

Power i-MIG 200E 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/240V INPUT

(First Number setting before the slash is for 120V use. Second setting after the slash mark is for 240V operation. NR = Not Recommended.)

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	SPEED VOLTS
STEEL	.023"/.6mm	ER70S-6	DCEP +	75/25 Ar/CO ₂	0.9/0.5	4.0/2.3	6.6/3.5	9.3/5.4	10.0/9.0	NR/9.8				
STEEL	.030"/.8mm	ER70S-6	DCEP +	75/25 Ar/CO ₂	1.0/0.6	2.3/1.3	3.8/2.1	6.0/3.4	7.5/5.4	9.4/5.8	NR/6.6	NR/7.5	NR/8.3	NR/9.0

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.

STAINLESS	.035"/.9mm	ER308L	DCEP +	He/Ar/CO ₂	9.0/4.7	4.0/2.3	7.5/4.5	NR/8.0	NR/8.8	NR/9.3	NR/9.8	NR/10.0	SPEED VOLTS
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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 .035" U-groove drive roll. Due to the maximum wire speed, .035" wire is recommended for axial spray, the best method for welding Aluminum. Use 240V input power and ER 4043 for best results. For greater thicknesses, use multiple passes, or preheat metal with an Oxy-Fuel torch.

ALUMINUM	.035"/.9mm	4043	DCEP +	100% Argon	NR/9.6	NR/7.6	NR/10.0	SPEED VOLTS
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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.

FLUXCORE	.035"/.9mm	E71T-11	DCEN -	No Gas	0.3/0.2	5.7/3.2	7.1/3.4	10.0/4.3	NR/5.3	SPEED VOLTS
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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.

NOTE: Operation with some wires sizes and types may require the purchase of additional drive rolls, consumables and gun liners. Please consult with www.everlastwelders.com for optional MIG parts, accessories and consumables. The standard size drive rolls are .6mm (.023-.025") and .8mm (.030") for hard (solid) wire operation. Limited operation with .9mm (.035") solid wire (for steel) is permissible, but not recommended as the upper limit of the Amp range of .035" wire exceeds the capability of this machine. Duty Cycle and Over-Current events may be experienced.

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 7,000 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 or long 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 to deliver perfect results for every application and position.