



Operator's Manual Model 175WFG Wire Feed Welder



MIG Welders

WARNING: Do not assemble, install, or operate this equipment without reading ALL of this manual and the safety precautions and warnings illustrated in this manual.

KDAR Company
15009 Manchester Road #283
Ballwin, MO 63011

Tel: 314-692-8555
Fax: 314-692-8578
Web Site: www.hotmaxtorches.com

SAFETY PRECAUTIONS AND WARNINGS
PLEASE READ BEFORE USING EQUIPMENT



WARNING

- Keep children away from this equipment
- Protect yourself and others from possible injury
- Pacemaker wearers should consult with their doctor before operating
- Read and follow all instructions in this manual before operating
- All installation, operation, and maintenance procedures are to be performed only by qualified individuals



ELECTRIC SHOCK CAN KILL.

- The input circuits are live and hot when the power is on
- Do not touch live electrical parts
- Wear dry, hole free insulated work gloves and body protection when operating
- Do not touch torch components if in contact with the work piece or ground
- Always turn off power before cleaning, checking, or changing parts
- Properly ground this piece of equipment per state and federal requirements
- Inspect and replace any worn or damaged torch cables or leads
- Keep all panels and covers securely in place
- Keep away from the torch tip and weld arc when trigger is pressed
- Ground the metal or work piece to the ground cable (Earth Clamp)
- Never dip the tip into water to cool or attempt to use welder in or under water
- This DC equipment holds a lot of power in the off position, before touching, make sure voltage is near zero on input capacitors before touching any parts.



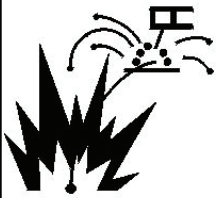
ARC RAYS CAN BURN SKIN AND EYES

- Arc rays when welding produce intense ultraviolet and infrared rays that can burn skin and eyes
- Wear face protection, either helmet or shield, when operating. ANSI Z49.1 approved shade #9 recommended for all cutting currents less than 300 amperes. The lens should conform to ANSI Z87.1 standards for testing.
- Wear approved safety glasses with side shields under the face protection
- Warn others not to stare at the arc as it can cause damage to the eyes. Provide barriers to protect other workers in the area from the arc while operating
- Wear flame resistant gloves, clothing, and shoes when operating



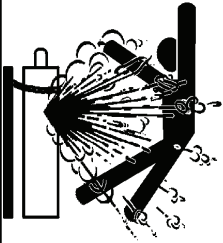
FUMES AND GASES CAN BE HAZARDOUS

- Arc welding produces fumes and gases and breathing these gases is hazardous to your health
- Keep your head out of the fumes and do not breath the fumes while welding
- Work only in a confined area if it has sufficient ventilation, or while wearing an air supplied respirator. Fumes from welding deplete the oxygen supply and can be harmful. Always be sure there is ample breathing air
- Read the MSDS sheets and the instructions from manufacturers for metals to be welded, coatings, and cleaners
- Do not use the welder near hydrocarbon vapors coming from degreasing, cleaning, or spraying operations. The heat and rays can react with solvent vapors to create the gas phosgene, a very toxic gas and other irritating gases
- Do not weld coated metals, such as galvanized, lead, or cadmium plated steel. Before welding, all plating must be removed. The area must be well ventilated or an air supplied hood must be used. The coatings and chemicals when burned cause highly irritating and toxic fumes.
- Do not weld containers with toxic, flammable, or reactive elements stored in them. They must be emptied and properly prepared before welding.



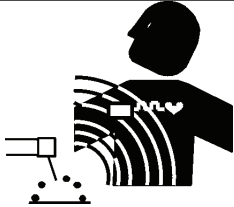
WELDING SPARKS CAN CAUSE INJURY, FIRE, OR EXPLOSION

- Remove all flammable materials from the welding area
- Always have a charged fire extinguisher available in the welding area
- When not welding make sure the welding tip is not grounded, this causes a heat build up and possible fire
- Avoid welding near hydraulic lines, fuel lines, electrical cords, air hoses, or welding guns and cables
- Sparks and hot metal fly out from the work area when welding, wear approved safety glasses with side shields under approved helmets, wear proper body and hand protection, and wear flame resistant ear plugs to keep sparks from entering the ears



CYLINDERS CAN EXPLODE IF DAMAGED

- Gas cylinders contain gas under very high pressure. If damaged they can result in that cylinder exploding. Gas cylinders are a major part of metalworking and must be treated with care.
- Protect gas cylinders from excessive heat, mechanical shocks, slag, open flames, sparks, and arcs
- Always keep cylinders in an upright position securely fastened to a fixed support
- Valve protection caps should always be in place and hand tight except when the cylinder is in use
- Keep all cylinders away from any welding or electrical circuits
- Never allow the arc from a welder to contact a cylinder
- Never cut any type of pressurized cylinder, an explosion could result
- Always turn your face away from the valve when opening the cylinder
- Read and follow all instructions on compressed gas cylinders, associated equipment, and CGA publication P-1 listed in the Safety Standards before using



ELECTRIC AND MAGNETIC FIELDS MAY BE DANGEROUS

- Electric current used in arc welding can create Electro-Magnetic Fields (EMF)
- Magnetic fields can affect pacemakers and wearers should avoid proximity to EMF. Wearers need to contact their doctors before operating this type of equipment
- Exposure to EMF during operation of this equipment may have other health effects which are not yet known
- Route the work and torch cables together and not around your body
- Do not place your body between the torch cable and the ground cable. They both need to be on the same side of your body when operating
- Do not work next to the welding machine



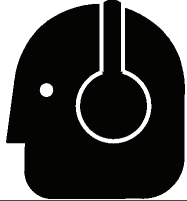
ELECTRICALLY POWERED EQUIPMENT

- Disconnect power source or turn off circuit breaker at the power panel before working on any equipment
- Only install equipment using the US National Electrical Code, all local codes, and the manufacturer's recommendations



HOT PARTS CAN CAUSE SERIOUS BURNS

- Do not touch hot parts without wearing protection.
- Allow the torch to cool sufficiently before working with parts that could potentially be hot.



NOISE CAN DAMAGE HEARING

- Prolonged noise exposure from welding equipment can cause damage if levels of noise exceed the OSHA standards
- Wear approved hearing protectors
- Warn other workers nearby of the high noise level and hazard

CALIFORNIA PROPOSITION 65 WARNINGS

- Welding or cutting equipment produces fumes or gases which contain chemicals known to the State of California to cause birth defects, and in some cases, cancer. (California Health and Safety Code Section 25249.5 et seq.)

PRINCIPAL SAFETY STANDARDS

AMERICAN WELDING SOCIETY

- AWS C5.2, Recommended Practices for Plasma Arc Cutting
- AWS F4.1, Recommended Safe Practices for the Preparation for Welding and Cutting

OSHA STANDARDS

- OSHA 29 CFR 1910, Safety and Health Standards

NATIONAL FIRE PROTECTION ASSOCIATION

- NFPA Standard 70, National Electric Code
- NFPA Standard 51B, Cutting and Welding Processes

AMERICAN NATIONAL STANDARDS INSTITUTE

- ANSI Standard Z87.1, Safe Practices for Occupation and Educational Eye and Face Protection
- ANSI Standard Z49.1, Safety in Welding and Cutting

Specifications

Rated input	230VAC, 60 hertz, 22 amps
Maximum output open-circuit voltage	35 volts DC
Rated output	130 AMPS@20volts 20%duty cycle
Wire feed rate	59 to 472 in/min (1.5-12m/min)
Specifications of applicable welding wire	.025”-.030” (0.6-0.8mm) solid steel .030”-.035” (0.8-0.9mm) Flux-Cored
Welding Wire Spool	8”x2” (200mmx50mm) 4”x2” (100mmx50mm)
Weight	54 lb (26 kg)
Dimensions (Length*Width*Height)	16”x9.6”x14.5” (408x244x367)

Table 1

Features & Benefits

- Light weight, small size all steel case.
- Easy to use.
- MIG/MAG ready, regulator and 5’ hose included.
- Optional spool gun available.
- Infinite output voltage level.
- Infinite wire feed speed control.
- Wire at gun is “cold” when not welding.
- Power on indicator light and overload indicator light equipped.
- Fan cooled.
- 20% duty cycle minimum.
- Welds 22 gauge to 3/8” with flux cored wire.
- Built in wire feeder with easy to use tension adjustment lever.
- Dual size groove drive roller to fit sizes .23” to .35” wire (.6 to .9 mm).
- Easy polarity change for switching to and from gas.
- Flux covered (FCAW) set up from the factory, ready to weld.
- Welds steel, aluminum, and stainless (special gas required for aluminum and stainless).
- 2 year limited warranty on the machine.
- 90 day limited warranty on gun and hose.
- Comes with the following components.
 - 2 replacement tips
 - Hand held welding shield
 - Hex wrench to change wire feed roller.
 - Gas nozzle for MIG welding.
 - 10# spool adaptor.
 - Gas regulator
 - 5’ gas hose
 - 2# Spool .030” Flux Core Wire

Installation/Setup

Safety Considerations

⚠ Warning



Electric Shock Can Kill

- Only qualified personnel should attempt to install this equipment.
- Turn off the input power at the power panel or disconnect switch and discharge capacitors before working inside the equipment.
- Take care not to touch electrically hot parts
- Make sure the unit is switched off before plugging it into a the power outlet.

Package Contents

Mig Welder Contents

<p>Welder Assembly</p> 	<p>Gun & Cable Assembly</p> 	<p>Ground Clamp & Cable Assembly</p> 	<p>Gas Regulator</p> 
<p>Gas Hose</p> 	<p>Face Shield</p> 	<p>Spool Adaptor</p> 	<p>Gas Shield</p> 
<p>Mig Tips</p> 	<p>Allen Wrench</p> 	<p>Manual</p> 	

Not pictured is 2# Spool .030" Flux Core

Installation/Setup

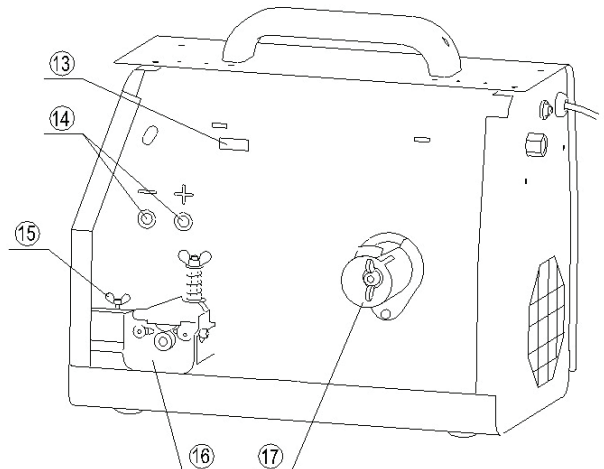
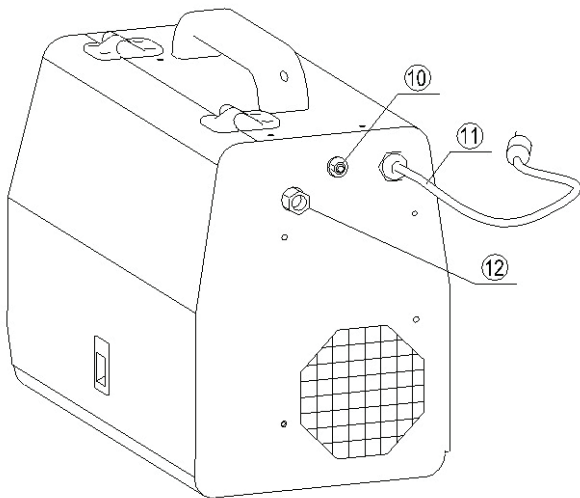
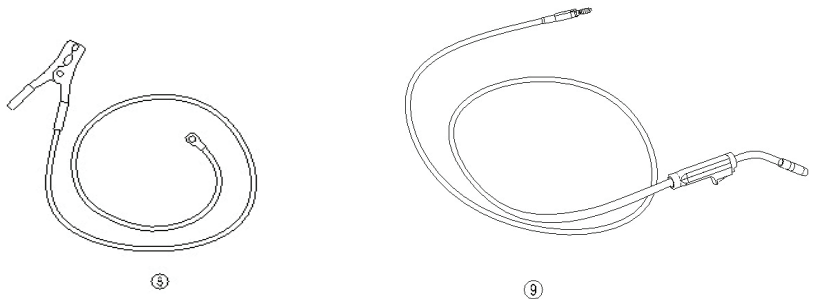
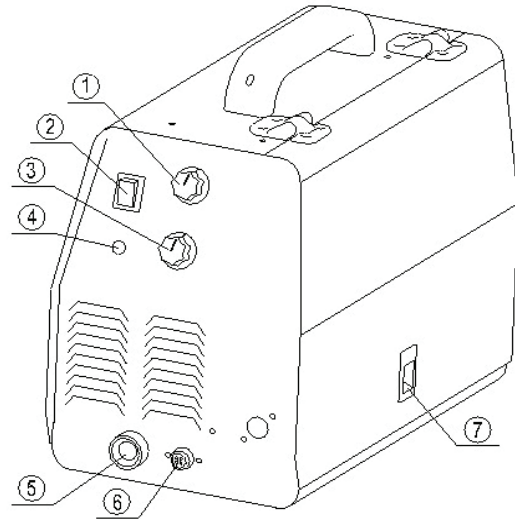
Selecting A Location

The 175WFG welder should be placed where clean cool air can easily flow through the vents in the front of the unit. Dirt and dust can be drawn into the unit resulting in excessive operating temperatures and shutdowns, therefore, dirt and dust around the unit should be kept to a minimum.

The 175WFG welder should be placed on a stable, level surface suitable to hold the unit's weight.

Components and Controls

1. Output voltage adjust knob
2. Power switch
3. Wire feed rate adjust knob
4. Thermal overload indicator
5. Ground clamp connection port
6. Gun trigger lead connectors
7. Door latch
8. Ground (work) clamp and cable
9. Welding gun and cable assembly
10. Overload reset button - the protector will cut off the circuit if the welding machine is in excess of the maximum load, after which the switch must be manually reset.
11. Power Cord
12. Shielding gas inlet fitting
13. Spool gun selection switch
14. Positive (+) and Negative (-) output terminals
15. Wing nut to secure welding gun
16. Wire feed gearbox
17. Wire spool spindle/shaft



Installation/Setup

Warning Always unplug the welder before connecting or disconnecting the Ground Clamp cable and/or the Gun Cable.

Ground Clamp & Lead Connection

- 1. Ground Cable Attachment:** The Hot Max MIG Welders use a convenient 1/4 turn connection for attaching the ground cable to the unit. Insert the male end of the ground cable into the female connection port (1) and turn 1/4 turn clockwise.
- 2. For FCAW (Flux Cored Arc Welding) Only:** The WFG series of welders are delivered set up for FCAW welding with negative electrode polarity. The cable coming out of the wing nut (6) on the connector block is attached to the negative (-) output terminal and the ground lead is connected to the positive (+) terminal.
- 3. GMAW (Gas Metal Arc Welding) Only:** To set up for GMAW welding with positive electrode polarity, connect the cable coming from the wing nut (6) on the connector block to the positive (+) output terminal and the ground lead to the negative (-) output terminal. Make sure all connections are tight.
- 4. Gun Selection:** Select standard gun or optional spool gun using the gun selector switch (4).

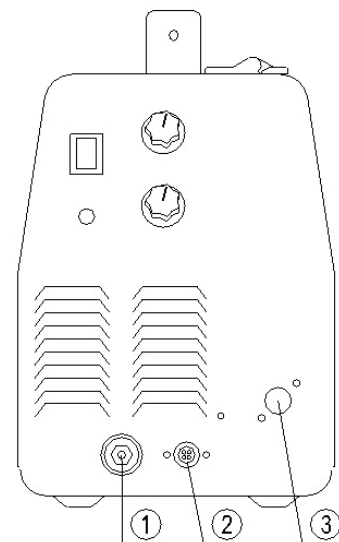


Figure C-1

Gun Installation

1. Insert the male connector on the gun cable into the gun cable connection port (3). With the connector all the way in the connector block tighten the wing nut (6) to secure the gun.
2. Connect the gun lead terminal to the gun lead connector (2).

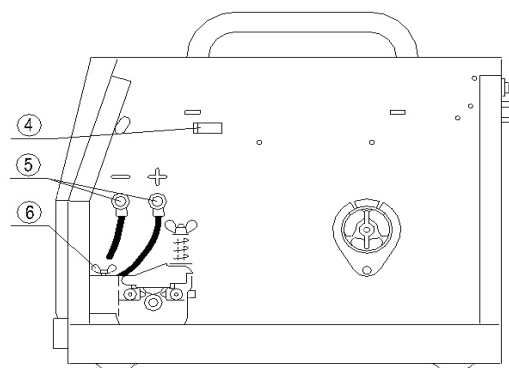


Figure C-2

Installation/Setup

Gas Connection

Warning



- Cylinder can explode if damaged. Keep cylinder chained upright to a secure support.
- Keep cylinder away from areas where it could be damaged.
- Never lift or move the welder with the cylinder attached.
- Do not let the welding electrode touch the cylinder.
- Keep the cylinder away from welding or other live circuits.

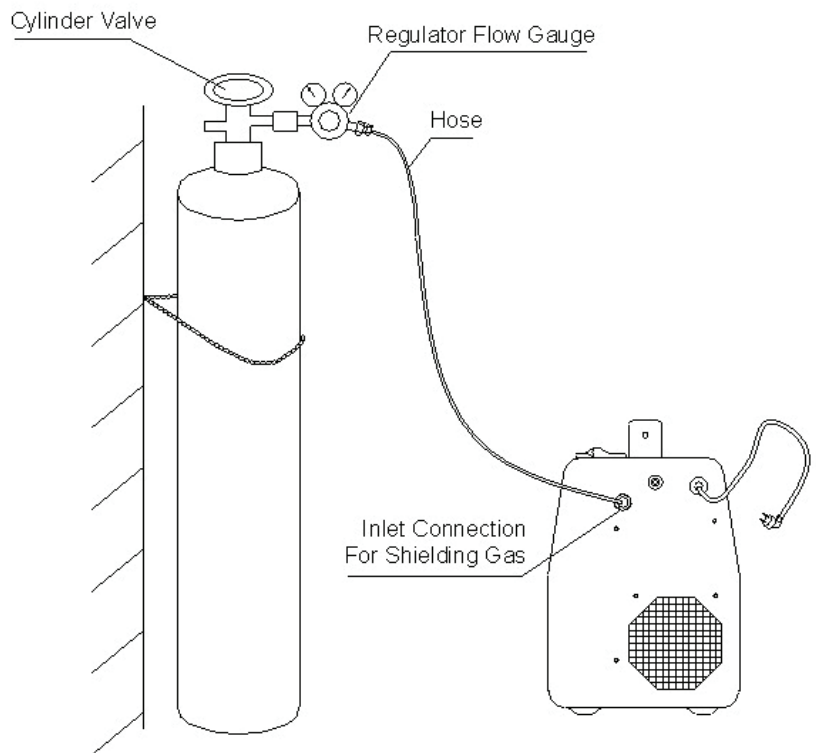


- Shielding Gas may be harmful to health or cause death.
- Turn off gas supply when not in use.
- Refer to American National Standard Z-49.1, "Safety in Welding and Cutting" from the American Welding Society for more information.

Gas Hook Up

When using the GMAW process, a cylinder of shielding gas must be used. Shielding gas cylinders and gas can be obtained at a local gas supply company or some farm supply stores. The recommended gases for the Hot Max WFG welders is either Welding grade CO₂ or a Argon/CO₂ blend with 75-80% Argon and 20-25% CO₂ (see Suggested Settings chart on the welder compartment door).

1. Insure the cylinder is properly secured to a wall or other stationary support to prevent it from falling over during setup or operation. Be sure the cylinder is insulated from the work circuit and ground.
2. Once the cylinder is properly secured, remove the cylinder cap. Standing to one side slowly open the cylinder valve for an instant to blow away any debris that may have accumulated in the valve outlet.
3. Attach the flow regulator to the cylinder valve and tighten with a wrench.
4. Attach one end of the gas hose to the output fitting of the regulator and tighten securely with a wrench.
5. Test to insure the flow regulator is closed by opening cylinder valve slightly. If the regulator is not closed turn the black knob counter clockwise until the flow of gas has stopped.
6. Connect the other end of the hose to the gas inlet fitting on the 175WFG welder making sure that the hose is not kinked or twisted.



Installation/Setup

Gas Hook Up (cont.)

7. Reopen the regulator valve until the flow indicator shows 15 L/min (initial flow setting). The setting may need to be adjusted by the operator to compensate for welding conditions.
8. Always close the cylinder valve and open the regulator valve when not in use.

Input Connections

The 175WFG welder has power input cables located on the rear of the unit. A plug for the cord is not included and must be purchased separately. Follow the directions provided with the plug for terminating the power cable located on the back of the machine. Make sure the plug you purchase is rated for 250 Volts and 50 Amps minimum.

Operation

Safety Considerations

Warning



Electric Shock Can Kill

- Do not touch live electrical parts of the electrode with skin or wet clothing.
 - Insulate yourself from work and ground.
 - Always wear insulated gloves and keep them dry.
-



Fumes & Gases Can Be Hazardous

- Plasma cutter should only be used in a well ventilated area or with an exhaust system.
 - Keep your head away from the fumes.
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Arc Rays Can Burn Skin and Eyes

- Always wear eye, ear and body protection.
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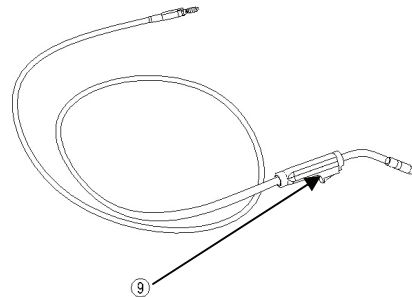
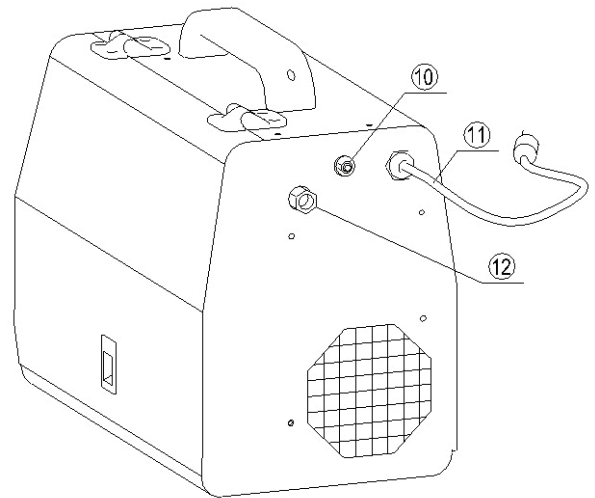
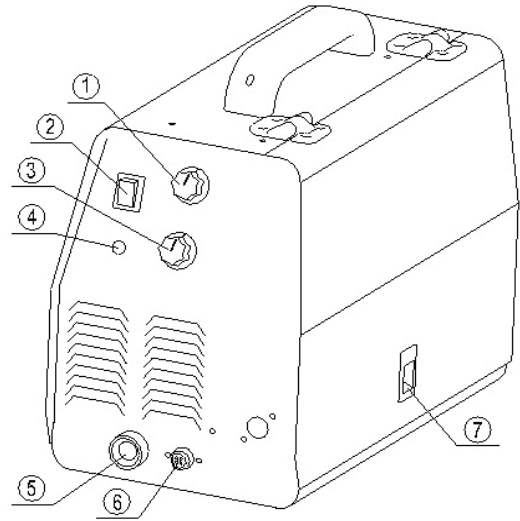
Cutting Sparks Can Cause Injury, Fire , or Explosion

- Do not use near flammable material.
 - Do not cut or gouge on containers that have held combustibles.
-

Operation

Controls

- 1. Output Voltage Control**—The Hot Max infinite setting output voltage control knob adjusts to any setting from 25 to 175 amps. Additionally, the voltage can be adjusted while welding.
- 2. Power On/Off Switch**—A light within the switch will be illuminated and the cooling fan will run when the power is on.
- 3. Speed Control**—Controls the wire feed speed. The control can be preset on the dial to the setting specified on the application chart located inside the wire feed section door.
- 4. Overload Indicator**—This LED comes on to indicate the duty cycle had been exceeded. Output will be shut off until the unit has cooled to an acceptable operating temperature. The fan will continue to run.
- 9. Gun Trigger**—Pressing the trigger activates the welding output, wire feed and gas operation. Releasing the trigger stops the welding output, wire feed and gas operation. Releasing the trigger also starts the burn back function to prevent the welding wire from sticking to the working weld.
- 10. Overload Breaker**—This breaker protects the unit from damage due to exceeding the maximum output. The breaker pops out when tripped and must be pushed in to be reset.



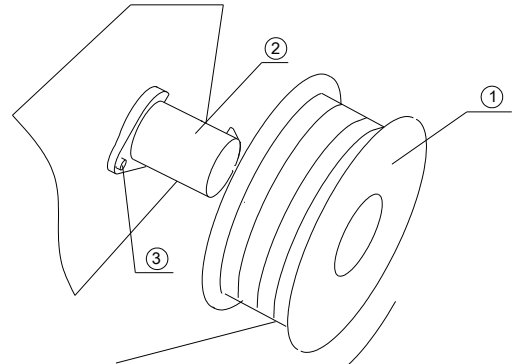
Operation

Loading Wire

Note: Always turn power off when working inside the welder enclosure.

8" Diameter Spool

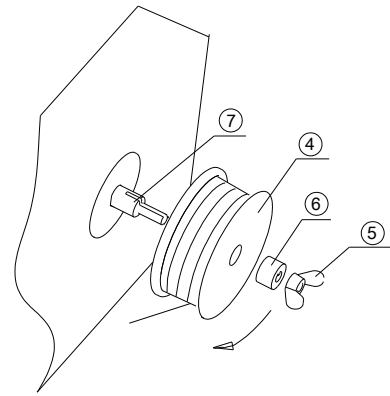
1. Remove the wing nut (5), and plastic tension spacer (6).
2. Place the spool adaptor (2) over the shaft as shown.
3. Replace spacer and wing nut. Make sure the wing nut is positioned so that it does not interfere with the locking tab.
4. Place spool on the spool adaptor making sure the hole in the spool engages the stud (3) on the spool adaptor and the spool slides completely over the locking tab.



Use the welding wire board with 8 "(200 mm) in diameter
Figure D-1

4" Diameter Spool

1. Remove wing nut (5) and the plastic tension spacer (6).
2. Place the spool (label out) on the shaft with the wire feeding from under the spool.
3. Replace the spacer, washer and wing nut



Use the welding wire board with 4 "(100 mm) in diameter
Figure D-2

Adjusting Friction Break

While turning the spool with one hand begin tightening the wing nut with the other. Once you start to feel tension; then turn the wing nut an additional 1/4 to 1/2 turn.

The intent is for the friction break to produce just enough friction to prevent the spool from continuing to turn after the drive motor has stopped.

Operation

Wire Feeding

1. Release the spring loaded tension arm (1) by flipping it to the right and down.
2. Lift the idle arm (2).
3. Make sure the groove size on the drive roll (5) is in the feeding position that matches the wire size being used. Refer to the Suggested Settings for Welding chart at the back of this manual or on the inside of the welder compartment door.
4. Detach the end of the wire from the spool and clip a small amount of wire to get a good straight start. **Note:** In order to prevent the spool from unwinding; it is important to keep tension on the wire until after the idle arm and tension arm are back in place.
5. Thread the wire through the inlet tube (4), over the drive roll (5) and into the outlet guide tube (6).
6. Close the idle arm (2).
7. Move the spring loaded tension arm (1) into position.
8. If required, rotate the wire spool counter clockwise to take up any slack in the wire.
9. If feeding problem occur because the wire is excessively flattened, turn the wing nut on the spring loaded tension arm (1) counter clockwise to reduce the pressure. If the drive roll (5) is slipping while feeding the wire; turn the wing nut clockwise to create more tension on the wire.

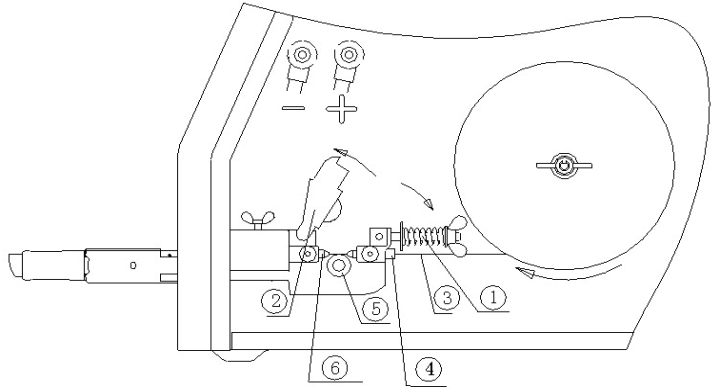


Figure D-3

10. Remove nozzle (7) and contact tip (8) from end of gun.
11. Turn on the Hot Max 175WFG.
12. With the gun cable assembly straight; press the trigger switch. The welding wire will feed through the cable and gun. Release the trigger when the wire has fed approximately 2 inches past the end of the gun.
13. Turn off the Hot Max 175WFG.
14. Replace the contact tip (8) and nozzle (7)
15. Cut wire off approximately 3/8" from the end of the contact tip. The Hot Max 175WFG is ready for welding.

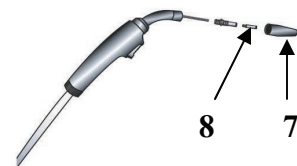


Figure 13

Warning

When feeding the wire, the drive roll, the connector block and gun contact tip are electrically charged relative to work and ground and remain charged for several seconds after the gun trigger is released.

Operation

Welding

1. See Suggested Settings at the back of this manual or on the inside of the wire feed compartment door for welding wire and shielding gas recommendations.
2. See Suggested Settings for information on setting the controls on the Hot Max WFG for specific welding wire and metal thickness.
3. Set the voltage and wire speed.
4. Insure the unit is set up for the correct polarity for the welding wire and process being used. The Hot Max WFG is shipped set up for FCAW (Flux Cored Arc Welding)
5. Insure the proper nozzle and tip are installed on the gun for the welding wire and process being used.
6. If required, turn on gas supply.
7. Connect the ground clamp to the metal being welded. The clamp must make a good connection.
8. Position the gun of the joint to be welded. The wire can touch the metal lightly.
9. Lower the welding helmet, pull the trigger on the gun and start welding. The contact tip should be about 3/8" from the work surface.
10. Release the trigger to stop welding and pull the gun away from the work after the arc has stopped.
11. If there is no more welding to be done, close the valve on the gas cylinder (if gas was used) and pull the trigger on the gun to release the gas pressure and then turn off the Hot Max WFG.

Changing the Welder for Feeding Different Wire Sizes

The Hot Max 175WFG is shipped ready to run .030" gasless flux cored wire. To run other sizes of wire the contact tip must be changed and the drive feed roll may need to be changed.

Changing the Contact Tip

1. To change the contact tip (1) you must first remove the nozzle (2). This is done by unscrewing it counter clockwise.
2. Unscrew the contact tip counter clockwise.
3. Screw in selected contact tip clockwise. Hand tighten only.
4. Replace nozzle by screwing on clockwise.

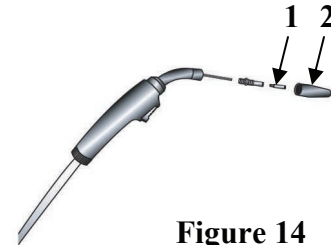


Figure 14

Operation

Changing Drive Roll

The drive roll has two groves; the smaller groove is for .023" - .025" welding wire and the larger groove is for .030" - .035" welding wire. The welder is shipped set up for the larger welding wire sizes.

To change the drive roll position:

1. Connect the unit to the appropriate power source.
2. Open the wire drive compartment door, release the spring loaded tension arm (1) by flipping it to the right and down and lift the idle arm (2).
3. Turn the power on.
4. Turn the feed control speed to the minimum setting and momentarily pull the trigger to turn the drive roll (4). Stop when the set screw (3) is facing up.

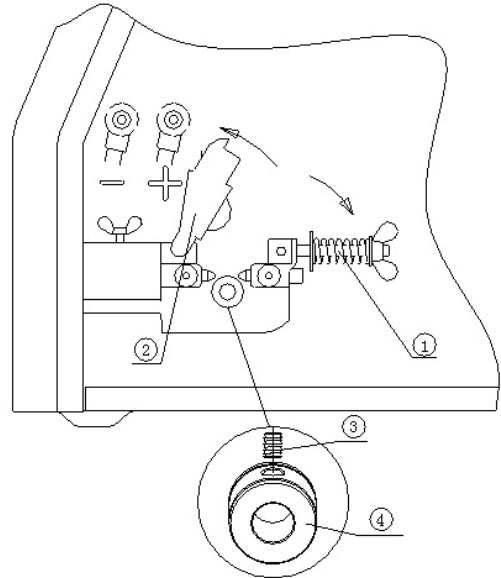


Figure C-4

Warning

When feeding the wire, the drive roll, the connector block and gun contact tip are electrically charged relative to work and ground and remain charged for several seconds after the gun trigger is released.

5. Turn the power off.
6. Loosen the drive roll set screw (3) with the hex wrench provided with the Hot Max 175WFG.
7. Remove the drive roll (4) turn it around and put it back on the shaft.
8. Cut and straighten about 5" of the desired wire and feed it through the wire inlet tube and into the outlet tube. Line up the drive roll groove with the welding wire and tighten with the hex wrench. Make sure the set screw is on the flat part of the shaft.

Aluminum & Stainless Steel Wire

The Hot Max 175WFG is capable of welding with both .035" aluminum and .030" stainless steel welding wire. See the table below for welder settings for these wires.

Process	Welding Wire	Shielding Gas	Voltage/Wire Speed			
			16 ga	14 ga	12 ga	10 ga
MIG DC+	.035 Dia 4043 Aluminum Wire	100% Argon	B-5.5	C-7	C-9	C-9
MIG DC+	.035 Dia 5356 Aluminum Wire	100% Argon	B-5.5	C-8	C-9	C-10
MIG DC+	.030 Dia 308L Stainless Steel Wire	98% Argon/ 2% Oxygen	A-3	C-7	C-7	C-7

Table 2

Maintenance

Warning



Electrical Shock Can Kill

Disconnect from the input power source prior to working inside the Hot Max WFG.

Allow only qualified personnel to do maintenance and trouble shooting.

General Maintenance

Power Supply Compartment

The Hot Max 175WFG does not have any serviceable parts inside the power supply compartment. **Do not** attempt to service parts in the power supply compartment. Contact KDAR Company for instructions if you have problems that can not be corrected by following the trouble shooting instructions.

If you are working in dusty areas, dirt may get into the air vents and cause the welder to run hot and trip the thermal overload protection. If this happens, blow the dirt out with low pressure air regularly.

Wire Feed Compartment

1. Occasionally dirt will accumulate in the wire feed compartment. When this happens, simply vacuum the dirt out of the compartment.
2. Each time the wire spool is changed, inspect the inside diameter of the wire feed inlet tube. If necessary, clean the inside of the tube.
3. The motor and gearbox needs no lubrication or maintenance.

Wire Spool Shaft

Requires no maintenance. **Do Not Lubricate.**

Gun Cable

1. To clean the cable liner, remove the gun cable assembly from the welder and lay it out straight on the floor.
2. Take the contact tip off of the gun. Blow low pressure air through the liner from the gun end of the liner.
3. Flex the cable over its entire length and blow air through again. Repeat flexing the cable and blowing air through until no dirt comes out.

Contact Tip & Nozzle

1. When dirt builds up in the contact tip hole, wire feeding can be restricted. To clean the tip, run the appropriate sized tip cleaner through the tip repeatedly. This should remove any dirt that has built up on the walls of the contact tip. KDAR Company tip cleaner number TC-1 is available for selected distributors or www.hotmaxtorches.com.
2. Remove splatter from the inside gas nozzle and the tip frequently.

Troubleshooting

Warning

Most components of the 175WFG welder are not serviceable by the operator and should only be serviced by a qualified repair technician. Unauthorized repairs to these units may result in danger to the operator and will void the factory warranty. For your safety, please follow all safety precautions found throughout this manual.

Problem

Nothing happens when the trigger is pulled; no wire feed, weld output or gas flow. Fan is not operating.

When trigger is pulled there is no wire feed, weld output or gas flow but the fan operates.

Little or no gas flow is evident when the trigger is pulled. Wire feed, weld output and fan operate as normal.

No wire feed when the trigger is pulled but the fan runs, gas flows and there is weld output.

Possible Cause

1. Check to insure the power switch is turned on.
 2. Insure correct voltage is applied to the welder and the plug is correctly wired.
 3. Check to insure the circuit breaker is not tripped.
-
1. The welder may have overheated and tripped the thermostat. Let the welder cool down and weld at a lower amperage setting.
 2. Check for obstructions in the air flow and to insure the gun cable assembly connections are correct.
 3. Gun trigger may not operate properly.
-
1. Check to insure the gas supply is adequate.
 2. Check the regulator and gas hoses to insure there are no problems.
 3. Check to insure there are no obstructions or leaky seals in the gun cable assembly connection.
-
1. Check to see if the wire drive motor is turning. If it is, make sure the drive roll is the correct size and is installed properly.
 2. Check to insure the cable liner and/or tip are not clogged and is sized correctly.
 3. Check to insure the Spool Gun Selection switch is set to the correct position.

Troubleshooting

Problem

Arc is unstable—Poor starting

Possible Cause

1. Check to insure proper input voltage to the welder. Check the plug to make sure the unit was wired correctly for 230V.
2. Check electrode polarity to make sure it is correct for the process being used.
3. Check tip for proper size and damage; replace if necessary.
4. Insure proper gas flow for the process.
5. Make sure the connections for the ground cable are correct.
6. Make sure the drive roll is installed and aligned properly.
7. Make sure the wire size is correct and there is no damage to the gun cable assembly.

Note: For problems that can not be corrected by following the troubleshooting procedures listed above; please contact KDAR Company. NEVER attempt to work on any part of the welder not listed above. Unauthorized repairs to the unit may result in danger to the operator and will void the factory warranty.

Warranty

KDAR Company, and its affiliates, warrants that all welders covered under this warranty is free from defects in material and workmanship for one year from the date of purchase. KDAR also warrants that all guns, hoses and ground clamp assemblies are free from defects in material and workmanship for 90 days from the date of purchase. This warranty is extended to the original purchaser who uses the product in a consumer application (personal, residential or household usage). All welders covered under this limited warranty which are used in commercial applications (i.e. income producing) are warranted to be free from defects in material and workmanship for 90 days from the date of original purchase. The products covered under this warranty are the 125WFG, 135WFG and 175WFG welders.

KDAR Company, and its affiliates, will repair or replace, at KDAR's sole discretion, parts found to be defective in material or workmanship within the warranty period. Warranty service will be scheduled according to the normal work flow and business hours of the service center doing the work as well as the availability of replacement parts. All decisions from KDAR Company regarding this limited warranty shall be final.

Original Purchaser's Responsibility:

1. Retain the original cash register receipt as proof of purchase.
2. Follow manual instructions regarding the care and operation of your welder.
3. If warranty work is required, **DO NOT RETURN THIS WELDER TO THE RETAILER.** Contact KDAR Company for instructions. Visit www.hotmaxtorches.com or call KDAR Company M-F 8AM-5PM CST to locate the nearest Authorized Service Center.

Not Covered:

1. Transportation charges for sending or delivering the welder to the Authorized Service Center or returning the repaired or replacement welder back to the customer. These charges are the responsibility of the customer.
2. Damages caused by ordinary wear, abuse, rain, freeze damage, negligence, accident or failure to operate or maintain the welder in accordance with the instructions in the operator's manual supplied with the welder.
3. Damage caused by unauthorized repair or alterations.

Exclusions and Limitations:

KDAR Company makes no other warranty of any kind, express or implied. Implied warranties, including warranties of merchantability and of fitness for a particular purpose, are hereby disclaimed. The warranty service described above is the exclusive remedy under this warranty; liability for incidental and consequential damages is excluded to the extent permitted by law.

This warranty gives you specific legal rights, and you may have other rights which vary from state to state. Some states do not allow a disclaimer of implied warranties, or the exclusion of incidental and consequential damages, so the above disclaimers and exclusions may not apply to you.

For warranty service or to obtain service parts or accessories:

Call: 314-692-8555 M-F 8-5 PM, CST

Visit: www.hotmaxtorches.com

Write: KDAR Company

15009 Manchester Rd #283

Ballwin, MO 63011

KDAR Company
15009 Manchester Rd. #283
Ballwin, MO 63011-4626

Phone: 314-692-8555 Fax: 314-692-8578