He Ar CO2	75 - 770	
.045 Stainless Ar Blends	50 - 600	
.045 Stainless He Ar CO2	50 - 600	
.035 Aluminum 4043	100 - 700	
.035 Aluminum 5356	115 - 740	
3/64 Aluminum 4043	80 - 550	
3/64 Aluminum 5356	85 - 700	
1/16 Aluminum 4043	75 - 325	
1/16 Aluminum 5356	75 - 450	
.035 Nickel Alloys (Non Adaptive)	80 - 700	<p>The Nickel Alloy pulse programs are non adaptive. The operator sets the output control knob to deliver the correct arc length at desired wire feed speed and stick out. While welding, the operator manipulates the stick out to maintain the correct arc length. This method of operation produces very stable arc performance considering the nature of nickel alloys.</p> <p>Preferred gas: Argon/Helium Blends = for the best results add helium to the argon base from 0-25%.</p>
.045 Nickel Alloys (Non Adaptive)	75 - 550	
PULSE ON PULSE		
.035 4043 (4x Pulse on Pulse)	120 - 600	<p>Arc Control = Pulse on Pulse frequency. For faster travel speed welds, the arc control should be increased.</p> <p>For larger puddle, slower travel speeds, the arc control should be decreased.</p>
3/64 4043 (4x Pulse on Pulse)	85 - 400	
.035 5356 (5x Pulse on Pulse)	130 - 700	
3/64 5356 (5x Pulse on Pulse)	100 - 550	

*IPM (INCHES PER MINUTE)

EX350i



LN-10/DH-10 Wire Feeder Compatibility Note:

The LN-10 and DH-10 feeders can be used to pulse weld and in the power mode with the panel. The displays on the LN-10 & DH-10 do not show the wire feed speed or power.

8. HOT START and ARC CONTROL features have different functions depending on the welding Mode that is active. Each feature is described under the welding mode heading. **(See Item 7 or 7.A for specified Mode Operations) (See Figure 1 or 2)**

LOWER CASE PANEL (See Figure 1)

The output studs, line switch and remote connector are located on the lower case front.

9. Both STUDS contain "Twist-Mate" connector inserts.

- The Negative stud is configured to accept the pass through gas system.

10. The ON-OFF switch is a 3-phase circuit breaker rated at 100 amps per leg.

11. The METER POLARITY switch is located above the output connectors. The switch provides a work connection for wire feeder voltmeters. Place the switch in the position of the electrode polarity indicated by the decal. **The switch does not change the welding polarity.**

12. 3-PIN AMPENOL for remote control.

REMOTE CONTROL of the OUTPUT CONTROL and WELD TERMINALS

The EX350i has auto sensing of remote output controls. If after connecting or removing a remote, the EX350i is not configured the way you would like the local or remote control settings can be changed by pushing the OUTPUT CONTROL or WELD TERMINAL button. (A user cannot select between the 3 and 14 pin amphenols.)

CV modes

- The remote will default to the 14-pin amphenol remote if a remote is connected to either of the 14-pin amphenols and the 3-pin amphenol. Note: Only one of the 14-pin amphenols can have a remote control connected at a time. If no remote is connected to either of the 14-pin amphenols then the remote will default to the 3-pin amphenol if a remote is connected to it.
- If a remote control **is connected or is not connected** to any of the amphenols the WELD TERMINAL control will default to REMOTE.

TIG mode

- The remote will default to the 3-pin amphenol if a remote control is connected to the 3-pin amphenol and one of the 14-pin amphenols. If a remote is not connected to the 3-pin amphenol then the remote will default to the 14-pin amphenols if a remote is connected to one of the 14-pin amphenols.

- If a remote control is connected to any of the amphenols the WELD TERMINAL control will default to REMOTE. If there are not any remote control devices attached the WELD TERMINAL control will default to ON.

CC-Stick modes

- The remote will default to only the 3-pin amphenol if a remote is connected to it.
- The WELD TERMINAL control will default to ON with or without a remote connected.

Types of Remote OUTPUT CONTROL

- The EX350i's Output Control can be controlled by either a potentiometer connected between 77 & 75 with the wiper connected to 76 or a 0V to 10V DC supply connected between 76 & 75. (76 needs to be positive)
- 14-Pin Amphenol lead 75 is pin G, lead 76 is pin F and lead 77 is pin E.
- 3-pin Amphenol lead 75 is pin A, lead 76 is pin B and lead 77 is pin C.

Potentiometer Control

- The total resistance should be between 2000 ohms (2K) and 10,000 ohms (10K)
- The machine output will be at minimum when lead 76 (wiper) is at the end of the potentiometer that is connected to 75. The machine's output will increase as the wiper of the potentiometer is moved to the end that is connected to 77. (Note: In TIG mode, moving the lead 76 (wiper) to lead 77 would produce the current that has been set by the EX350i's front panel Output Control.)

Voltage Control

- The supply should be an isolated supply. (Not referenced to earth ground, any auxiliary power from the EX350i or the welding output) The supply should be capable of supplying at least 20mA.
- 0 volts supplied to 76 will set the EX350i to minimum output for the mode that has been selected while 10 volts supplied to 76 will set the EX350i to the maximum output for the mode. (Note: In TIG mode, 10 volts supplied to lead 76 would produce the current that has been set by the EX350i's front panel Output Control.)

Types of Remote WELD TERMINAL Control

- The EX350i's Weld Terminals can be controlled from each of the 14 pin amphenol connectors. The circuit has a nominal OCV of 15VDC and requires a dry contact closure (less than 100 ohms) to activate the output of the EX350i.
- 14 Pin Amphenols the Weld Terminals are controlled from pins C (lead 2) and pin D (lead 4). Pin C is positive.

EX350i



AUXILIARY POWER

- 115VAC, 42VAC and 24VAC power is available from the two 14-pin amphenols on the rear of the unit. These supplies are intended to supply power for auxiliary equipment like wire feeders and the TIG Module.
- 115VAC supply is rated at 2 amps and is protected by a 2.5 amp breaker located by the amphenol.
- 42 VAC supply is rated at 5.5 amps and is protected by a 6 amp breaker located by the amphenol.
- 24 VAC supply is rated at 5.5 amps and is protected by a 6 amp breaker located by the amphenol.

LIMITATIONS

- The EX350i is not recommended for processes other than those listed.
- The EX350i can only be used with the recommended equipment and options.

RECOMMENDED PROCESSES

Properly equipped, the EX350i supports GMAW, FCAW, SMAW, GMAW-P, GTAW and CAC-A processes for a variety of materials, including mild steel, stainless steel, cored wires, and aluminum.

OPTIONS / ACCESSORIES

- K2176-1 Twist-Mate to Lug Adapter
- K1764-1 Inverter and Feeder Cart
- K1557 Swivel Kit
- K1702-1 Dual Cylinder Kit (For K1764-1)
- K1838-2 Valet Style Undercarriage

Welding Cable Connectors:

- K852-70 1/0-2/0 cable
- K852-95 2/0-3/0 cable

- K857 Remote Output Control 25ft.
- K814 Arc Start Switch
- K963-[] Hand Operated Amptrol
- K870 Foot Operated Amptrol

Note: All of the above remote controls have a 6-pin MS-style connector, a K864 or K876 adapter is needed to connect them to the 14 pin wire feeder MS-style connector. (See Diagram in Section F-1)

- K930-2 TIG Module
- K428 LN-25 Wire Feeder with meters*
- K449 LN-25 Wire Feeder *
- K617-1 LN-742 Wire Feeder W/2 Roll Drive
- K618-1 LN-742 Wire Feeder W/4 Roll Drive
- K440-2 LN-7 GMA Wire Feeder
- K567-2 LN-7 GMA Wire Feeder W/4 Roll Drive
- K1559-1 LN-10 Bench Model (CV)
- K1564-1 LN-10 Generic 16ft. Boom Package
- K1499-1 DH-10 Bench Model
- K1521-1 DH-10 Generic 16ft. Boom Package
- K1853-1 Cobramatic

*Not recommended for pulse welding

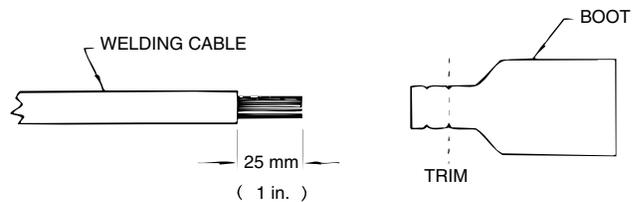
FIELD INSTALLED OPTION

- K1762-2 TIG Gas Control Kit
- K1763-1 Advanced Process Panel

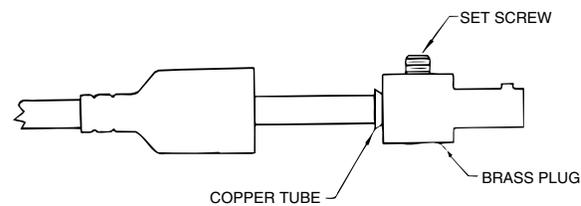
QUICK DISCONNECT PLUGS

A quick disconnect system is used for the welding cable connections. The K852-70 is designed to accept a welding cable size of 1/0 to 2/0.

1. Remove 25mm (1 in.) of welding cable insulation.
2. Slide rubber boot onto cable end. The boot end may be trimmed to match the cable diameter. Soap or other lubricant will help to slide the boot over the cable.



3. Slide the copper tube into the brass plug.
4. Insert cable into copper tube.



5. Tighten set screw to collapse copper tube. Screw must apply pressure against welding cable. The top of the set screw will be well below the surface of the brass plug after tightening.
6. Slide rubber boot over brass plug. The rubber boot must be positioned to completely cover all electrical surfaces after the plug is locked into the receptacle.

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.



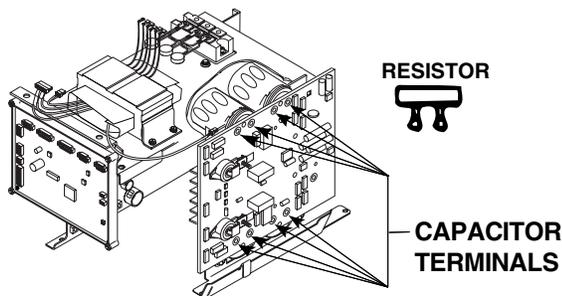
EXPLODING PARTS can cause injury.

- Failed parts can explode or cause other parts to explode when power is applied.
- Always wear a face shield and long sleeves when servicing.

See additional warning information throughout this Operator's Manual

CAPACITOR DISCHARGE PROCEDURE

1. Obtain a power resistor (25 ohms, 25 watts).
2. Hold resistor body with electrically insulated glove. **DO NOT TOUCH TERMINALS.** Connect the resistor terminals across the two studs in the position shown. Hold in each position for 1 second. Repeat for all four capacitors.



3. Use a DC voltmeter to check that voltage is not present across the terminals on all four capacitors.

VISUAL INSPECTION

Clean interior of machine with a low pressure air stream. Make a thorough inspection of all components. Look for signs of overheating, broken leads or other obvious problems. Many problems can be uncovered with a good visual inspection.

ROUTINE MAINTENANCE

1. Every 6 months or so the machine should be cleaned with a low pressure airstream. Keeping the machine clean will result in cooler operation and higher reliability. Be sure to clean these areas:
 - All printed circuit boards
 - Power switch
 - Main transformer
 - Input rectifier
 - Auxiliary Transformer
 - Reconnect Switch Area
 - Fan (Blow air through the rear louvers)
2. Examine the sheet metal case for dents or breakage. Repair the case as required. Keep the case in good condition to insure that high voltage parts are protected and correct spacings are maintained. All external sheet metal screws must be in place to insure case strength and electrical ground continuity.

PERIODIC MAINTENANCE

Overload Protection

The machine is electrically protected from producing high output currents. Should the output current exceed 430A, an electronic protection circuit will reduce the current to approximately 100A. The machine will continue to produce this low current until the protection circuit is reset. Reset occurs when the output load is removed.

Thermal Protection

Thermostats protect the machine from excessive operating temperatures. Excessive temperatures may be caused by a lack of cooling air or operating the machine beyond the duty cycle and output rating. If excessive operating temperature should occur, the thermostat will prevent output voltage or current. The meter will remain energized during this time.

Thermostats are self-resetting once the machine cools sufficiently. If the thermostat shutdown was caused by excessive output or duty cycle and the fan is operating normally, the Power Switch may be left on and the reset should occur within a 15 minute period.

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.

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.

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 AREAS OF MISADJUSTMENT(S)	RECOMMENDED COURSE OF ACTION
Major physical or electrical damage is evident when the sheet metal covers are removed.	1. Contact your local authorized Lincoln Electric Field Service facility for technical assistance.	1.If all recommended possible areas of misadjustment have been checked and the problem persists, Contact your local Lincoln Authorized Field Service Facility.
Input fuses keep blowing, or input breaker keeps tripping	<ol style="list-style-type: none"> 1. Make certain that the fuses or breakers are properly sized. See installation section of the manual for recommended fuse and breaker sizes. 2. Welding procedure is drawing too much output current, or duty cycle is too high. Reduce output current, duty cycle or both. 3. There is internal damage to the power source. Contact an authorized Lincoln Electric Service facility. 	
Machine will not power up (No lights)	<ol style="list-style-type: none"> 1. Make certain that the power switch is in the "ON" position. 2. The circuit breaker in the reconnect area may have opened. Reset. Check input voltage section below. 3. Input voltage selection made improperly. Power down, check input voltage reconnect according to diagram on reconnect cover. 4. The 6 amp breaker may have opened. Check for overload on 42VAC or 24VAC supply from the 14 pin MS-style connector. 	
Machine won't weld, can't get any output.	<ol style="list-style-type: none"> 1. If the displays show an Err ### see the fault section for corrective action. 2. If the displays are not lit refer to machine will not power up section. 3. If the thermal symbol is lit refer to the thermal section. 4. If the output terminals are in remote control switch to "ON" and check for output voltage. If output voltage is now present check for correct remote control connection and operation. 	

 **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.

EX350i



Observe all Safety Guidelines detailed throughout this manual

PROBLEMS (SYMPTOMS)	POSSIBLE AREAS OF MISADJUSTMENT(S)	RECOMMENDED COURSE OF ACTION
Thermal symbol is lit	<ol style="list-style-type: none"> 1. Check for proper fan operation. If fan is not operating correctly the CB 2 amp breaker may have opened. Check for an overload on the 115VAC. Blow air in rear louvers to remove dirt from around fan. 2. Check for material blocking intake or exhaust louvers. 3. Blow air in the rear louvers to clear dirt from the fan. 	<ol style="list-style-type: none"> 1. If all recommended possible areas of misadjustment have been checked and the problem persists, Contact your local Lincoln Authorized Field Service Facility.
Wire feeder won't work. Apparently no power to wire feeder	<ol style="list-style-type: none"> 1. Check circuit breakers by the wire feeder receptacles on the rear of the machine. Reset 2. Check the control cable between the power source and the wire feeder for continuity. 	

 **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.

EX350i



Observe all Safety Guidelines detailed throughout this manual

Fault Codes			
Code	Description		Corrective Action
31	Primary over current.	If condition persists contact an authorized Lincoln Field Service Shop	The machine needs to be turned off and back on to reset the machine.
32	CAP bank A under voltage.	Check input power reconnect to make sure the machine is connected for the input power being supplied.	Self-clearing as condition ceases.
33	CAP bank B under voltage.		
34	CAP bank A over voltage.		
35	CAP bank B over voltage.		
37	Soft start Failed.		
39	Glitch on the primary over current fault interrupt; possibly caused by noise or a signal level (misc. hardware fault #1)	Check the machine ground. If problem persists contact an authorized Lincoln Field Service Shop	Self-clearing as condition ceases.
43	CAP delta; CAP A and B are out of balance.	Check input power reconnect to make sure the machine is connected for the input power being supplied.	
44	Main CPU problem. The DSP has detected a problem with the CPU.	Check the machine ground.	
47	Possible erroneous electrical noise on Voltage/Frequency capacitor feed back circuit. (misc. hardware fault #2)	If problem persists contact an authorized Lincoln Field Service Shop	
48	The main contactor opened unexpectedly. (misc. hardware fault #3)	If condition persist contact an authorized Lincoln Field Service Shop	Self-clearing
"bad node' #####"	The selected weld mode does not exist in the weld table that is presently loaded in the machine.	If condition persists contact an authorized Lincoln Field Service Shop	Press the Mode Select button to select a different mode

⚠ 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.

EX350i



Observe all Safety Guidelines detailed throughout this manual

Displays	Description
Scrolling dash	Appears at power up while the machine is going through its self configuration
"Err" "####"	Fault code display. The first fault to occur will be displayed for three seconds. The display will cycle through fault codes for all faults that persist after the initial three-second period are displayed for 1 second each.
"----" "----"	Weld mode is changing
"----" "####"	A constant voltage weld mode is selected, machine output is off. The numeric value in the right display is the work point.
"####" "----"	A constant current weld mode is selected, machine output is off. The numeric value in the left display is either the work point or a work point limit, depending on the weld mode and remote configuration.
"####" "####"(on steady)	machine output is on. Left display is current, right display is voltage. If actively welding, the displays are arc current and arc voltage. If not actively welding, the display will show work point.
"####" "####" (blinking)	weld just finished – the average arc voltage and current will be blinked for 5 seconds following a weld. If the work point changes during this 5 second period, the display will revert to the above mode.

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.

EX350i



REMOTE CONTROL ADAPTERS

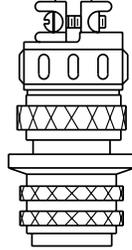
▲ WARNING:



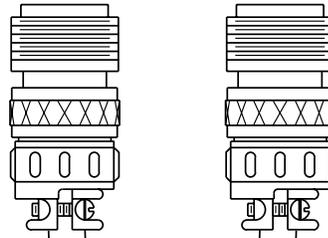
ELECTRIC SHOCK CAN KILL

TURN THE POWER SWITCH OF THE WELDING POWER SOURCE "OFF" BEFORE INSTALLING PLUGS ON CABLES OR WHEN CONNECTING OR DISCONNECTING PLUGS TO WELDING POWER SOURCE.

STRAIGHT PLUG (14 PIN)
TO POWER SOURCE



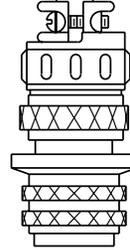
K864



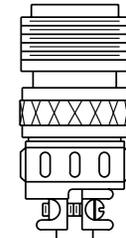
CABLE RECEPTACLE (6 SOCKET)

- TO: 1) K857 REMOTE CONTROL
- 2) K963 HAND AMPPTROL
- 3) K870 FOOT AMPPTROL

STRAIGHT PLUG (14 PIN)
TO POWER SOURCE



K876

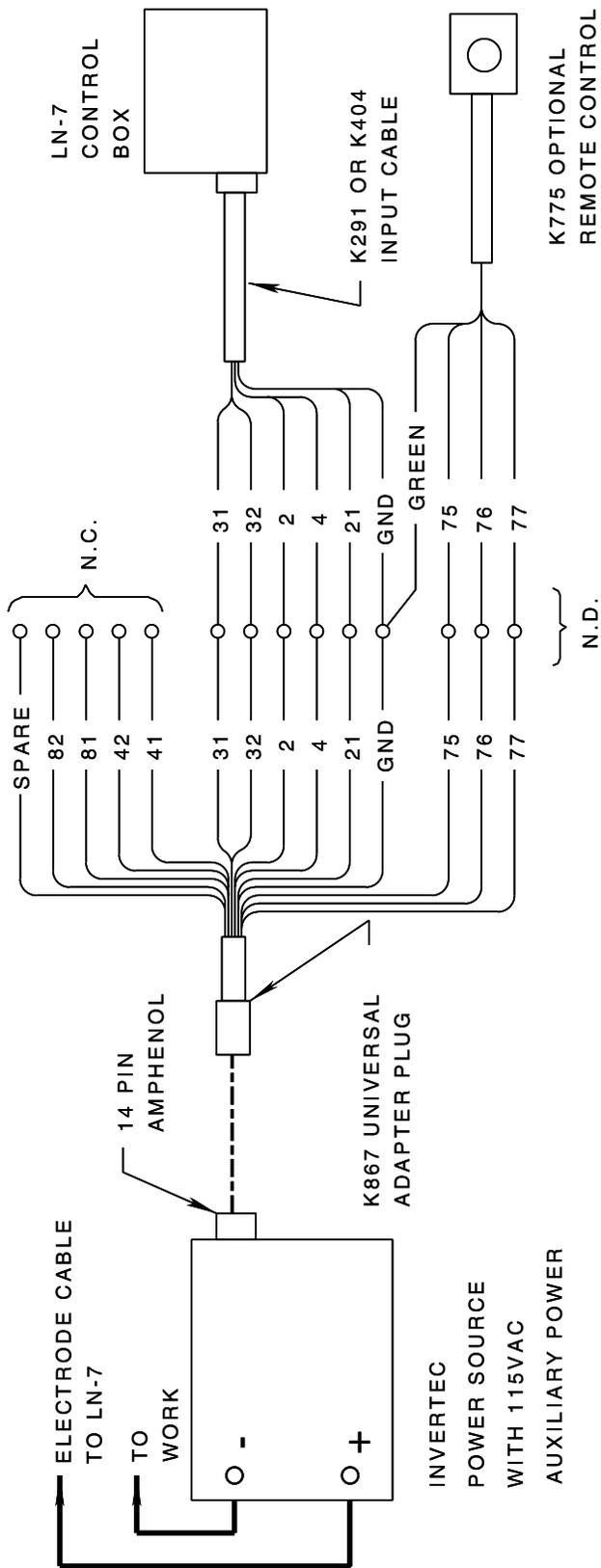


CABLE RECEPTACLE (6 SOCKET)

- TO: 1) LN-25 WIRE FEEDERS

K867 PLUG TO LN-7 - CONNECTION DIAGRAM

 <p>WARNING</p>	<ul style="list-style-type: none"> • Turn off input power to the Welding Power Source using the disconnect switch at the fuse box Before connecting the wire feeder. • Only qualified persons should install, use or service this machine.
<p>ELECTRIC SHOCK CAN KILL</p>	



N.A. WELDING CABLE MUST BE SIZED FOR CURRENT AND DUTY CYCLE OF APPLICATION.

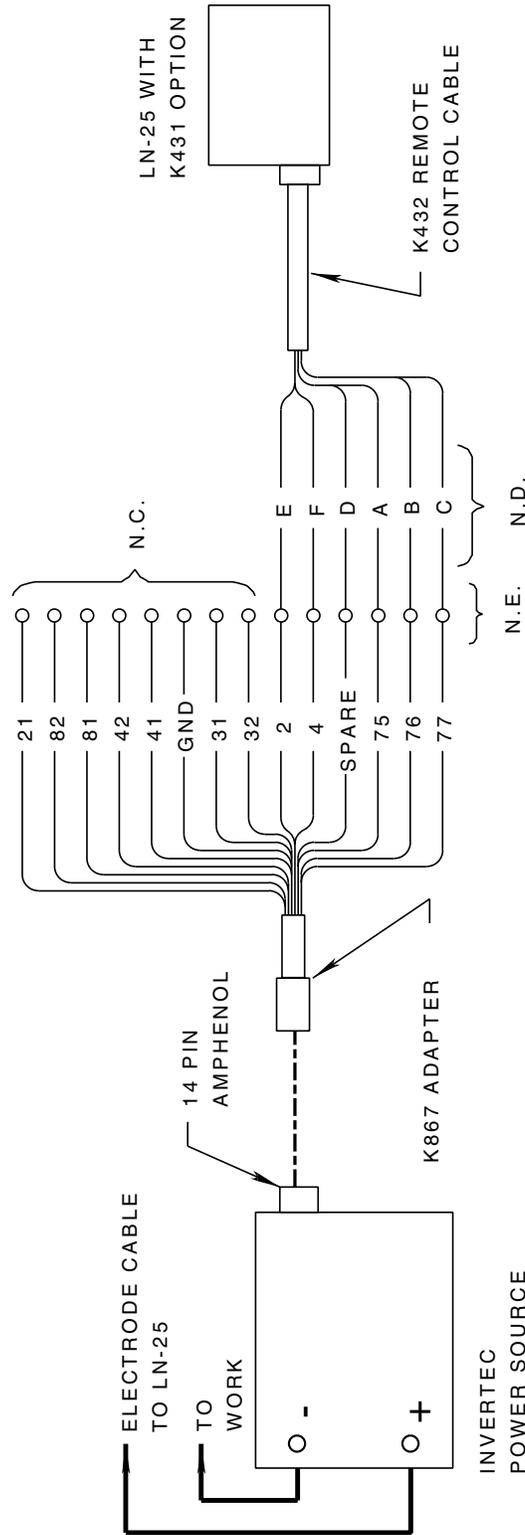
N.B. DIAGRAM SHOWS ELECTRODE POSITIVE. TO CHANGE POLARITY, TURN POWER "OFF", REVERSE ELECTRODE AND WORK CABLE AT POWER SOURCE.

N.C. INSULATE EACH UNUSED LEAD INDIVIDUALLY.

N.D. SPLICE LEADS AND INSULATE.

K867 PLUG TO LN-25 - CONNECTION DIAGRAM

 <p>WARNING</p>	<ul style="list-style-type: none"> • Turn off input power to the Welding Power Source using the disconnect switch at the fuse box Before connecting the wire feeder. • Only qualified persons should install, use or service this machine.
 <p>ELECTRIC SHOCK CAN KILL</p>	



N.A. WELDING CABLE MUST BE SIZED FOR CURRENT AND DUTY CYCLE OF APPLICATION.

N.B. DIAGRAM SHOWS ELECTRODE POSITIVE. TO CHANGE POLARITY, TURN POWER "OFF", REVERSE ELECTRODE AND WORK CABLE AT POWER SOURCE.

N.C. INSULATE EACH UNUSED LEAD INDIVIDUALLY.

N.D. REMOVE 6 PIN PLUG FROM K432 CABLE IN ORDER TO CONNECT K867 PLUG. LABEL EACH LEAD (A THRU F) AS THEY ARE REMOVED FROM 6 PIN PLUG.

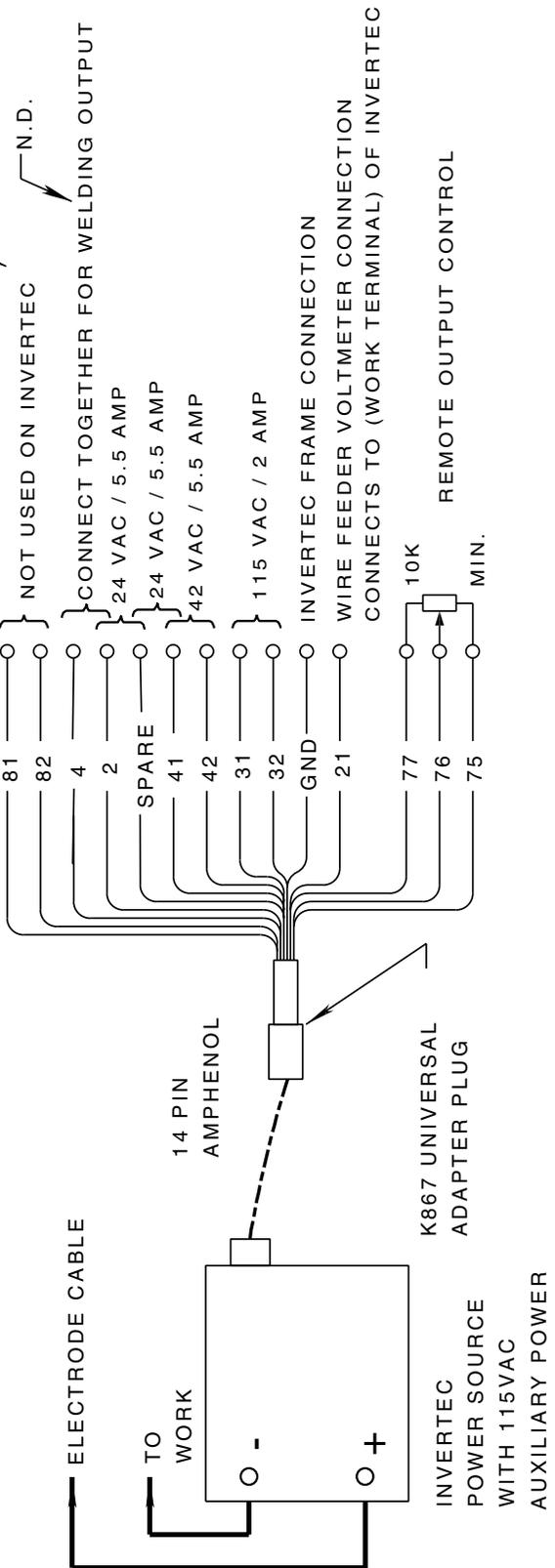
N.E. SPLICE LEADS AND INSULATE.

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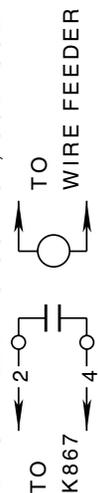
S19405

K867 UNIVERSAL ADAPTER / INVERTEC - CONNECTION DIAGRAM

 <p>WARNING ELECTRIC SHOCK CAN KILL</p>	<ul style="list-style-type: none"> • Turn off input power to the Welding Power Source using the disconnect switch at the fuse box Before connecting the wire feeder. • Only qualified persons should install, use or service this machine.
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- N.A. WELDING CABLE MUST BE SIZED FOR CURRENT AND DUTY CYCLE OF APPLICATION.
- N.B. DIAGRAM SHOWS ELECTRODE POSITIVE. TO CHANGE POLARITY, TURN POWER "OFF", REVERSE ELECTRODE AND WORK CABLE AT POWER SOURCE.
- N.C. INSULATE EACH UNUSED LEAD INDIVIDUALLY.
- N.D. FOR WIRE FEEDERS THAT RETURN A SIGNAL FOR WELDING OUTPUT, USE ISOLATION RELAY TO CLOSE LEADS 2 & 4.

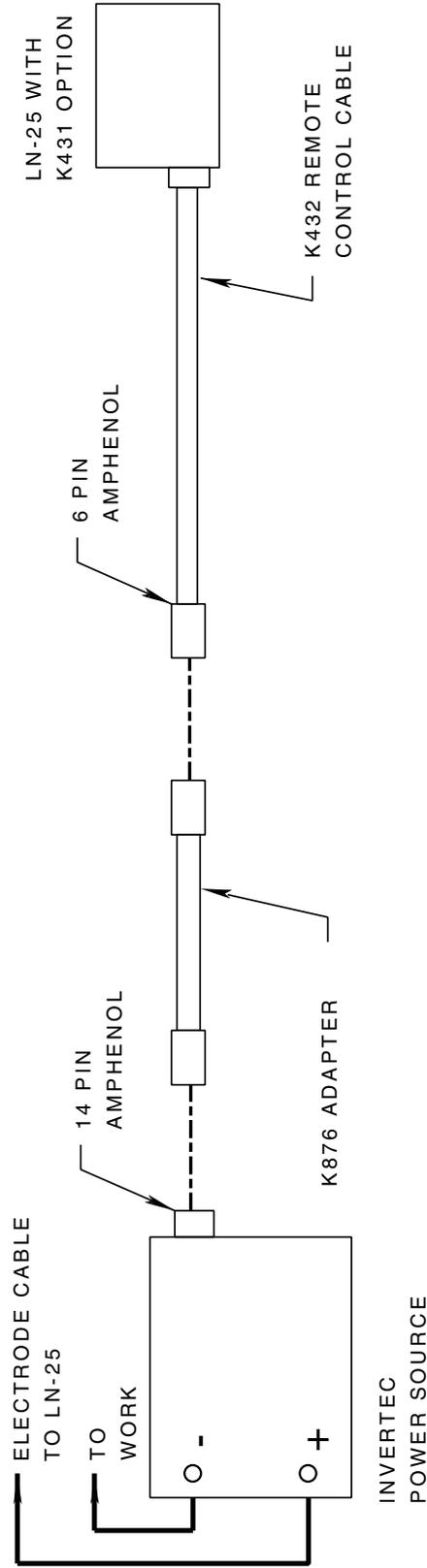


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K876 ADAPTER TO LN-25 - CONNECTION DIAGRAM

 <p>WARNING</p>	<ul style="list-style-type: none"> • Turn off input power to the Welding Power Source using the disconnect switch at the fuse box Before connecting the wire feeder. • Only qualified persons should install, use or service this machine.
<p>ELECTRIC SHOCK CAN KILL</p>	



N.A. WELDING CABLE MUST BE SIZED FOR CURRENT AND DUTY CYCLE OF APPLICATION.

N.B. DIAGRAM SHOWS ELECTRODE POSITIVE. TO CHANGE POLARITY, TURN POWER "OFF", REVERSE ELECTRODE AND WORK CABLE AT POWER SOURCE.

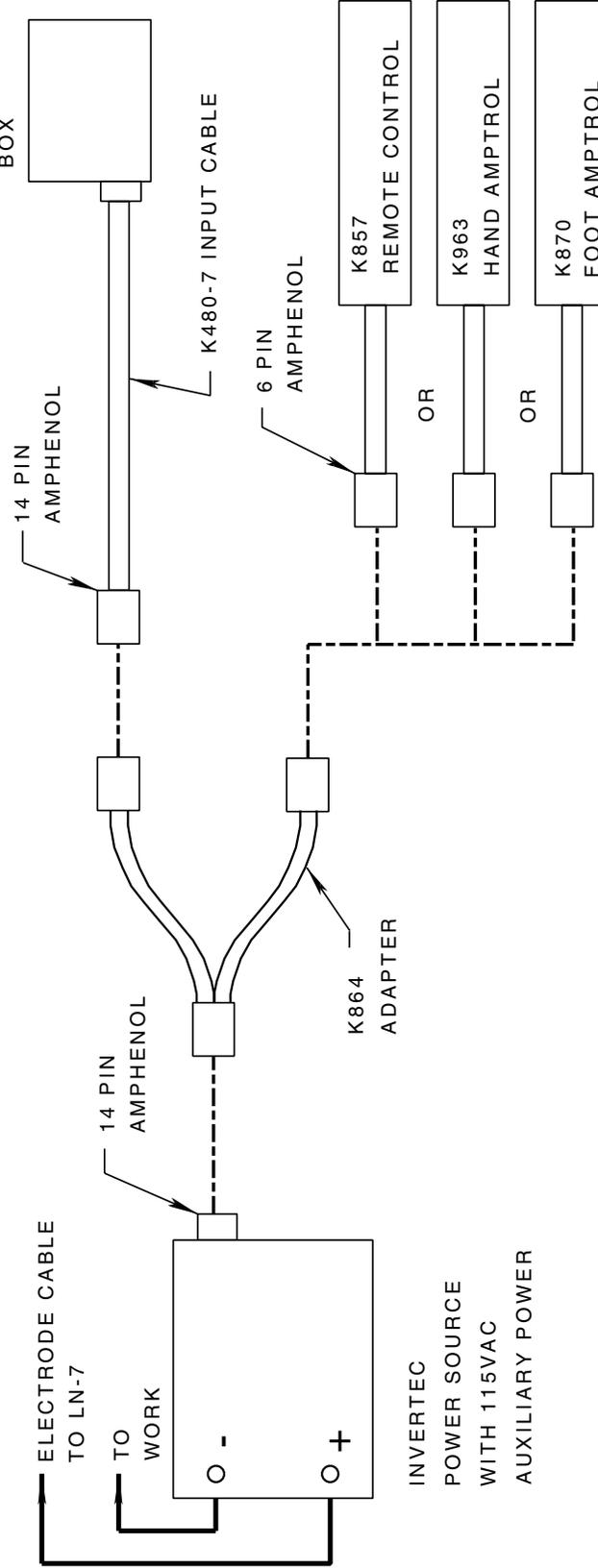
N.C. FOR INVERTECS WITH 6 PIN AMPHENOL, K432 CABLE CAN BE CONNECTED DIRECTLY.

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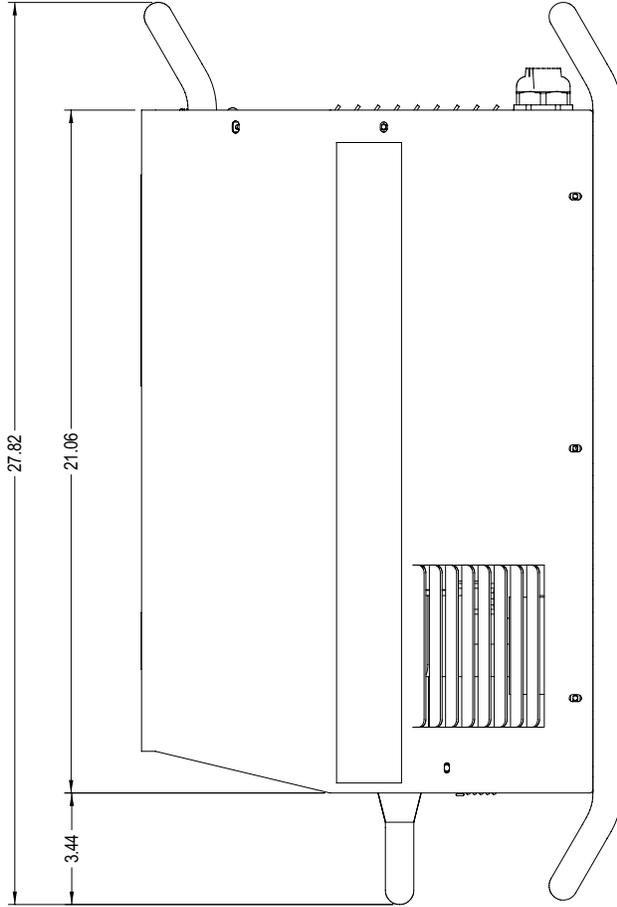
K864 ADAPTER TO LN-7 & REMOTE CONTROL - CONNECTION DIAGRAM

<p>WARNING</p>	<ul style="list-style-type: none"> • Turn off input power to the Welding Power Source using the disconnect switch at the fuse box Before connecting the wire feeder. • Only qualified persons should install, use or service this machine.
<p>ELECTRIC SHOCK CAN KILL</p>	



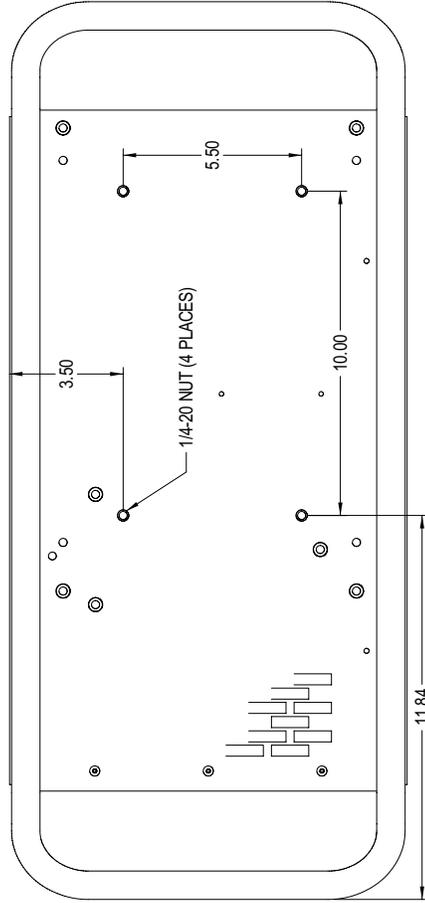
- N.A. WELDING CABLE MUST BE SIZED FOR CURRENT AND DUTY CYCLE OF APPLICATION.
- N.B. DIAGRAM SHOWS ELECTRODE POSITIVE. TO CHANGE POLARITY, TURN POWER "OFF", REVERSE ELECTRODE AND WORK CABLE AT POWER SOURCE.
- N.C. K480-7 INPUT CABLE CAN BE CONNECTED DIRECTLY IF REMOTE CONTROL IS NOT REQUIRED.
- N.D. K864 ADAPTER CANNOT BE USED WITH AN LN-25.

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S19901

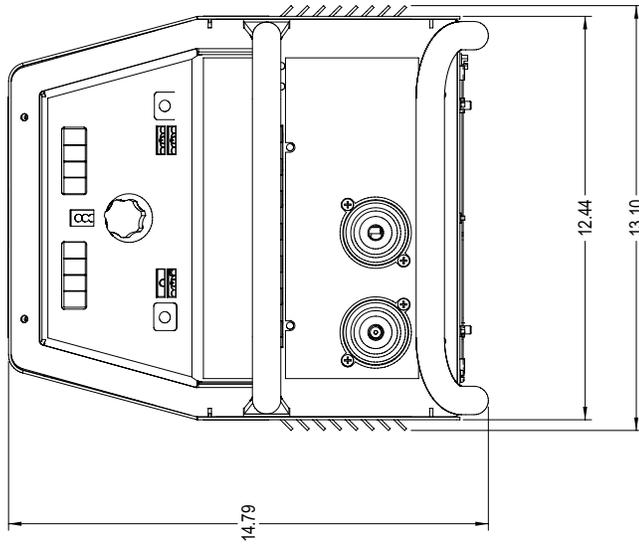


MOUNTING HOLE LOCATIONS

NOTE: MOUNTING SCREWS CANNOT PROTRUDE MORE THAN 0.5 INCHES INSIDE THE MACHINE.



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M19527



EX350i



NOTES

EX350I



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TOTAL COST				

WARNING	<ul style="list-style-type: none"> ● Do not touch electrically live parts or electrode with skin or wet clothing. ● Insulate yourself from work and ground. 	<ul style="list-style-type: none"> ● Keep flammable materials away. 	<ul style="list-style-type: none"> ● Wear eye, ear and body protection.
Spanish AVISO DE PRECAUCION	<ul style="list-style-type: none"> ● No toque las partes o los electrodos bajo carga con la piel o ropa mojada. ● Aíslese del trabajo y de la tierra. 	<ul style="list-style-type: none"> ● Mantenga el material combustible fuera del área de trabajo. 	<ul style="list-style-type: none"> ● Protéjase los ojos, los oídos y el cuerpo.
French ATTENTION	<ul style="list-style-type: none"> ● Ne laissez ni la peau ni des vêtements mouillés entrer en contact avec des pièces sous tension. ● Isolez-vous du travail et de la terre. 	<ul style="list-style-type: none"> ● Gardez à l'écart de tout matériel inflammable. 	<ul style="list-style-type: none"> ● Protégez vos yeux, vos oreilles et votre corps.
German WARNUNG	<ul style="list-style-type: none"> ● Berühren Sie keine stromführenden Teile oder Elektroden mit Ihrem Körper oder feuchter Kleidung! ● Isolieren Sie sich von den Elektroden und dem Erdboden! 	<ul style="list-style-type: none"> ● Entfernen Sie brennbares Material! 	<ul style="list-style-type: none"> ● Tragen Sie Augen-, Ohren- und Körperschutz!
Portuguese ATENÇÃO	<ul style="list-style-type: none"> ● Não toque partes elétricas e electrodos com a pele ou roupa molhada. ● Isole-se da peça e terra. 	<ul style="list-style-type: none"> ● Mantenha inflamáveis bem guardados. 	<ul style="list-style-type: none"> ● Use proteção para a vista, ouvido e corpo.
Japanese 注意事項	<ul style="list-style-type: none"> ● 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。 ● 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。 	<ul style="list-style-type: none"> ● 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。 	<ul style="list-style-type: none"> ● 目、耳及び身体に保護具をして下さい。
Chinese 警告	<ul style="list-style-type: none"> ● 皮膚或濕衣物切勿接觸帶電部件及鎢條。 ● 使你自已與地面和工件絕緣。 	<ul style="list-style-type: none"> ● 把一切易燃物品移離工作場所。 	<ul style="list-style-type: none"> ● 佩戴眼、耳及身體勞動保護用具。
Korean 위험	<ul style="list-style-type: none"> ● 전도체나 용접봉을 젖은 헝겍 또는 피부로 절대 접촉치 마십시오. ● 모재와 접지를 접촉치 마십시오. 	<ul style="list-style-type: none"> ● 인화성 물질을 접근시키지 마십시오. 	<ul style="list-style-type: none"> ● 눈, 귀와 몸에 보호장구를 착용하십시오.
Arabic تحذير	<ul style="list-style-type: none"> ● لا تلمس الاجزاء التي يسري فيها التيار الكهربائي أو الألكترود بجسد الجسم أو بالملابس المبللة بالماء. ● ضع عازلا على جسمك خلال العمل. 	<ul style="list-style-type: none"> ● ضع المواد القابلة للاشتعال في مكان بعيد. 	<ul style="list-style-type: none"> ● ضع أدوات وملابس واقية على عينيك وأذنيك وجسمك.

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

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，並請遵守貴方的有閣勞動保護規定。

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.



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