

Power i-MIG 140E 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 15-20%. Joint design, technique and welding position will affect settings. Start with clean metal. 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 Hard wire, use a 10-15° "push" gun angle. For Flux-Core, use a 10 to 15 "pull" angle.

120V INPUT

					15A			20A			30A														
Wire Metal	Wire Diameter	Wire Class	Polarity	Shielding Gas	22ga .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												
STEEL	.023"/.6mm	ER70S-6	DCEP +	75/25 Ar/CO ₂	1.0	1.9	1.7	3.2	2.5	5.5	3.6	6.5	4.2	8.7	5.3	10.0	SPEED VOLTS								
STEEL	.030"/.8mm	ER70S-6	DCEP +	75/25 Ar/CO ₂	1.3	1.1	2.0	2.2	2.5	3.3	3.6	5.0	4.2	5.5	5.3	6.3	5.8	6.6	6.1	7.2	7.0	7.5	SPEED VOLTS		
STAINLESS	.035"/.9mm	ER308L	DCEP +	He/Ar/CO ₂																				SPEED VOLTS	
ALUMINUM	.030"/.8mm	4043	DCEP +	100% Argon																					SPEED VOLTS
ALUMINUM	.035"/.9mm	4043	DCEP +	100% Argon																					SPEED VOLTS
FLUXCORE	.035"/.9mm	E71T-11	DCEN -	No Gas																					SPEED VOLTS

Stainless welding can be used with a Trimix (He/Ar/CO₂ blend), or with 98/2 Ar/CO₂ for short circuit. However, the settings below are calculated based off a Trimix. Additional wire speed and volts are needed for Ar/CO₂.

Use the optional PowerSpool SM100N Spool Gun for welding Aluminum or, as an alternative, use the main gun with an optional polymer liner and optional .030" or .035" U-groove drive roll. Some settings are for short circuit mode only. Due to the maximum wire speed, .035" wire is recommended for axial spray, the best method for welding Aluminum, though capacity is limited with only 140A @ 21V. Use ER 4043 for best results.

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

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.

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

⚠ If this unit is used with a generator, select one rated for at least 5,000 Watts (surge) output and for clean-power (<5%THD) by the generator manufacturer. Use with generators that are not clean-power rated will damage the welder and void warranty.

Tripping of the breaker or blowing of fuses may occur if used at or near the maximum amp rating listed above. For best results, use a slow blow fuse, or a delayed trip breaker for minimizing fuse blows/breaker tripping. Do not use with undersized extension cords.

*Settings are a starting point only. Settings may vary 20% depending upon exact application, welding position, joint design etc. This means you will have to fine tune the settings and should not be relied upon as they are to deliver perfect results for every application.