Forney®

WELDING IN AMERICA.
SINCE THE BEGINNING.

WARNING: To prevent serious injury, read manual warnings and instructions before use.

140 MP WELDER QUICK START GUIDE

1. Assemble top handle and bottom supports. *(Tools needed: screwdriver)*

2. Attach gas bottle and regulator hose assembly. *(Tools needed: adjustable wrench)*

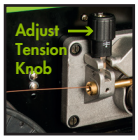
3. Use Process Selector Knob to select desired process.

MIG

1. Install wire spool.

2. Install MIG gun, turn it on, and squeeze trigger until wire comes out.

3. Adjust wire feed tension.



Verify polority is set correctly for MIG or Flux-core welding wire.

4. Adjust wire feed speed and voltage per chart on the inside of welder.

5. Verify drive rolls, liner and tips are properly sized for desired wire diameter.

STICK

1. Adjust polarity for the stick electrode.

(Usually DCEP - Electrode Positive).

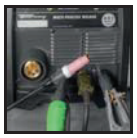
2. Disconnect MIG gun as it will be electrically "hot" while Stick welding.

3. Adjust amperage.

4. Adjust hot start if needed.

TIG

1. Attach TIG torch and Foot Pedal if desired.



2. Verify proper shielding gas is used for TIG welding.

(Most MIG shielding gases will not work)

3. Disconnect MIG gun as it will be electrically "hot" while Stick welding.

4. Adjust amperage.

* Torch & Foot Pedal sold seperately

WARNING: To prevent fire and serious injury: Keep torch and wire clear of grounded objects while welder is plugged in. Be sure to follow safe welding proceedures and wear proper PPE (clothes, welding helmet, safety glasses, welding gloves, boots, etc.)

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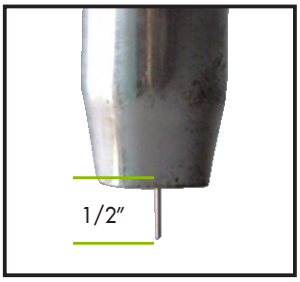
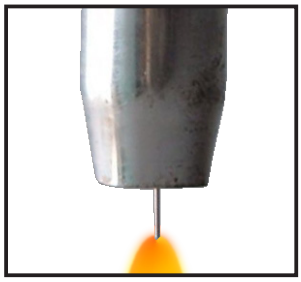
MIG WELDING TIPS

OPTIMAL STICKOUT



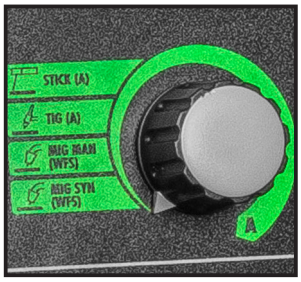
- Stickout 1/2″ +/- 1/8″
- Short stickout = more current and more penetration

VOLTAGE



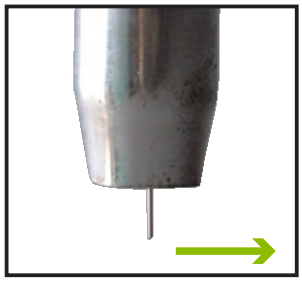
- Affects the arc shape
- Less voltage = tighter arc and potentially more spatter

WIRE FEED SPEED (WFS)



- Higher wire feed speed equals more amperage
- Can also affect arc shape and penetration

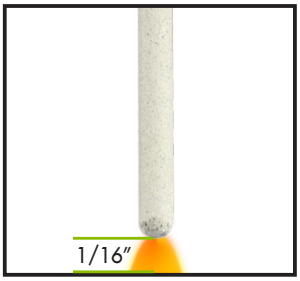
TRAVEL SPEED



- Affects bead width and height
- Can also affect penetration

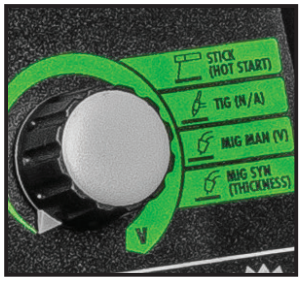
STICK WELDING TIPS

OPTIMAL STICKOUT



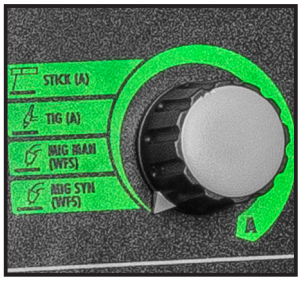
- Optimal stickout varies by electrode type and diameter but is usually approximately 1/16″

HOT START



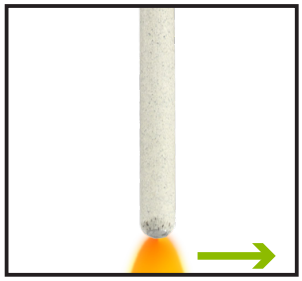
- Provides higher amperage at arc start to prevent electrode sticking

AMPERAGE



- Affects penetration and bead width
- Can also affect spatter, electode starting and ability to weld vertical or overhead

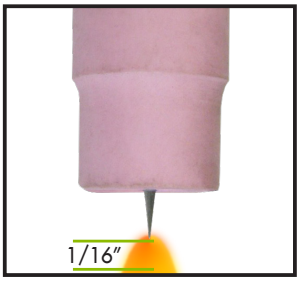
TRAVEL SPEED



- Affects bead width and height
- Can also affect penetration

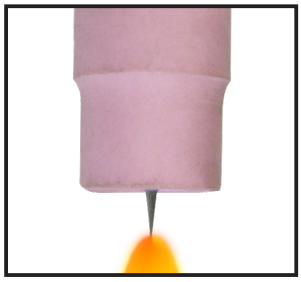
TIG WELDING TIPS

OPTIMAL STICKOUT



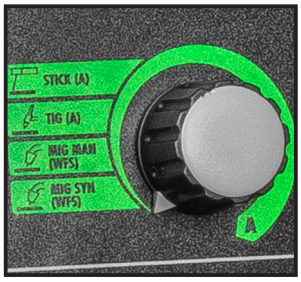
- Optimal stickout varies by electrode type and diameter but is usually approximately 1/16″

ARC START



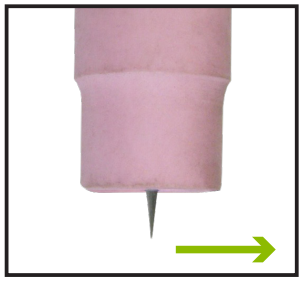
- A scratch or lift Start is often used to initiate the arc
- Try to minimize electrode and tungsten contamination

AMPERAGE



- Affects penetration and bead width
- Amperage is often referred to as “heat” in TIG Welding

TRAVEL SPEED



- Affects bead width and height
- Can also affect penetration