

HOW TO CHOOSE A WELDER

IMPORTANT! IDENTIFY YOUR INPUT VOLTAGE: DO YOU HAVE 120 VOLT OR 240 VOLT?

1	WHAT IS YOUR SKILL LEVEL?	LOW	MODERATE	HIGH	LOW	MODERATE	HIGH	LOW	MODERATE	HIGH	LOW	MODERATE	HIGH	MIG or FLUX CORED?		
2	WILL YOU NEED SHIELDING GAS?	NO-GAS REQUIRED			GAS REQUIRED <i>Indoor welding recommended</i>			NO-GAS REQUIRED			GAS REQUIRED <i>Indoor welding recommended</i>			USES CORED WIRE	MIG	FLUX CORED
3	WHAT TYPE OF MATERIAL WILL YOU BE WELDING?	STEEL STAINLESS STEEL			STEEL STAINLESS STEEL ALUMINUM <i>(Spool gun required)</i>			STEEL STAINLESS STEEL CASTINGS			STEEL, STAINLESS STEEL, CHROME MOLY → DC TIG REQUIRED ALUMINUM, MAGNESIUM ALLOYS → AC TIG REQUIRED			USES SOLID WIRE	✓	
4	WHAT IS YOUR MATERIAL THICKNESS?	18 Gauge to 5/16"			22 Gauge to 3/8"			10 Gauge to 1/2"			24 Gauge to 3/16"			USES SHIELDING GAS	✓	
5	TYPICAL APPLICATIONS	• Galvanized steel • General fabrication • Pipe and tubing • Maintenance & repair			• Sheet metal • Automotive body • Tubing • Structural steel			• Pipe and tubing • Structural steel • Pressure vessels • Maintenance & repair			• Stainless steel exhausts • Bicycle frames • Thin wall pipe & tubing • Metal art			CLEAN WELDS MINIMAL SPATTER	✓	
6	HOW CLEAN DO YOU NEED YOUR WELD?	MORE SPATTER			CLEAN / MINIMAL SPATTER			MORE SPATTER			EXTREMELY CLEAN			WELDS OVER MILL SCALE AND RUST		✓
USE THIS WELDING PROCESS		 FLUX-CORED / FCAW • Ideal for outdoor or windy conditions • Forgiving on rusty or dirty steels • Good out of position welding capabilities • High deposition rates achievable			 MIG / GMAW • Fast production (high welding speeds) • Easiest to learn • Clean welds with no slag • Better control on thin materials			 STICK / SMAW • Ideal for outdoor or windy conditions • Forgiving on rusty or dirty steels • Deep penetration • Good choice for thicker materials			 TIG / GTAW • Highest quality welds • Extremely aesthetic weld appearance • Can be used on a variety of materials • Precise control			The Duty Cycle is the number of minutes, within a 10 minute period, a welding process can produce the specified welding current without overheating.		
														DUTY CYCLE EXAMPLE		
														165A @ 30% Duty Cycle		
														3 Minutes Welding  7 Minutes Resting		