

Forney

EASY WELD™

WELD EXAMPLES & TROUBLESHOOTING

GOOD WELD



- Smooth bead
- Minimal spatter
- Good fusion

CURRENT/WFS TOO HIGH



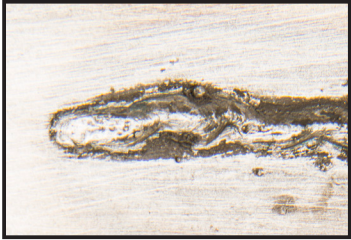
- Too wide
- Bead too flat
- Visible melt through

CURRENT TOO LOW



- Lack of fusion

WELD SPEED TOO FAST



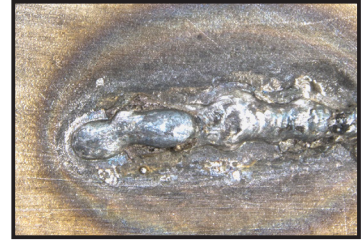
- Stringy and lack of fusion

WELD SPEED TOO SLOW



- Melt through or burn through

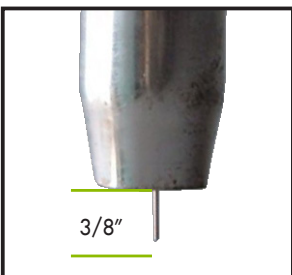
STICK OUT TOO LONG



- Excessive spatter

WELDING TIPS

OPTIMAL STICKOUT



- Stickout 3/8" +/- 1/8"
- Short stickout = more current and more penetration

VOLTAGE



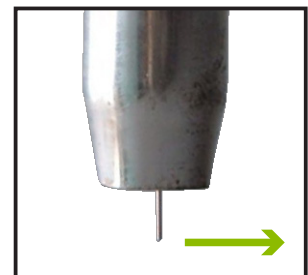
- Affects the arc shape
- Less voltage = tighter arc and potentially more spatter

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

THIN MATERIAL THICK MATERIAL

Less voltage
More voltage

Lower wire feed speed
Higher wire feed speed

Faster travel speed
Slower travel speed

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 procedures and wear proper PPE (clothes, welding helmet, safety glasses, welding gloves, boots, etc.).

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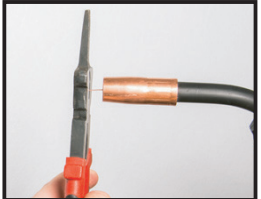
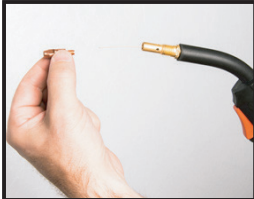
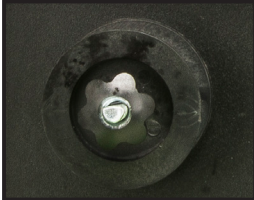
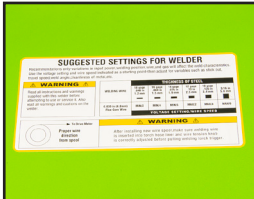
WARNING: To prevent serious injury, read manual warnings and instructions before use.

125 FC WELDER QUICK START GUIDE

- 1** Assemble torch wrap tabs to top handle.
(Tool needed: screwdriver)

- 2** Install wire spool per the diagram inside the cabinet.

- 3** Plug in welder.

- 4** Turn it on, and squeeze trigger until wire comes out.

- 5** Carefully tighten wire feed tension knob and despooler knob.

- 6** Adjust wire feed speed and material thickness switch per setup chart.

- 7** Turn machine on, pull trigger on MIG gun and weld. Adjust stickout, travel speed, wire feed speed and voltage as necessary to achieve a good weld. See reverse side for weld examples and welding tips.
