

# 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
STEEL	.023"/.6mm	ER70S-6	DCEP +	75/25 Ar/CO <sub>2</sub>	3-6.5
STEEL	.030"/.8mm	ER70S-6	DCEP +	75/25 Ar/CO <sub>2</sub>	5-7.5
STEEL	.035"/.9mm	ER70S-6	DCEP +	75/25 Ar/CO <sub>2</sub>	5-7.5
STAINLESS	.030"/.8mm	ER308L	DCEP +	Trimix w/He	7-9
STAINLESS	.035"/.9mm	ER308L	DCEP +	Trimix w/He	7-9
ALUMINUM	.035"/.9mm	4043	DCEP +	100% Argon	3-6.5
FLUXCORE	.035"/.9mm	E71T-11	DCEN -	No Gas	4-7

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" 3mm	10ga 9/64" 3.4mm	7ga 3/16" 4.5mm	3ga 1/4" 6mm											
130 IPM	180 IPM	260 IPM	300 IPM	380 IPM	420 IPM															
15.5V	16.0V	16.5V	17.2V	17.5V	18.0V															
100 IPM	140 IPM	180 IPM	240 IPM	260 IPM	290 IPM	300 IPM	320 IPM	380 IPM	420 IPM											
15.8V	16.2V	16.5V	17.2V	17.5V	18.0V	18.5V	18.7V	19.2V	20.0V											
110 IPM	160 IPM	200 IPM	230 IPM	260 IPM	270 IPM	290 IPM	320 IPM	340 IPM												
16.2V	16.5V	17.2V	17.5V	18.0V	18.5V	19.0V	19.5V	21.0V												
340 IPM	360 IPM	400 IPM	410 IPM	420 IPM																
19.0V	19.5V	20.0V	20.5V	21.0V																
150 IPM	200 IPM	260 IPM	320 IPM	330 IPM	340 IPM	360 IPM	420 IPM													
19.0V	20.0V	20.5V	21.0V	21.5V	22.0V	23.0V	24.0V													
375 IPM	390 IPM	410 IPM	420 IPM	450 IPM																
21.0V	21.5V	22.0V	22.0V	24.0V																
70 IPM	130 IPM	340 IPM	280 IPM	340 IPM	360 IPM	370 IPM														
15.5V	16.0V	19.0V	20.0V	22.0V	22.0V	22.5V														

For use with 100% CO<sub>2</sub>, 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.

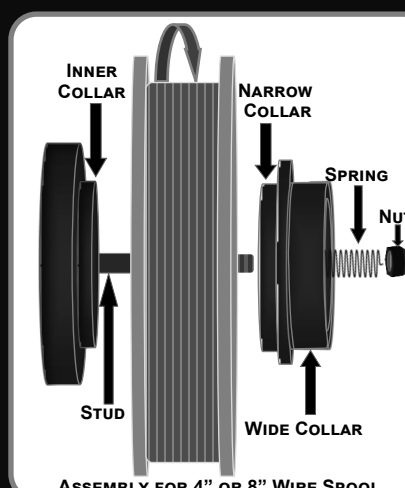
**!** Stay safe. Weld safe. Always follow safe welding practices. Start by reading the manual. If you do not have a manual, download one from our website.

### 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" 3mm	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



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.



**!** 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.