Power i-MIG 200 Quick Adjustment Guide*

*NOTE TO USER: This guide is offered only as a basic starting point for settings. Additional adjustments may be required up to 15%. Joint design, technique and welding position will affect settings. Start with clean metal. Joints over 3/16" should be beveled and welded with multiple passes whenever possible. Always fine tune the Arc Force setting last. For GMAW welding (MIG) use a 10 to 15° push angle on the gun. Use the following gas flow rates as a guide: Steel: 20-25 CFH; Stainless Steel; 25-30 CFH; Aluminum: 30-40 CFH. Add more gas flow in drafty conditions. Use light amounts of nozzle spray regularly. For Flux-Core use a 10 to 15° pull angle on the gun.

Wire Metal	Wire Diameter	Wire Class	Polarity	Shielding Gas	Arc Force	120V Input						240V Input			
						22ga 1/32" .8mm	20ga .9mm	18ga 1.2mm	16ga 1/16" 1.5mm	14ga 5/64" 1.9mm	12ga 7/64" 2.7mm	11ga 1/8" 3 mm	10ga 9/64" 3.4mm	7ga 3/16" 4.5mm	3ga 1/4" 6mm
STEEL	.023"/.6mm	ER70S-6	DCEP +	75/25 Ar/CO_2	3-6.5	130 IPM 15.5V	180 IPM 16.0V	260 IPM 16.5V	300 IPM 17.2V	380 IPM 17.5V	420 IPM 18.0V				
STEEL	.030"/.8mm	ER70S-6	DCEP +	75/25 Ar/CO_2	5-7.5	100 IPM 15.8V	140 IPM 16.2V	180 IPM 16.5V	240 IPM 17.2V	260 IPM 17.5V	290 IPM 18.0V	300 IPM 18.5V	320 IPM 18.7V	380 IPM 19.2V	420 IPM 20.0V
STEEL	.035"/.9mm	ER70S-6	DCEP +	75/25 Ar/CO_2	5-7.5	110 IPM 16.2V	160 IPM 16.5V	200 IPM 17.2V	230 IPM 17.5V	260 IPM 18.0V	270 IPM 18.5V	290 IPM 19.0V	320 IPM 19.5V	340 IPM 21.0V	
STAINLESS	.030"/.8mm	ER308L	DCEP +	Trimix w/He	7-9	340 IPM 19.0V	360 IPM 19.5V	400 IPM 20.0V	410 IPM 20.5V	420 IPM 21.0V					
STAINLESS	.035"/.9mm	ER308L	DCEP +	Trimix w/He	7-9	150 IPM 19.0V	200 IPM 20.0V	260 IPM 20.5V	320 IPM 21.0V	330IPM 21.5V	340 IPM 22.0V	360 IPM 23.0V	420 IPM 24.0V		
ALUMINUM	.035"/.9mm	4043	DCEP +	100% Argon	3-6.5	375 IPM 21.0V	390 IPM 21.5V	410 IPM 22.0V	420 IPM 22.0V	450 IPM 24.0V					
FLUXCORE	.035"/.9mm	E71T-11	DCEN -	No Gas	4-7	70 IPM 15.5V	130 IPM 16.0V	340 IPM 19.0V	280 IPM 20.0V	340 IPM 22.0V	360 IPM 22.0V	370 IPM 22.5.V			

For use with 100% CO_2, add 1 to 2 Volts to setting. For welds over 3/16" prep the joints by beveling and use multiple passes. By using proper technique and multi-pass welds, this unit can weld up to 3/8"with excellent results.

Use the optional PowerSpool SN200N Spool Gun for welding Aluminum or, as an alternative, use the main gun with an optional polymer liner and optional .035" U-groove drive roll.

For Flux-Cored (Gasless) operation, use optional knurled drive roll. Be sure to change polarity to Electrode Negative (-) by changing buss bar location and relocate work clamp to the Positive (+) lug.

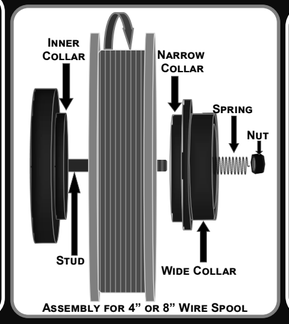
⚠ Stay safe. Weld safe. Always follow safe welding practices. Start by reading the manual. If you do not have a manual, download one from our website.

Stick Setup and Adjustment

NOTE: Some electrode manufacturer's Amperage suggestions may vary.

Important: This unit is not rated for E6010 use. Successful use with E6011 may be brand dependent.

Rod Class	Diameter	Input	Arc Force	Polarity	14ga 5/64" 1.9mm	12ga 7/64" 2.7mm	11ga 1/8" 3 mm	10ga 9/64" 3.4mm	7ga 3/16" 4.5mm	3ga 1/4" 6mm
E7018	3/32"	120/240V	1-3	DCEP +	55-70A	70-75A	70-80A	70-85A	75-90A	80-95A
E7018	1/8"	240V	1-4	DCEP +				85-90A	90-100A	90-125A
E7014	3/32"	120/240V	2-3	DCEP +	70-80A	80-85A	85 –90A	85-95A	90-110A	90-115A
E7014	1/8"	240V	2-4	DCEP +				95-100A	95-120A	100-130A



Assembly for 4" or 8" Wire Spool

Install the wire spool so that the wire threads into the drive from the bottom. The spool should rotate counter-clockwise. After installing the wire, tighten nut on spring until light resistance is felt. Don't overtighten. For 4" spools, the spool will sandwich between the two collars. The 8" spool sits and rotates on the collars.

Before feeding wire into the gun, release drive tensioner lever and check that the correct size drive roll is engaged with the wire. Raise lever and adjust feeder tensioner to approximately 3.5 to 4.5 on the scale.

Maximum recommended wire diameter for this unit is .035" due to gun liner limitations. The unit comes equipped with .023"-.030" drive roll for hard (solid wire) and .030" contact tip. Additional drive rolls (solid wire and flux), nozzles, and contact tips may be purchased direct from Everlast or locally for a series 15 MIG gun.

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⚠ If this unit is used with a generator, use with one rated for at least 9 Kw (surge) output and for clean-power (<5%THD) by the generator manufacturer. Using with generators that are not clean-power rated will damage the welder and void warranty.

Need help? Need accessories? Call us toll-free (U.S.) @ 1-877-755-9353. Download the manual, register your unit, get warranty info and order consumables/accessories by visiting www.everlastwelders.com.