

Set Up Machine in 3 Easy Steps

1 Process Selection Control

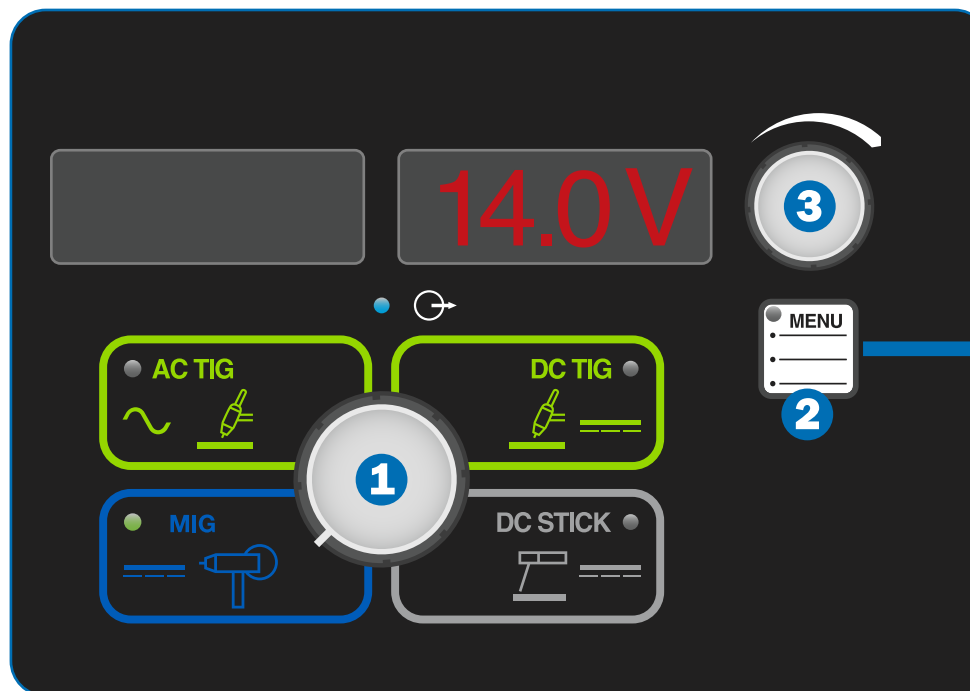
Turn to select process.

2 Menu Button

Press to access process parameters.
Menu automatically returns to amperage setting 15 seconds after adjustment.

3 Encoder Control

Turn to adjust selected parameter.



Voltage Control

Controls the welding voltage output.

[WFS] Wire Feed Speed

Controls the speed of the wire feed with a minimum of 0.0 to maximum of 10.

Auto-Set™ feature. Use this when you want the speed, convenience, and confidence of pre-set controls. Simply set the spool gun, process/gas type, wire size, and material thickness, and you're ready to weld.

User Menu—Hold Down Menu Button for 3 Seconds to Access

[GUN] Spool Gun

Choose the correct spool gun you are welding with using the Encoder Control. Select from the Spoolmate™ 100 and the Spoolmate™ 150.

[PROC] Process/Gas Type

Choose the correct process you are welding with using the Encoder Control. Select from Flux, Trigas, C25, C100, 4043 and 5356. (5356 is only selectable with the Spoolmate 150.)

[WIRE] Wire Size

Choose the appropriate wire size by using the Encoder Control. Select from 0.024, 0.030 and 0.035.

[MAT] Material Thickness

Choose the correct material thickness for the material you are welding with using the Encoder Control. Select from 24GA, 22GA, 20GA, 18GA, 16GA, 14GA, 1/8, 3/16, 1/4, and 3/8.



Read and follow all labels and the Owner's Manual carefully before installing, operating, or servicing unit.
Read the safety information at the beginning of the manual and in each section.

Note: These settings are intended to be a starting point for control panel setup — this is not a welding procedure specification nor a substitute for procedure qualification.

Wire Welding (MIG/Flux-Cored) Parameters for Spoolmate™ 100

Material	Wire Type	Polarity*	Shielding Gas	Wire Dia.	24 ga.	22 ga.	20 ga.	18 ga.	16 ga.	14 ga.	1/8"	3/16"	1/4"	3/8"	
					120 V / 240 V	120 V / 240 V	120 V / 240 V	120 V / 240 V	120 V / 240 V	120 V / 240 V	120 V / 240 V	240 V	240 V	240 V	240 V
Steel	Solid Wire ER70S-6	DCEP	Ar/CO ₂ "C25"	0.024	16/3.7	16/3.7	16.2/4.6	16.7/8.8	17.7/9.3	18.4/9.9	18.9/10				
				0.030	15.4/0	15.4/0	16/0.6	17/1	17/3.2	17.8/4.8	19.5/6	20.1/6.9	21.8/7.5		
				0.035			16/0.2	17/0.8	17.7/1.6	18.4/1.5	19.6/2.8	20.8/3.9	21/4.3	22.1/5	
			CO ₂ "C100"	0.024	17/0.7	17/0.7	17.5/1.3	18.6/2.5	19.8/3.8	21/8.9	21.8/10				
				0.030	17/0.3	17/0.3	17.5/0.5	18.6/1.5	17.4/3.2	19.3/3.9	21.2/5.1	21.8/5.6			
				0.035			17.5/0.3	18.6/1.2	19.8/1.9	20.5/2.2	20.9/2.9	21.8/3.2			
Flux-Cored E71T-11	DCEN	None "Flux"	0.030						18.3/3.6	18.5/3.8	20.5/5.2	22.5/8.6			
			0.035							18.5/3.5	20.5/4.7	21.5/5.5	22/6.5		
Stainless Steel	Stainless Steel	DCEP	"Trigas"	0.030		18/0.2	18.3/0.5	18.5/0.7	18.9/1	19.4/1.2	20.9/6.6	21.5/7	22.5/7.5		
				0.035			18.3/0.3	18.5/0.4	18.9/0.6	19.4/0.9	20.9/3.6	21.5/3.9	22.3/4.2		
Aluminum	Aluminum ER4043	DCEP	Argon	0.030						14.8/8.5	15.2/8.8	20.7/9.8	22.5/10		
				0.035						14.8/8.2	15.2/8.6	20.3/9.7	21.4/9.9		

Wire Welding (MIG/Flux-Cored) Parameters for Spoolmate™ 150

Material	Wire Type	Polarity*	Shielding Gas	Wire Dia.	24 ga.	22 ga.	20 ga.	18 ga.	16 ga.	14 ga.	1/8"	3/16"	1/4"	3/8"		
					120 V / 240 V	120 V / 240 V	120 V / 240 V	120 V / 240 V	120 V / 240 V	120 V / 240 V	120 V / 240 V	240 V	240 V	240 V	240 V	
Steel	Solid Wire ER70S-6	DCEP	Ar/CO ₂ "C25"	0.030	15.4/0	15.4/0	16/0.5	17/1	17.7/1.4	17.8/4.8	19.5/6	20.1/6.9	21.8/7.4			
				0.035			16/0.2	17/0.6	17.7/1.1	18.4/1.3	19.6/2.2	20.8/3.9	21/4.3	22.1/4.7		
				0.030	17/0.2	17/0.2	17.5/0.5	18.6/1.1	19.8/1.5	19.3/3.6	21.2/4.6	21.3/5.2				
			CO ₂ "C100"	0.035			17.5/0.1	18.6/0.6	19.8/1	20.5/1.2	19.3/3.6	21.2/4.6	21.3/5.2			
				Flux-Cored E71T-11	DCEN	None "Flux"	0.030					18.3/3.3	19.3/4.1	21.4/7.9	22.5/8.6	
							0.035						18.5/3.2	20.5/4.4	21.5/5.3	22/6.5
Stainless Steel	Stainless Steel	DCEP	"Trigas"	0.030		18/0	18.3/0.4	18.5/0.8	18.9/1.1	19.4/1.6	21.5/7	22.5/7.2				
				0.035			18.3/0.1	18.5/0.2	18.9/0.4	19.4/0.9	20.9/3.7	21.5/3.9	22.3/4.2			
Aluminum	Aluminum ER4043	DCEP	Argon	0.030					14.8/7.5	18/7.9	20.7/8.4	21.6/8.9				
				0.035					15.4/3.8	18/6.5	19.3/7.8	20.4/8.8				
	Aluminum ER5356	DCEP	Argon	0.030					14.5/8.9	15.7/9.2						
				0.035					15.8/7.4	17.2/8.7	19.2/10					

*Polarity selection is done automatically by the power source.

Note: Some parameters are not available in 120 V due to limited input power. **Blue values** are only available when connected to 240 V.

