

## RAZOR 200 PULSE Welding Setup Guide



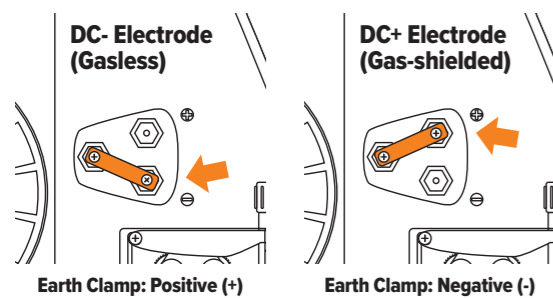
- 1. Back Button**  
Press the **BACK Button** to return to the previous page. This button can also be pressed to exit a pop up menu.
- 2. Amp / Wire Speed / Scroll Knob**
  - Turn this knob for digital screen navigation and cycling through menu options.
  - Press this knob in order to confirm actions, between the weld screen and the weld menu parameters.
  - In TIG/STICK mode this knob can be used to adjust current.
  - In MIG Manual mode this can be used to adjust wire speed.
  - In Synergic modes this can be used to adjust material thickness.
- 3. Voltage / Arc Length Knob**
  - In TIG this knob can be used to adjust weld cycle parameters.
  - In MIG Manual this knob is used to adjust voltage.
  - In MIG Synergic / Pulse mode this can be used to adjust arc length.
  - In MMA mode this knob can be used to adjust Arc Force.
- 4. Menu Button**  
Press the **MENU Button** to enter the main menu.
- 5. Digital Screen**  
The digital screen is a **Touch Screen**, you can tap menu items to select and adjust values. You can also swipe on screen to navigate menu items.

### Drive Rollers

SKU	Description
0.6-0.8V30/22	Drive Roll V Groove 0.6-0.8mm
0.8-1.0V30/22	Drive Roll V Groove 0.8-1.0mm
0.9-1.2V30/22	Drive Roll V Groove 0.9-1.2mm
1.0-1.2V30/22	Drive Roll V Groove 1.0-1.2mm
0.8-0.9F30/22	Drive Roll Knurled 0.8-0.9mm
0.9-1.2F30/22	Drive Roll Knurled 0.9-1.2mm
0.8-1.0U30/22	Drive Roll U Groove 0.8-1.0mm
0.9-1.0U30/22	Drive Roll U Groove 0.9-1.0mm
0.9-1.2U30/22	Drive Roll U Groove 0.9-1.2mm
1.0-1.2U30/22	Drive Roll U Groove 1.0-1.2mm

Please refer to operating manual for more detailed information.

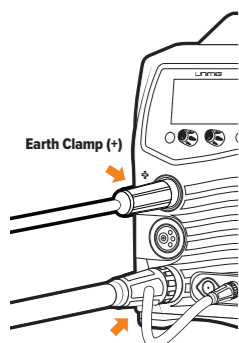
### Polarity: MIG



Earth Clamp: Positive (+)

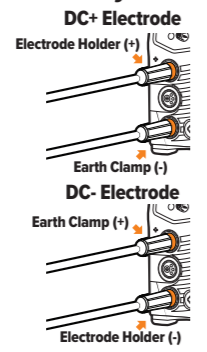
Earth Clamp: Negative (-)

### Polarity: TIG



TIG Torch (+)

### Polarity: Stick



Please refer to electrode packaging for correct polarity settings.

### Manual MIG Setup Guide

Material Type	Wire Type	Wire Size	Drive Roller	Polarity	Shielding Gas	Gas Flow Rate	Material Thickness	1mm	2mm	3mm	4mm	6mm	8mm	10mm	
Steel	ER70S-6	0.8mm	V Groove	DCEP+	ArCO <sup>2</sup>	8-12L/min	Voltage (V)	17.5	19.7	24.5	25.5	26.5	28.5		
							Wire Speed (m/min)	8.5	10	14.5	15.5	16.5	18		
	ER70S-6	0.9mm	V Groove	DCEP+	ArCO <sup>2</sup>	8-12L/min	Voltage (V)		21	25	26	26.7	29	31	
							Wire Speed (m/min)		12.4	15	16	16.4	16.9	17.6	
	E71T-11	0.8mm	F Groove (Knurled)	DCEN-				Voltage (V)	13.2	14.2	15.5	17.3	19.3	21.4	
								Wire Speed (m/min)	1.8	2	3.4	4.8	6.6	8.3	
E71T-11	0.9mm	F Groove (Knurled)	DCEN-				Voltage (V)		15	15.3	17.6	18	22	26	
							Wire Speed (m/min)		2.5	3.5	4.9	5.8	9	11.5	
Stainless Steel	316LSi	0.8mm	V Groove	DCEP+	ArCO <sup>2</sup>	8-12L/min	Voltage (V)	17.5	19.7	24.5	25.5	26.5	28.5		
							Wire Speed (m/min)	8.5	10	14.5	15.5	16.5	18		
	316LSi	0.9mm	V Groove	DCEP+	ArCO <sup>2</sup>	8-12L/min	Voltage (V)		21	25	26	26.7	29	31	
							Wire Speed (m/min)		12.4	15	16	16.4	16.9	17.6	

### DM26 MIG Torch Spares

SKU	Description	QTY
PCTH26M8S	TIP HOLDER	2
PCGD26	Gas Diffuser	2
PCT0005-08	CONTACT TIPS - Steel 0.8mm - M8	10
PCT0005-09	CONTACT TIPS - Steel 0.9mm - M8	10
PCT0005-10	CONTACT TIPS - Steel 1.0mm - M8	10
PCT0005-12	CONTACT TIPS - Steel 1.2mm - M8	10
PCTAL0005-08	CONTACT TIPS - Aluminium 0.8mm - M8	10
PCTAL0005-09	CONTACT TIPS - Aluminium 0.9mm - M8	10
PCTAL0005-10	CONTACT TIPS - Aluminium 1.0mm - M8	10
PCTAL0005-12	CONTACT TIPS - Aluminium 1.2mm - M8	10
PGN38CON	GAS NOZZLE - Conical	2
PGN38CYL	GAS NOZZLE - Cylindrical	2
PGN38TAP	GAS NOZZLE - Tapered	2

Please refer to operating manual for more detailed information.

### TIG Setup Guide (Pure Argon Gas / DC- Polarity)

Tungsten Diameter	Filler Rod	Material	1.6mm	3.2mm	4.8mm	6.0mm
1.6mm	1.6mm	Steel	60-90A	80-115A		
		Stainless	40-70A	65-110A		
2.4mm	2.4mm	Steel			115-165A	
		Stainless			100-150A	
3.2mm	2.4mm	Steel				160-200A
		Stainless				135-180A

### Stick Setup Guide

Material Type	Electrode Type	Electrode Thickness	2.5mm	3.2mm	4.0mm
Steel	HYPERARC® GP 6013	Amperage Range (A)	50-90A	90-130A	110-170A
		Polarity	DCEP+		
Steel	HYPERARC® 161C	Amperage Range (A)	50-90A	80-130A	110-180A
		Polarity	DCEP+		
Stainless Steel	HYPERARC® 316L	Amperage Range (A)	50-90A	70-110A	100-150A
		Polarity	DCEP+		

This setup information is intended to act as a guide only. Individual may vary depending on technique, skill and material. Please refer to the operating manual for further instructions.