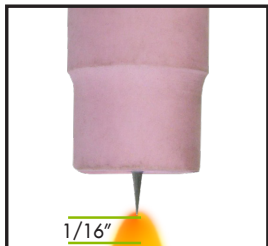# Forney

EASY WELD™

100 ST WELDER QUICK START GUIDE

TIG

1 Attach a size 25 Dinse TIG torch
(Size 9 or 17 with valve is recommended)

2 Verify proper shielding gas is used for TIG
welding. *(100% Argon)*

3 Make sure process switch is on TIG

4 Adjust amperage

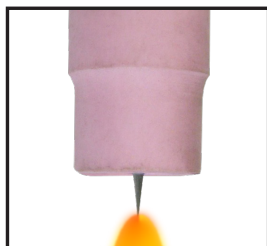**5** Open gas valve on torch and use lift arc technique

---

TIG WELDING TIPS

OPTIMAL ARC LENGTH

1/16"

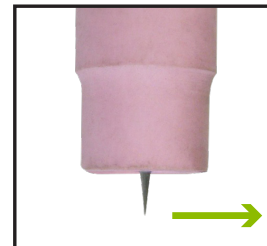- Optimal arc length varies by electrode type and diameter but is approximately 1/16"

ARC START

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

AMPERAGE

100 ST
DC Stick/TIG

- 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

Forney
# EASY WELD™

100 ST WELDER QUICK START GUIDE
STICK

1 Plug in welder

2 Adjust polarity for the stick electrode (Usually DCEP - Electrode Positive)

3 Make sure process switch is on STICK

4 Adjust amperage per electrode manufactures recommendations

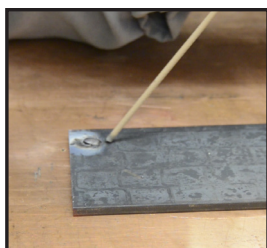| GENERAL AMPERAGE RECOMMENDATION			
Ø	E6011, E6013, E7014	E7018	E308, E309, E316, E312
1/16"	30-40A	N/A	20-40A
5/64"	40-60A	N/A	30-50A
3/32"	50-70A	70-80A	40-70A
1/8"	80A	80A (DIFFICULT)	50-80A

STICK WELDING TIPS

OPTIMAL STICKOUT

1/16"
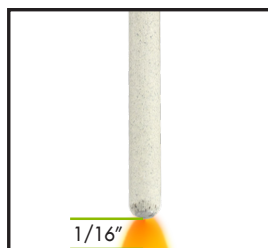
• Optimal stickout varies by electrode type and diameter but is approximately 1/16"
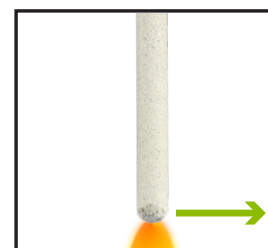
STRIKE ARC

• Scratch or tap technique is often used

AMPERAGE

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

TRAVEL SPEED

• Affects bead width and height
• Can also affect penetration