



# OPERATING MANUAL

## JRW200AC/DC



**3 YEARS Warranty**  
(Power Source)

Please read and understand this instruction manual carefully before the installation and operation of this equipment.

Thank you for your purchase of your RAZORWELD welding machine.

We are proud of our range of welding equipment that has a proven track record of innovation, performance and reliability.

Our product range represents the latest developments in Inverter technology put together by our professional team of highly skilled engineers. The expertise gained from our long involvement with inverter technology has proven to be invaluable towards the evolution and future development of our equipment range. This experience gives us the inside knowledge on what the arc characteristics, performance and interface between man and machine should be.

Within our team are specialist welders that have a proven history of welding knowledge and expertise, giving vital input towards ensuring that our machines deliver control and performance to the utmost professional level.

We employ an expert team of professional sales, marketing and technical personnel that provide us with market trends, market feedback and customer comments and requirements. Secondly they provide a customer support service that is second to none, thus ensuring our customers have confidence that they will be well satisfied both now and in the future.

RAZORWELD welders are manufactured and compliant with - CAN/CSA 609741-1 guaranteeing you electrical safety and performance.

## WARRANTY

- 3 Years from date of purchase.
- JASIC TECHNOLOGIES AMERICA INC warranties all goods as specified by the manufacturer of those goods.
- This Warranty does not cover freight or goods that have been interfered with.
- All goods in question must be repaired by an authorised repair agent as appointed by this company.
- Warranty does not cover abuse, mis-use, accident, theft, general wear and tear.
- New product will not be supplied unless JASIC TECHNOLOGIES AMERICA INC has inspected product returned for warranty and agree's to replace product.
- Product will only be replaced if repair is not possible
- Please view full Warranty term and conditions supplied with machine or at [www.razorweld.com/warranty.asp](http://www.razorweld.com/warranty.asp) or at the back of this manual.

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## ATTENTION! - CHECK FOR GAS LEAKS

At initial set up and at regular intervals we recommend to check for gas leakage.

Recommended procedure is as follows:

1. Connect the regulator and gas hose assembly and tighten all connectors and clamps.
2. Slowly open the cylinder valve.
3. Set the flow rate on the regulator to approximately 20-30cfh
4. Close the cylinder valve and pay attention to the needle indicator of the contents pressure gauge on the regulator, if the needle drops away towards zero there is a gas leak.  
Sometimes a gas leak can be slow and to identify it will require leaving the gas pressure in the regulator and line for an extended time period. In this situation it is recommended to open the cylinder valve, set the flow rate to 20-30cfh, close the cylinder valve and check after a minimum of 15 minutes.
5. If there is a gas loss then check all connectors and clamps for leakage by brushing or spraying with soapy water, bubbles will appear at the leakage point.
6. Tighten clamps or fittings to eliminate gas leakage.

**IMPORTANT!** - We strongly recommend that you check for gas leakage prior to operation of your machine. We recommend that you close the cylinder valve when the machine is not in use.

JASIC TECHNOLOGIES AMERICA INC , authorised representatives or agents of JASIC TECHNOLOGIES AMERICA INC will not be liable or responsible for the loss of any gas.

## SAFETY

Welding and cutting equipment can be dangerous to both the operator and people in or near the surrounding working area if the equipment is not correctly operated. Equipment must only be used under the strict and comprehensive observance of all relevant safety regulations. Read and understand this instruction manual carefully before the installation and operation of this equipment.

### Machine Operating Safety

- Do not switch the function modes while the machine is operating. Switching of the function modes during welding can damage the machine. Damage caused in this manner will not be covered under warranty.
- Disconnect the electrode-holder cable from the machine before switching on the machine, to avoid arcing should the electrode be in contact with the work piece.
- Operators should be trained and or qualified.



Electric shock: It can kill. Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on. The input power circuit and internal machine circuits are also live when power is on. In Mig/Mag welding, the wire, drive rollers, wire feed housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is dangerous.

- Connect the primary input cable according to USA AND /OR CANADIAN standards and regulations.
- Avoid all contact with live electrical parts of the welding circuit, electrodes and wires with bare hands. The operator must wear dry welding gloves while he/she performs the welding task.
- The operator should keep the work piece insulated from himself/herself.
- Keep cords dry, free of oil and grease, and protected from hot metal and sparks.
- Frequently inspect input power cable for wear and tear, replace the cable immediately if damaged, bare wiring is dangerous and can kill.
- Do not use damaged, under sized, or badly joined cables.
- Do not drape cables over your body.



Fumes and gases are dangerous. Smoke and gas generated whilst welding or cutting can be harmful to people's health. Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

- Do not breathe the smoke and gas generated whilst welding or cutting, keep your head out of the fumes
- Keep the working area well ventilated, use fume extraction or ventilation to remove welding fumes and gases. Use of a PAPR system is recommended.
- In confined or heavy fume environments always wear an approved air-supplied respirator. Welding fumes and gases can displace air and lower the oxygen level causing injury or death. Be sure the breathing air is safe.
- Do not weld in locations near de-greasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapours to form highly toxic and irritating gases.
- Materials such as galvanized, lead, or cadmium plated steel, containing elements that can give off toxic fumes when welded. Do not weld these materials unless the area is very well ventilated, and or wearing an air supplied respirator.



Arc rays: harmful to people's eyes and skin. Arc rays from the welding process produce intense visible and invisible ultraviolet and infrared rays that can burn eyes and skin.

- Always wear a welding helmet with correct shade of filter lens and suitable protective clothing including welding gloves whilst the welding operation is performed.
- Measures should be taken to protect people in or near the surrounding working area. Use protective screens or barriers to protect others from flash, glare and sparks; warn others not to watch the arc.



Fire hazard. Welding on closed containers, such as tanks, drums, or pipes, can cause them to explode. Flying sparks from the welding arc, hot work piece, and hot equipment can cause fires and burns. Accidental contact of electrode to metal objects can cause sparks, explosion, overheating, or fire. Check and be sure the area is safe before doing any welding.

- The welding sparks may cause fire, therefore remove any flammable materials away from the working area, at least 40ft from the welding arc. Cover flammable materials and containers with approved covers if unable to be moved from the welding area.
- Do not weld on closed containers such as tanks, drums, or pipes, unless they are properly prepared according to the required Safety Standards to insure that flammable or toxic vapors and substances are totally removed, these can cause an explosion even though the vessel has been “cleaned”. Vent hollow castings or containers before heating, cutting or welding. They may explode.
- Do not weld where the atmosphere may contain flammable dust, gas, or liquid vapours (such as petrol)
- Have a fire extinguisher nearby and know how to use it. Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas. Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.



Gas Cylinders. Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Because gas cylinders are normally part of the welding process, be sure to treat them carefully. CYLINDERS can explode if damaged.

- Protect gas cylinders from excessive heat, mechanical shocks, physical damage, slag, open flames, sparks, and arcs.
- Ensure cylinders are held secure and upright to prevent tipping or falling over.
- Never allow the welding electrode or earth clamp to touch the gas cylinder, do not drape welding cables over the cylinder.
- Never weld on a pressurised gas cylinder, it will explode and kill you.
- Open the cylinder valve slowly and turn your face away from the cylinder outlet valve and gas regulator.



Gas build up. The build up of gas can causes a toxic environment, deplete the oxygen content in the air resulting in death or injury. Many gases use in welding are invisible and odourless.

- Shut off shielding gas supply when not in use.
- Always ventilate confined spaces or use approved air-supplied respirator.



Electronic magnetic fields. MAGNETIC FIELDS can affect Implanted Medical Devices.

- Wearers of Pacemakers and other Implanted Medical Devices should keep away.
- Implanted Medical Device wearers should consult their doctor and the device manufacturer before going near any electric welding, cutting or heating operation.



Noise can damage hearing. Noise from some processes or equipment can damage hearing. Wear approved ear protection if noise level is high.



Hot parts. Items being welded generate and hold high heat and can cause severe burns. Do not touch hot parts with bare hands. Allow a cooling period before working on the welding gun. Use insulated welding gloves and clothing to handle hot parts and prevent burns.

## CAUTION

### 1. Working Environment.

- 1.1 The environment in which this welding equipment is installed must be free of grinding dust, corrosive chemicals, flammable gas or materials etc, and at no more than maximum of 80% humidity.
- 1.2 When using the machine outdoors protect the machine from direct sun light, rain water and snow etc; the temperature of working environment should be maintained within -10°C to +40°C.(14 F-104 f)
- 1.3 Keep this equipment 30cm distance from the wall.
- 1.4 Ensure the working environment is well ventilated.

### 2. Safety Tips.

#### 2.1 Ventilation

This equipment is small-sized, compact in structure, and of excellent performance in amperage output. The fan is used to dissipate heat generated by this equipment during the welding operation.

Important: Maintain good ventilation of the louvers of this equipment. The minimum distance between this equipment and any other objects in or near the working area should be 30 cm. Good ventilation is of critical importance for the normal performance and service life of this equipment.

#### 2.2 Thermal Overload protection.

Should the machine be used to an excessive level, or in high temperature environment, poorly ventilated area or if the fan malfunctions the Thermal Overload Switch will be activated and the machine will cease to operate. Under this circumstance, leave the machine switched on to keep the built-in fan working to bring down the temperature inside the equipment. The machine will be ready for use again when the internal temperature reaches safe level.

#### 2.3 Over-Voltage Supply

Regarding the power supply voltage range of the machine, please refer to "Main Parameter" table. This equipment will automatically compensate for input voltage variations within a specific range. In circumstances where the voltage of the input power supply exceeds the stipulated value, it is possible to cause damage to the internal components of this equipment. Please ensure your primary power supply is correct."

- 2.4 Do not come into contact with the output terminals while the machine is in operation.  
An electric shock may possibly occur.

## MAINTENANCE

Exposure to extremely dusty, damp, or corrosive air is damaging to the welding machine. In order to prevent any possible failure or fault of this welding equipment, clean the dust at regular intervals with clean and dry compressed air of required pressure.

Please note that: lack of maintenance can result in the cancellation of the warranty; the warranty of this welding equipment will be void if the machine has been modified or shows signs of attempts to open or take apart the machine through damaging the factory-installed seal without the consent of an authorized representative of the manufacturer.

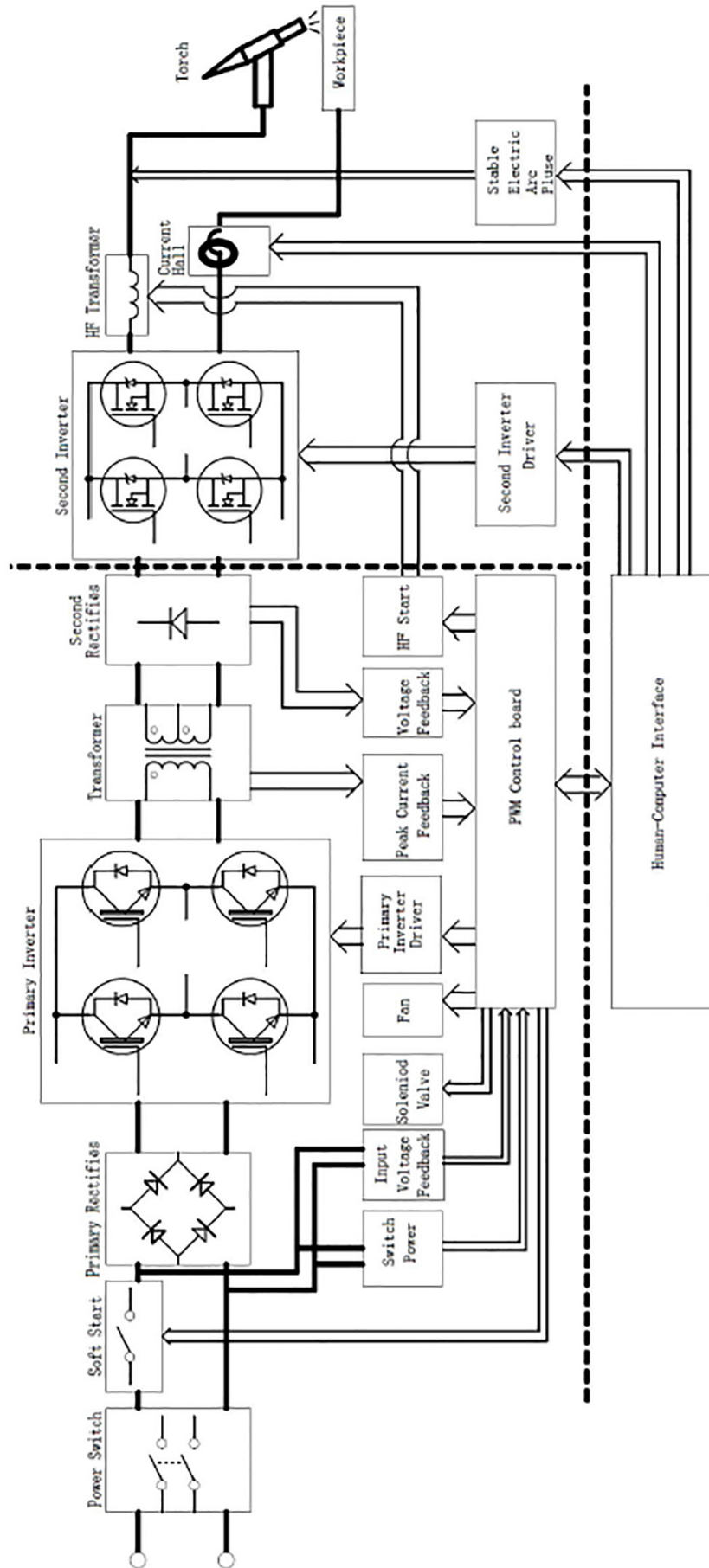
## TROUBLE SHOOTING

Caution: Only qualified technicians are authorized to undertake the repair of this welding equipment. For your safety and to avoid Electrical Shock, please observe all safety notes and precautions detailed in this manual.

### Note:

Minimum Motor Generator Power Suggested:- 7KVA (9KVA Generator)

- Our equipment as described in this manual conforms to all applicable rules and regulations of the 'LowVoltage Directive' (European Council Directive 73/23/EEC) as set out and amended by Council Directive 93/68/EEC) and to the National legislation for the enforcement of this Directive.
- Our equipment as described in this manual conforms to all applicable rules and regulations of the European Council Directive 89/336/EEC, (EMC Directive) and to the National legislation for the enforcement of this Directive.



# RAZOR DIGITAL 200 AC/DC TIG/ARC - Digital Inverter Welder

**Welds:** Aluminium, Magnesium, Zinc Alloys, Steels, Stainless, Cast Iron, Bronze, Copper



## TIG/ARC 200 Amp AC/DC Inverter Welder Digital Control - 115/230V

### Features

- Latest 43KHz Inverter Technology
- AC/DC HF TIG/ARC Function
- Arc Ignition HF Oscillation
- AC Square Wave 20 - 250Hz
- AC Balance Control Adjustable
- Pulse Frequency 1 - 200Hz
- Pulse Width 50%
- Base Current 5 - 200A
- Up Slope 0 -10 sec
- Down Slope 0 -15 sec
- Pre Gas 0 - 5 sec
- Post Gas 0.5 -20 sec
- Trigger Function 2/4T-Spot
- ARC
- Arc Ignition Current Automatic
- Arc Ignition Time Automatic
- Foot control as standard



### MACHINE SPECIFICATIONS

200AC/DC Pulse		TIG AC/DC Pulse inverter welder	
		Serial No.:	
		CAN/CSA - E60974-1 ANSI/IEC 60974-1	
WELDING OUTPUT			
	Input: AC115V Output: 10A/10.4V -95A/13.8V	X	60% 100%
		I <sub>2</sub>	95A 73A
	U <sub>0</sub> Input: AC230V Output: 10A/10.4V 58V -210A/18V	X	25% 60% 100%
		I <sub>2</sub>	200A 129A 100A
	Input: AC115V Output: 10A/10.4V -60A/22.4V	X	60% 100%
		I <sub>2</sub>	60A 46.4A
	U <sub>0</sub> Input: AC230V Output: 10A/10.4V -110A/7.5.4V	X	30% 60% 100%
		I <sub>2</sub>	160A 114A 88A
<b>ENERGY INPUT</b>			
	U <sub>1</sub>	I <sub>1max</sub> /A	I <sub>1cont</sub> /A
		115V	21A
1~50/60Hz	IP21 S	220V	34A 18A
		Insulation class: B	



TIG torch

RWJFC-2D  
Remote Foot Control as  
Standard

### Overview

The RAZOR200ACDC is a Digital Controlled Square Wave AC/DC TIG inverter welder. Intelligent digital control of the main functions are realized by intuitive software providing ease of operation and high accuracy. Full TIG functionality, offers simple step by step digital control of functions and parameters providing complete professional control. HF arc ignition provides Pre Gas with instant arc ignition leaving no tungsten inclusion or contamination of the tungsten electrode. Digital set of Pre Gas Time, Start Current, Up Slope and Down Slope Time, Finish Current Level and Post Gas Time with the choice of 2T or 4T trigger function allows control of the welding process at a professional level from start to finish. Digital Pulse Control gives full parameter setting of Peak & Base Current, Pulse Frequency & Pulse Width providing control of heat input, penetration & distortion. AC Square Wave Balance gives control of the electron flow at the tungsten, the AC TIG arc can be adjusted from maximum oxide-layer cleaning on aluminum through to a deeper penetrating weld. Remote Control Interface provides remote amperage control at the foot-pedal control. The Selectable Tungsten feature allows the user to initiate softer arc starts when using small tungsten with thin metals avoiding burn through on their work. When using a larger tungsten it requires a larger initial current and by selecting a larger tungsten size it avoids arc stutter or lack of arc initiation. DC ARC welding delivers a smooth and stable arc for easy welding of electrodes producing high quality welds including cast Iron, stainless and low hydrogen. Arc Ignition and Arc Force control allows you to set the ideal arc condition no matter what electrode you choose. Optimized auto protection of the power input provides auto shut down of the machine when large scale fluctuations occur. Unique air channel design increases the heat dissipation of the power device, control circuits, minimizes dust absorption, thereby greatly improving longevity and reliability. RAZOR200ACDC is the new standard for Dual voltage welders making it the ideal choice for both the experienced professional welder and the weekend Warrior alike. Built to our specifications and manufactured in compliance to CAN/CSA 60974.1

### MACHINE PACKAGE: JRW200AC/DC

Standard option includes: RAZOR200AC/DC Machine, WP/SR17 TIG Torch x 13ft, Earth Lead 1" x 13ft, Argon Regulator, 6ft Gas Hose with fittings, Power Adaptor







Front Machine Layout Description

1. Digital control panel
2. Positive output terminal
3. Negative output terminal
4. Quick lock gas connector \* 5/8 NPT in USA
5. Torch switch - remote connector 5 Pin
6. Encoder knob
7. Handle



Rear Machine Layout Description

8. Power switch - on/off
9. Caution notice
10. Mains power input cable
11. Fan
12. Inlet gas connector \* 5/8" NPT (USA)

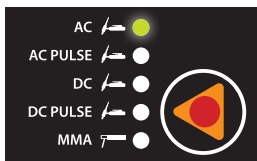


Front Panel Functions

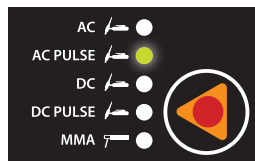


Indicates Active Selector Pad

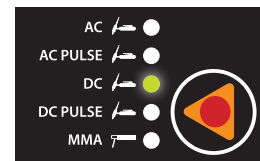
1. Mode Selector - Enables selection of required welding mode - AC TIG - AC PULSE TIG - DC TIG - DC PULSE TIG DC ARC (Stick)



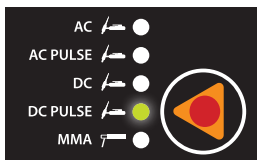
AC TIG: Select by pushing the selector pad to cycle through to illuminate the AC icon.



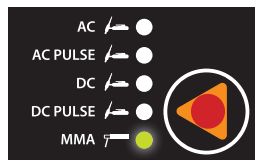
AC Pulse TIG: Select by pushing the selector button to cycle through to illuminate the AC PULSE icon.



DC TIG: Select by pushing the selector button to cycle through to illuminate the DC icon.



DC Pulse TIG: Select by pushing the selector button to cycle through to illuminate the DC PULSE icon.



DC ARC: Select by pushing the selector button to cycle through to illuminate the ARC icon.

3. Torch Switch Mode Selector - Controls the on/off cycle of the machine using the torch switch while incorporating the weld program parameters selections.



2T: Select the 2T icon using the selector pad. 2T uses 2 actions of the torch switch while incorporating the weld program parameter selections. (refer to page 10 for instruction of 2T function)



4T: Select the 4T icon using the selector pad. 4T uses 4 actions of the torch switch while incorporating the weld program parameter selections. 4T provides operator control of the start and finish portions of the weld sequence. (refer to page 11 for instruction of 4T function)

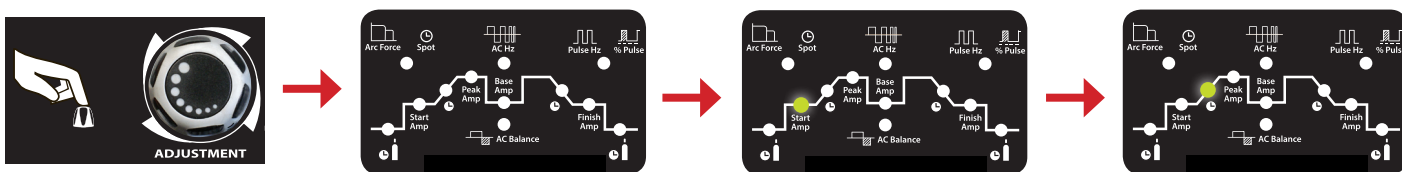


SPOT: Select the SPOT icon using the selector pad. Spot uses a single action of the torch switch 1) Pressing the torch switch gives arc ignition and initializes the welding sequence for the period of time set using the spot timer. (refer to page 11 for instruction of SPOT function)

3. Encoder Knob - provides digital adjustment of welding parameters and provides step by step motion through the weld cycle parameters.



Encoder knob weld parameter value selection  
Turning the encoder will adjust the value of the parameters required. The value selected will show in the digital display screen.



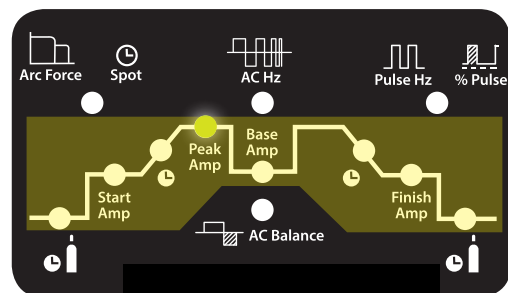
Encoder knob weld cycle function selection  
Pushing the encoder will allow step by step selection of the weld cycle function. The weld function selected will shown by the illuminated LED. Turning the Encoder Knob will allow adjustment and setting of value for the weld function parameter selected.

#### 4a - Weld Program - Selection weld program parameters

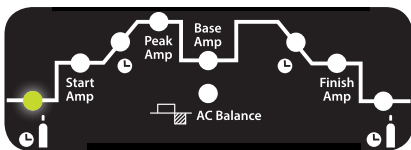
Parameter selection: Select by pushing the Encoder Knob repeatedly to cycle through the weld parameter icons. The icon will illuminate when selected. Each push of the encoder knob will move the icon illumination in a clockwise cycle.



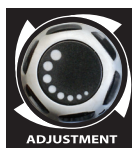
Shows selected icon



Pre Gas Timer - Provides selection for gas flow time prior to the arc starting.



Pre Gas Time: Select by pushing the encoder to cycle through to illuminate the Pre Gas Timer icon.

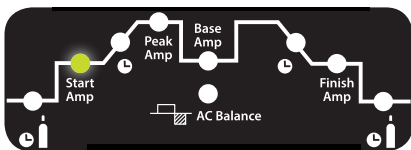


Turn the Encoder to set the Pre-Gas Time (Range is 0-3 Sec)



The value selected shows on the digital display. It is the length of time the gas will flow before the arc starts.

Start Amp - Provides selection for the amount of amps required at the start of the weld.



Start Amp: Select by pushing the encoder to cycle through to illuminate the Start Amp icon.



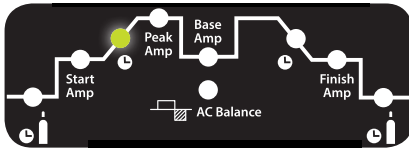
Turn the Encoder to set the Start Amp value (Range is 5-200A)




The value selected shows on the digital display. It is the amount of amps the machine will deliver at the start of the welding sequence.

After selecting Starting Amperage you will be prompted to enter initial Arc "Soft Start" 0-20ms, after entering initial start amperage start Amperage light will stay lit and display 0.0, select your desired initial delay from a range of 0-20ms.

**Up Slope Time - Sets the transition time from Start Amperage to Welding Amperage**



Up Slope Time: Select by pushing the encoder to cycle through to illuminate the Up Slope icon. 

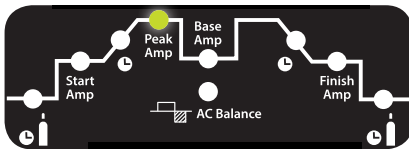


Turn the Encoder to set the Up Slope value (Range is 0-10 Sec)



The value selected shows on the digital display. It is the amount of time the welding current takes to climb from start amperage to welding amperage.

**Peak Amp - Provides selection for the Maximum Welding Amperage required during welding.**



Peak Amp: Select by pushing the encoder to cycle through to illuminate the Peak Amp icon.

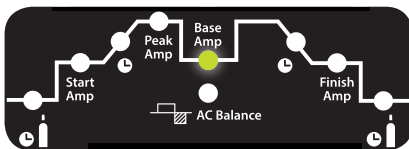


Turn the Encoder to set the Peak Amp value (Range is 10-200A)



The value selected shows on the digital display. It is the maximum set value of amperage the machine will deliver.

**Base Amp - Provides selection for the Base Amperage during the Pulse Welding cycle.**



Base Amp: Select by pushing the encoder to cycle through to illuminate the Base Amp icon.

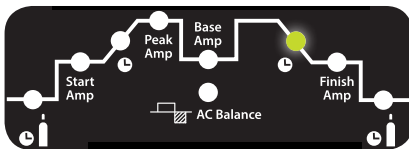



Turn the Encoder to set the Base Amp value (Range is 5-200A)



The value selected shows on the digital display. It is the set value of amperage the machine will deliver during the Base Amp period of the pulse cycle.

**Down Slope Time - Sets the transition time from Welding Amperage to Finish Amperage**



Down Slope Time: Select by pushing the encoder knob to cycle through to illuminate the Down Slope icon. 

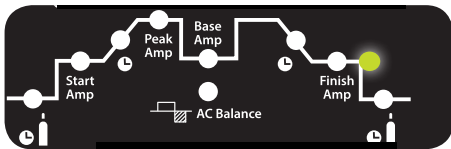


Turn the Encoder to set the Down Slope time (Range is 0-15 Sec)



The value selected shows on the digital display. It is the amount of time it takes for the welding amperage to drop down to the set finish amperage.

**Finish Amp - Provides selection for the amount of amperage required at the end of the weld.**



Finish Amp: Select by pushing the encoder knob to cycle through to illuminate the Finish Amp icon. After selecting finish Amperage you will be prompted to enter "Soft tailout" 0-20ms, after entering finish amperage the finish Amperage light will stay lit and display 0.0, select your desired tailout from a range of 0-20ms.

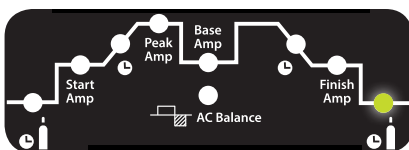



Turn the Encoder to set the Finish Amp value (Range is 10-200A)



The value selected shows on the digital display. It is the amount of amps the machine will deliver at the finish of the welding sequence.

**Post Gas Timer - Provides selection for continued gas flow time at the end of the welding after the arc is out.**



Post Gas Time: Select by pushing the encoder knob to cycle through to illuminate the Post Gas Timer icon. 



Turn the Encoder to set the Up Slope value (Range is 0.5-15 Sec)




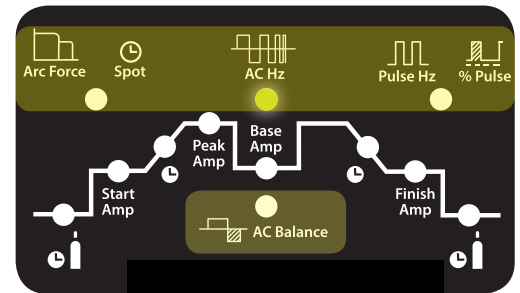
The value selected shows on the digital display. It is the length of time the gas will flow after the arc is finished.

### 4B Weld Program - Selection of further weld program parameters

Parameter selection: Select by pushing the Encoder Knob repeatedly to cycle through the weld parameter icons. The icon will illuminate when selected. Each push of the encoder knob will move the icon illumination in a clockwise cycle.



 Shows selected icon



**AC Balance** - Provides selection to adjust the balance of the AC wave form in AC TIG mode. Allows adjustment of the arc to be balanced, penetrating or oxide cleaning during AC TIG welding.



**Start Amp:** Select by pushing the encoder to cycle through to illuminate the AC Balance icon.



Turn the Encoder to set the AC Balance value  
Range is (-15 to -50)



The value selected shown on the digital display represents a more penetrating arc set at -15, a balanced arc at 0, or a more oxide cleaning action arc at -50

**AC Hz** - Provides selection to adjust the frequency of the AC square wave in AC TIG mode. Allows adjustment of frequency of the AC square wave cycle (transition from + to -) during AC TIG welding.



**AC Hz:** Select by pushing the encoder to cycle through to illuminate the AC Hz icon.



Turn the Encoder to adjust the AC Hz  
(Range is 20-250Hz)



The value selected shown on the digital display represents the number of times per second that the AC square wave transitions from + to - cycle.

**Pulse Hz** - Provides selection of the pulse frequency of the welding output current. Allows adjustment of frequency that the output current transitions from Peak Amp to Base Amp.



**Pulse Hz:** Select by pushing the encoder to cycle through to illuminate the Pulse Hz icon.

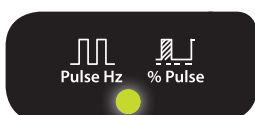


Turn the Encoder to adjust the Pulse Hz  
(Range is 0.02 - 200Hz)



The value selected shown on the digital display represents the number of times per second that the output welding current switches from Peak Amp to Base Amp

**% Pulse** - Provides selection of the on time ratio of the Peak Amp during the pulse welding cycle (Pulse Width). Allows adjustment of the % of time that the Peak Amp is on during each pulse cycle.



**% Pulse:** Select by pushing the encoder to cycle through to illuminate the Pulse Hz icon. Push the encoder a 2nd time to access % Pulse adjustment mode

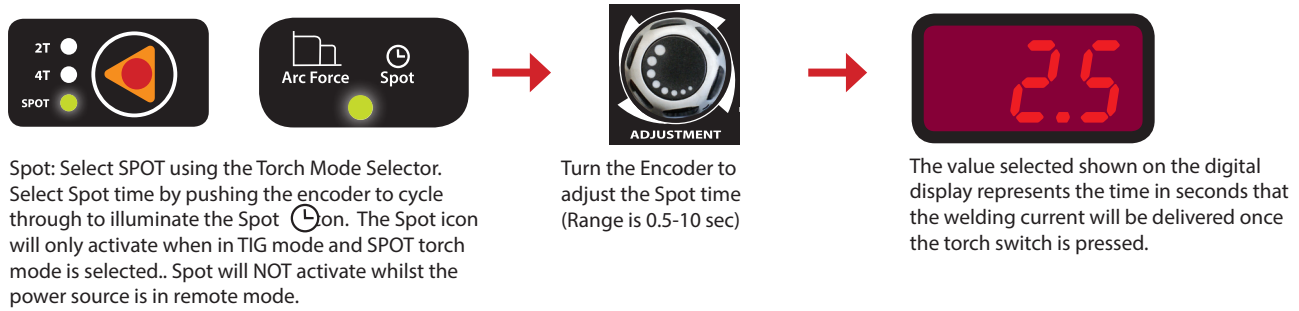


Turn the Encoder to adjust the % Pulse  
(Range is 10-90%)

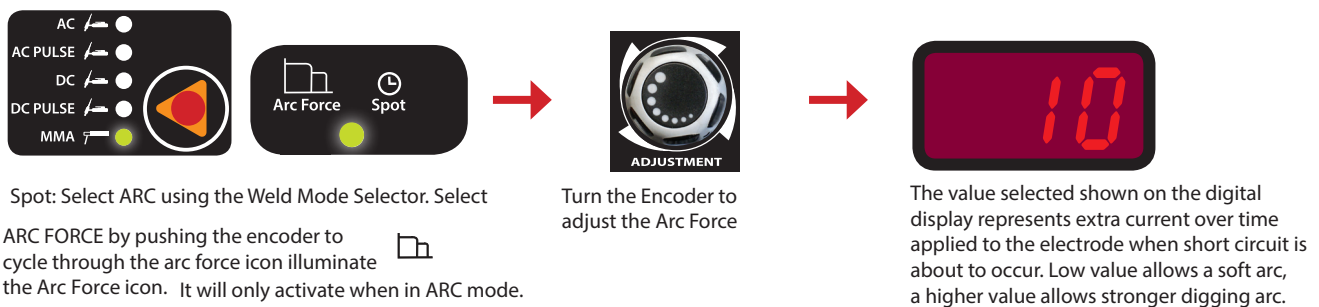


The value selected shown on the digital display represents the % of time that the Peak Amp is on during the pulse cycle.

**Spot** - Provides selection of a pre-set time period for welding current output.  
Allows adjustment of the time that machine will deliver amperage output from trigger activation.

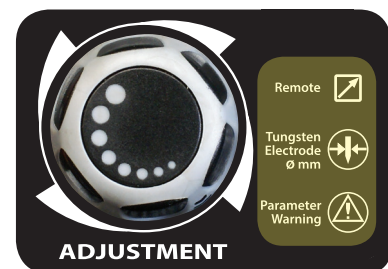


**Arc Force** - Provides selection for adjustment of the ARC FORCE during ARC (Stick) welding.  
Allows setting from a soft buttery arc characteristic through to a more digging, penetrating type of arc.

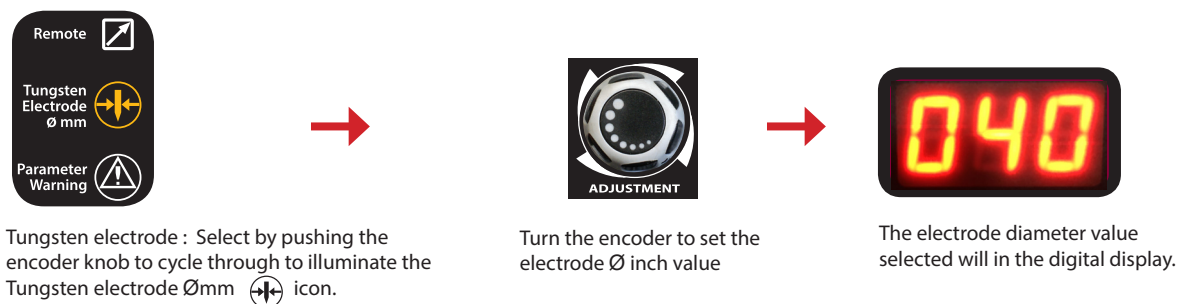


### 4C - Other front panel Icon selection

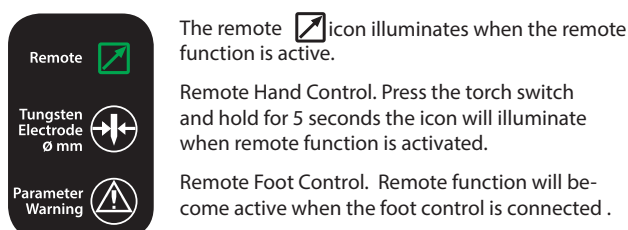
Icon selection: Select by pushing the Encoder Knob repeatedly to cycle through the weld parameter icons. The icon will illuminate when selected.



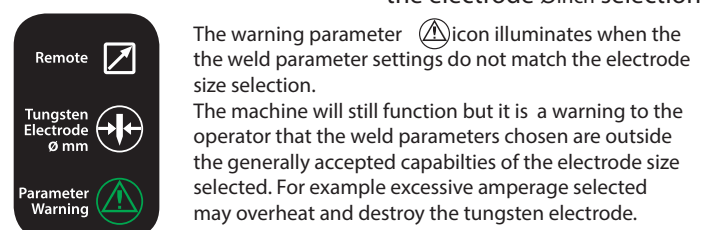
**Tungsten electrode Øinch** - for selection of Tungsten electrode and ARC electrode diameter



**Remote** - indicates remote control activation

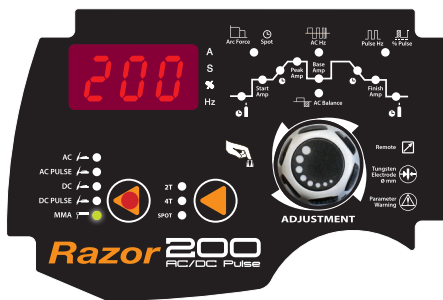




**Parameter Warning** - indicates weld parameters do not match the electrode Øinch selection

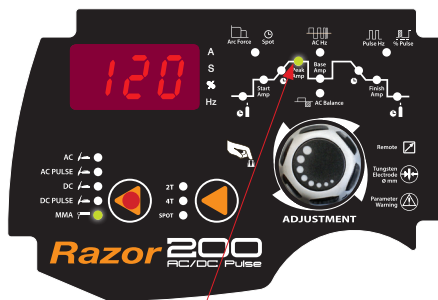


## ARC (Stick Electrode) Welding Setup and Operation

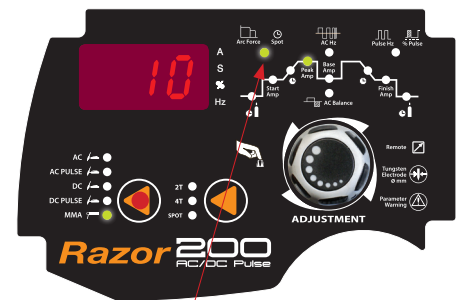
1. Connecting the Welding Lead Set: Various electrodes require a different polarity for optimum results refer to the electrode manufacturers information for the correct polarity. Most GP electrodes are electrode connected to  $\oplus$  output socket, Earth Connected to the  $\ominus$  output socket
2. Turn the power source on using the on/off switch located on the rear machine panel.




- (3) Select DC ARC Function. Push the  button until the DC  icon illuminates



- (4) Set the amperage by selecting the Peak Amp icon pressing the Encoder Knob until the Peak Amp icon illuminates. Turn the encoder knob to set the amperage according to the electrode type and size being used as recommended by the electrode manufacturer. The set amperage will show in the digital display panel.



- (5) Set the Arc Force by selecting the Arc Force icon pressing the Encoder Knob until the Arc Force icon illuminates.  Turn the encoder knob to set the Arc Force according to the electrode type and size being used. The set Arc Force will show in the digital display panel.

Refer to Page 12 for instruction and explanation on Arc Force Control



6) Connect the Earth Clamp securely to the work piece or the work bench.



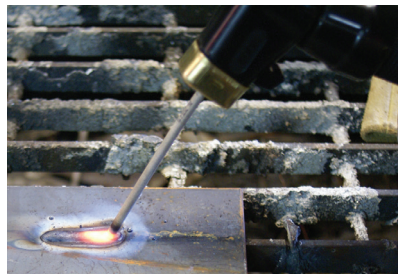
4) Place the electrode into the electrode holder and clamp tight.



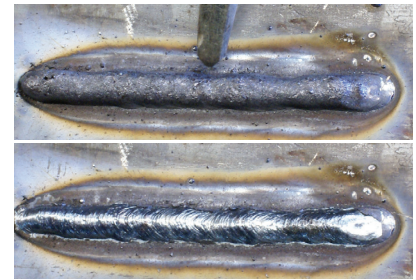
5) Strike the electrode against the work piece to create an arc and hold the electrode steady to maintain the arc



6) Hold the electrode slightly above the work piece to maintain the arc while travelling at an even speed to create an even weld deposition.



7) To finish the weld, break the arc by quickly snapping the electrode away from the work piece.



8) Wait for the weld to cool and carefully chip away the slag to reveal the weld metal below.

#### IMPORTANT NOTES - For ARC (Stick) Welding

##### ELECTRODE POLARITY - What is the electrode polarity and why is it important.

When using a DC power source, the question of whether to use electrode negative or positive polarity arises.

The first important point is that not all electrodes can be used with all polarities. Electrode manufacturer information and specifications such as BS EN ISO 2560:2005 and AWS A5.1-2004, define the polarity with which different electrodes may be used. The choice of polarity also depends on the type of the material and joint design. A welding procedure should specify the polarity to be used for the electrode choice and joint design.

**Direct current flows in one direction in an electrical circuit and the direction of current flow and the composition of the electrode coating will have a definite effect on the welding arc and weld bead. Refer to the electrode manufacturers recommendation for polarity choice.**

With DC electrode (+) positive (reverse) polarity, more heat is generated at the workpiece. This produces welds with deep penetration and a narrower weld bead and can reduce the incidence of lack-of-fusion defects in the weld.

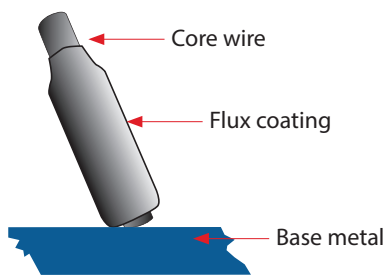
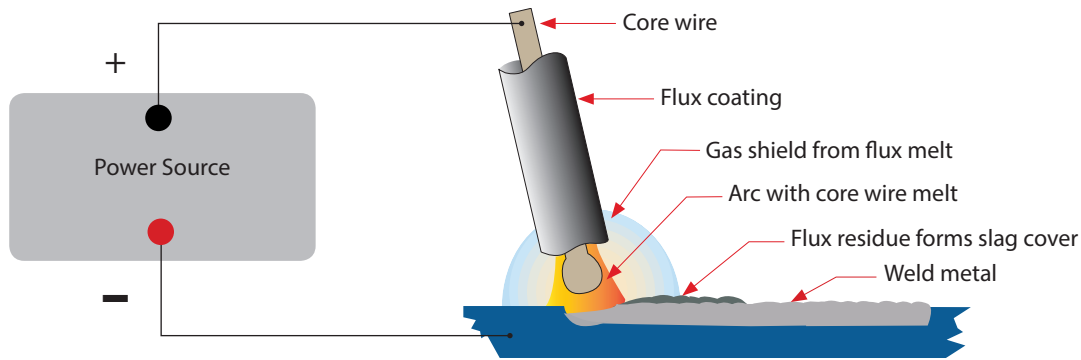
DC electrode (-) negative (straight) polarity generates more heat at the electrode and produces welds with shallower penetration. DC (-) negative electrode results in a higher burn off rate, and therefore a higher deposition rate at a given current. It is often used for welding thin sheet materials, or joints with poor fit-up, where more control of the weld pool is needed due to the increased risk of burn through.

##### ARC FORCE - What is the Arc Force Control and what does it do?

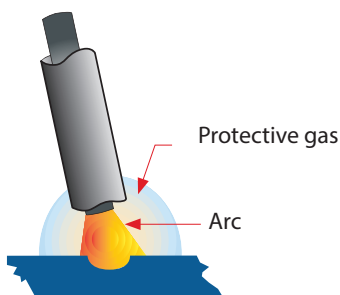
During welding arc voltage drops as the arc gets tighter and can cause the electrode to stick/short circuit to the work piece. Arc force should be set according to the electrode diameter, electrode type, welding current and the technical requirement. When you set the arc force high the machine senses the drop in voltage, as the electrode is about to stick/short circuit to the work piece the machine responds by increasing the arc voltage and welding current momentarily (per millisecond). This boost in arc voltage/current blasts away base metal and electrode to prevent the electrode from sticking itself to the work piece. High arc force means the molten droplet from the melting electrode is larger with quicker transition preventing the electrode from sticking, however too much arc force may create excessive spatter. Low arc force will result in a softer arc with minimal spatter and a nice shaped weld bead, however it may lead to the electrode sticking to the work piece easier, therefore the arc force should be adjusted to provide a smooth arc transition between the electrode and workpiece without it sticking and without providing excessive spatter. Higher Arc Force is more suited to thicker electrodes under low amperage settings, out of position welding, low hydrogen type electrodes where a forceful arc characteristic is preferred to maintain the arc and better control penetration. Lower Arc Force is better suited to hardfacing and cast Iron electrodes where a soft buttery arc is preferred to prevent the electrode material diluting too much with the base metal.



One of the most common types of arc welding is manual metal Arc welding (MMA) or stick welding. An electric current is used to strike an arc between the base material and a consumable electrode rod or 'stick'. The electrode rod is made of a material that is compatible with the base material being welded and is covered with a flux that gives off gaseous vapours that serve as a shielding gas and providing a layer of slag, both of which protect the weld area from atmospheric contamination. The electrode core itself acts as filler material the residue from the flux that forms a slag covering over the weld metal must be chipped away after welding.



- The arc is initiated by momentarily touching the electrode to the base metal.
- The heat of the arc melts the surface of the base metal to form a molten pool at the end of the electrode.
- The melted electrode metal is transferred across the arc into the molten pool and becomes the deposited weld metal.
- The deposit is covered and protected by a slag which comes from the electrode coating.
- The arc and the immediate area are enveloped by an atmosphere of protective gas



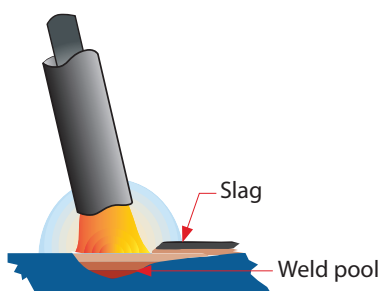
Manual metal arc (stick) electrodes have a solid metal wire core and a flux coating. These electrodes are identified by the wire diameter and by a series of letters and numbers. The letters and numbers identify the metal alloy and the intended use of the electrode.

The Metal Wire Core works as conductor of the current that maintains the arc. The core wire melts and is deposited into the welding pool.

The covering on a shielded metal arc welding electrode is called Flux. The flux on the electrode performs many different functions. These include:

- producing a protective gas around the weld area
- providing fluxing elements and deoxidizers
- creating a protective slag coating over the weld as it cools
- establishing arc characteristics
- adding alloying elements.

Covered electrodes serve many purposes in addition to adding filler metal to the molten pool. These additional functions are provided mainly by the covering on the electrode.



### Electrode Selection

As a general rule, the selection of an electrode is straight forward, in that it is only a matter of selecting an electrode of similar composition to the parent metal. However, for some metals there is a choice of several electrodes, each of which has particular properties to suit specific classes of work. It is recommended to consult your welding supplier for the correct selection of electrode.

### Electrode Size

Average Thickness of Material	Maximum Recommended Electrode Diameter
0.03 - 0.07 inches	0.09 inches
0.07 - 0.19 inches	0.12 inches
0.19 - 0.31 inches	0.15 inches
0.31 - > inches	0.19 inches

The size of the electrode generally depends on the thickness of the section being welded, and the thicker the section the larger the electrode required. The table gives the maximum size of electrodes that maybe used for various thicknesses of section base on using a general purpose type 6013 electrode.

### Welding Current (Amperage)

Electrode Size ø Inch	Current Range (Amps)
0.09	60 - 100
0.12	100 - 130
0.15	130 - 165
0.19	165 - 200

Correct current selection for a particular job is an important factor in arc welding. With the current set too low, difficulty is experienced in striking and maintaining a stable arc. The electrode tends to stick to the work, penetration is poor and beads with a distinct rounded profile will be deposited. Too high current is accompanied by overheating of the electrode resulting undercut and burning through of the base metal and producing

excessive spatter. Normal current for a particular job may be considered as the maximum, which can be used without burning through the work, over-heating the electrode or producing a rough spattered surface. The table shows current ranges generally recommended for a general purpose type 6013 electrode.

### Arc Length

To strike the arc, the electrode should be gently scraped on the work until the arc is established. There is a simple rule for the proper arc length; it should be the shortest arc that gives a good surface to the weld. An arc too long reduces penetration, produces spatter and gives a rough surface finish to the weld. An excessively short arc will cause sticking of the electrode and result in poor quality welds. General rule of thumb for down hand welding is to have an arc length no greater than the diameter of the core wire.

### Electrode Angle

The angle that the electrode makes with the work is important to ensure a smooth, even transfer of metal. When welding in down hand, fillet, horizontal or overhead the angle of the electrode is generally between 5 and 15 degrees towards the direction of travel. When vertical up welding the angle of the electrode should be between 80 and 90 degrees to the work piece.

### Travel Speed

The electrode should be moved along in the direction of the joint being welded at a speed that will give the size of run required. At the same time, the electrode is fed downwards to keep the correct arc length at all times. Excessive travel speeds lead to poor fusion, lack of penetration etc, while too slow a rate of travel will frequently lead to arc instability, slag inclusions and poor mechanical properties.

### Material and Joint Preparation

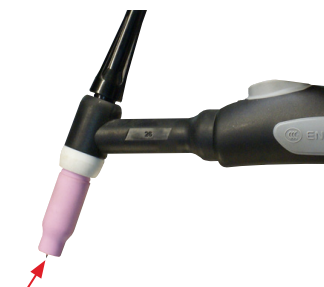
The material to be welded should be clean and free of any moisture, paint, oil, grease, mill scale, rust or any other material that will hinder the arc and contaminate the weld material. Joint preparation will depend on the method used include sawing, punching, shearing, machining, flame cutting and others. In all cases edges should be clean and free of any contaminants. The type of joint will be determined by the chosen application.

## DC HF TIG Welding Setup and Operation

1. Connect the TIG Torch connector to the negative terminal and tighten it.
2. Install the threaded connector into into the gas fitting
3. Connect the torch switch remote lead into the torch remote socket.
4. Connect the Earth Cable connector into the positive terminal and tighten it.
5. Connect gas line to Gas Regulator and connect the gas regulator to the Gas Cylinder. Slowly open the valve on the gas cylinder and set gas flow to the required rate.
6. Connect the gas line to the 5/8" threaded gas inlet at the rear of the machine. Check for gas leaks - JASIC Technologies America Inc nor it's representatives will be responsible for any gas loss.
8. Switch on the machine using the On/Off switch at the rear of the machine.
9. Set the weld parameters using the front panel set procedure on the following page.



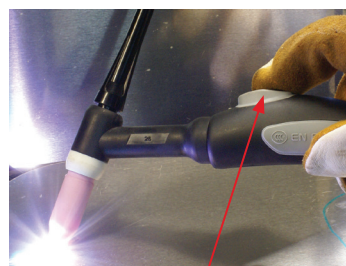
## Weld start procedure for HF DC TIG welding



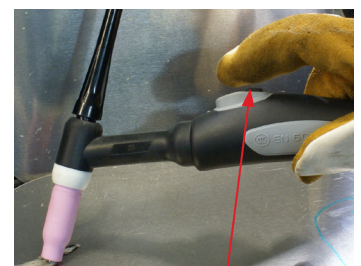
1. Assemble the front end torch parts use the correct size and type of tungsten electrode for the job, the tungsten electrode requires a sharpened point for DC welding



4. Lay the outside edge of the Gas Cup on the work piece with the Tungsten Electrode approx 1/16th of an inch from the work piece



5. Press the torch switch and the arc will ignite across the gap between the tungsten and work piece. Hold even distance of about 5/64th of an inch-gap between the tungsten and work piece to maintain the arc.





6. Release the torch switch to bring in the end of the welding sequence dependant of 2T or 4T trigger function choice

## Front panel set up procedure for basic HF DC TIG welding



### 1. Select DC TIG Function.



Select DC TIG by pressing the  button until the DC icon illuminates. Select 2T or 4T trigger function as required by the pushing the button  to cycle through the trigger options. The icon will illuminate for the selected trigger option.



### 2. Select Tungsten Diameter.



(2) Select the tungsten diameter required by pushing the encoder  repeatedly, cycle through to illuminate the Tungsten Electrode  icon. Set the size required by turning the encoder knob. The set size will appear in the digital display.



### 3. Set Pre-gas Time



Set the pre gas time by pushing the encoder  repeatedly, cycle through to illuminate the Pre Gas  icon. Set the time by turning the encoder knob. The set time will appear in the digital display



### 4. Set Start Amps



Set the Start Amps by pressing the encoder  to cycle through to illuminate the Start Amp  icon. Set the start amps by turning the encoder knob. The set start amps will appear in the digital display



### 5. Set Up Slope Time



Set the Up Slope by pressing the encoder  to cycle through to illuminate the Up Slope  icon. Set the up slope time by turning the encoder knob. The set up slope time will appear in the digital display



### 6. Set Welding Amperage



Set welding amps by pressing the encoder  to cycle through to illuminate the Peak Amp  icon. Set the amperage by turning the encoder knob. The set welding amperage will appear in the digital display



### 7. Set Down Slope Time



Set the down slope by pressing the encoder  to cycle through to illuminate the Down Slope  icon. Set the down slope time by turning the encoder knob. The set down slope time will appear in the digital display



### 8. Set Finish Amps

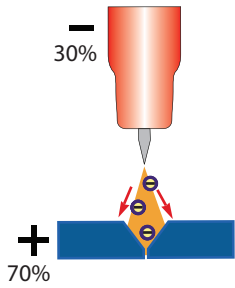


Set the finish amps by pressing the encoder  to cycle through to illuminate the Finish Amps  icon. Set the finish amps by turning the encoder knob. The set finish amps will appear in the digital display

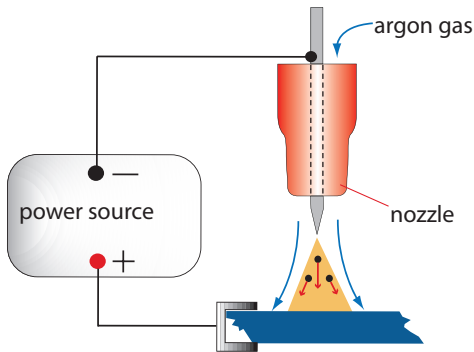
### 9. Set Post Gas Time



Set the post gas time by pressing the encoder  to cycle through to illuminate the Post Gas  icon. Set the post gas time by turning the encoder knob. The set post gas time will appear in the digital display

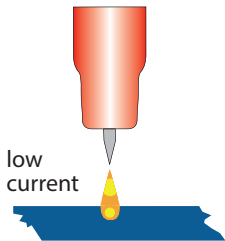


The DC power source uses what is known as DC (direct current) in which the main electrical component known as electrons flow in only one direction from the negative pole (terminal) to the positive pole (terminal). In the DC electrical circuit there is an electrical principle at work which should always be taken into account when using any DC circuit. With a DC circuit 70% of the energy (heat) is always on the positive side. This needs to be understood because it determines what terminal the TIG torch will be connected to (this rule applies to all the other forms of DC welding as well).

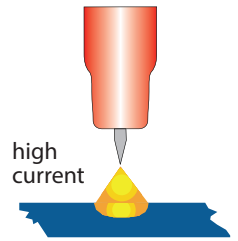


DC TIG welding is a process in which an arc is struck between a Tungsten electrode and the metal work piece. The weld area is shielded by an inert gas flow to prevent contamination of the tungsten, molten pool and weld area.

When the TIG arc is struck the inert gas is ionized and superheated changing its molecular structure which converts it into a plasma stream. This plasma stream flowing between the tungsten and the work piece is the TIG arc and can be as hot as 19,000°C. It is a very pure and concentrated arc which provides the controlled melting of most metals into a weld pool. TIG welding offers the user the greatest amount of flexibility to weld the widest range of material and thickness and types. DC TIG welding is also the cleanest weld with no sparks or spatter.

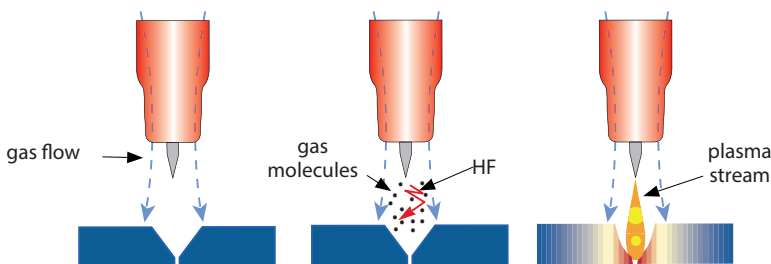


The intensity of the arc is proportional to the current that flows from the tungsten. The welder regulates the welding current to adjust the power of the arc. Typically thin material requires a less powerful arc with less heat to melt the material so less current (amps) is required, thicker material requires a more powerful arc with more heat so more current (amps) are necessary to melt the material.



### HF ARC IGNITION for TIG (tungsten inert gas) Welding

HF (high frequency) ignition allows the arc to be started in Tig welding without touching the tungsten to the work piece. By pressing the torch switch the machine will activate the gas flow and introduce the HF (high frequency) (high voltage) spark, this "ionizes" the air gap making it conductive allowing an arc to be created without touching the tungsten to the work piece. The gas molecules are superheated by the arc creating a stream of super heated gas that changes the molecular structure into producing a plasma stream. This plasma stream provides heat and energy that allows us to melt and fuse metals in an inert gas shielded environment know as TIG (tungsten inert gas) welding.



Pulse TIG welding is when the current output (amperage) changes between high and low current. Electronics within the welding machine create the pulse cycle. Welding is done during the high-amperage interval (this high amperage is referred to as peak current). During the low amperage period, the arc is maintained but the current output of the arc is reduced (this low amperage is referred to as base current). During pulse welding the weld pool cools during the low amperage period. This allows a lower overall heat input into the base metal. It allows for controlled heating and cooling periods during welding providing better control of heat input, weld penetration, operator control and weld appearance.

There are 4 variables within the pulse cycle:

Peak Current - Base Current - Pulse Frequency - Pulse Width

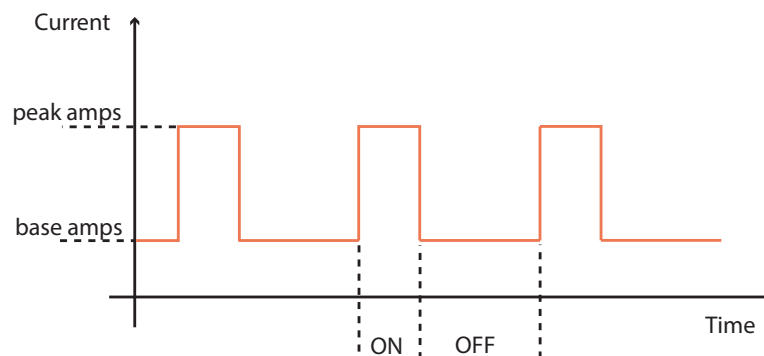
Setting and manipulation of these variables will determine the nature of the weld current output and is at the discretion of the operator.

Peak Current is the main welding current (amps) set to melt the material being welded and works much the same as setting maximum amperage values for regular DC TIG: as a guide use 30-40 amps for every 1mm of material thickness.

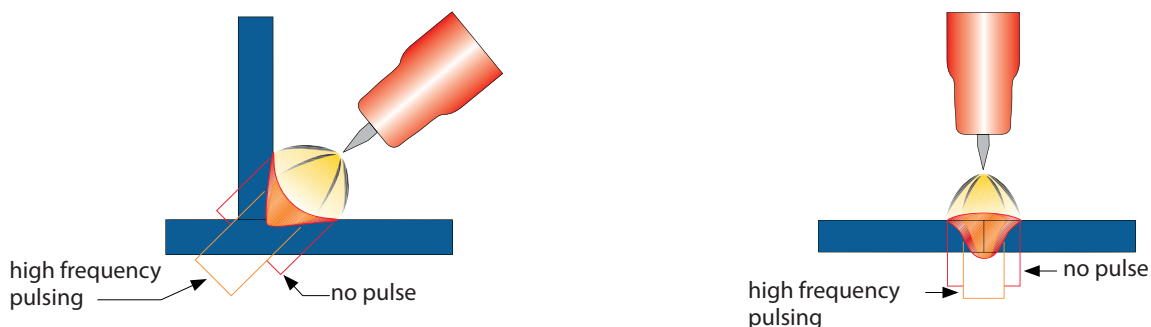
Base Current is the set level of background current (amps) which cools the weld puddle and affects overall heat input. As a rule, use enough background current to reduce the weld pool to about half its normal size while still keeping the weld pool fluid. As a guide start by setting the background amperage at 20 to 30 percent of peak amperage.

Pulse Frequency is the control of the amount of times per second (Hz) that the welding current switches from Peak Current to Base Current. DC Pulse TIG frequency generally ranges from 20 to 220 HZ depending on the job application. Control of the pulse frequency also determines the appearance of the weld.

Pulse Width is the control of the percentage of time during one pulsing cycle the power source spends at the peak current (main amperage). Example is with the Pulse Width set at 80 percent, the machine will spend 80% of the pulse at peak amperage and 20% at the base amperage. Increasing the pulse width percentage adds more heat to the job, while decreasing pulse width percentage reduces heat



DC Pulse TIG welding allows faster welding speeds with better control of the heat input to the job, reducing the heat input minimising distortion and warping of the work and is of particular advantage in the welding of thin stainless steel and carbon steel applications. The high pulse frequency capability of the advanced inverter agitates the weld puddle and allows you to move quickly without transferring too much heat to the surrounding metal. Pulsing also constricts and focuses the arc thus increasing arc stability, penetration and travel speeds.



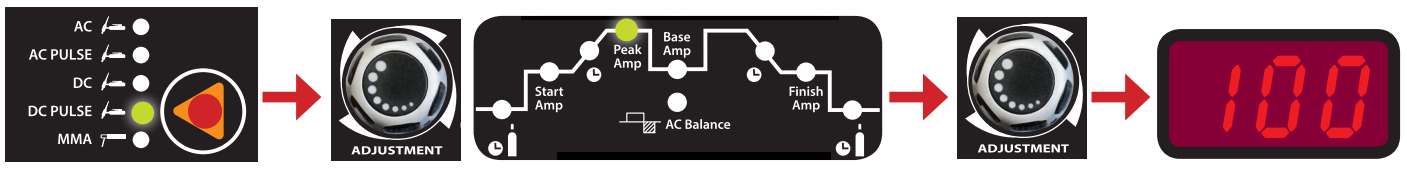
### DC Pulse TIG Welding Set Up Procedure

The Razorweld 200 machine has digital pulse frequency control. All the parameters for DC Pulse Tig welding - Peak Amp, Base Amp, Pulse Frequency and Pulse Width are easy to set via the digital control panel.


#### EXAMPLE OF PULSE DC TIG WELDING - SETUP PARAMETERS:

Material = Stainless Steel x 0.09 / Tungsten Electrode = 0.063 2% Thoriated / Gas = Argon

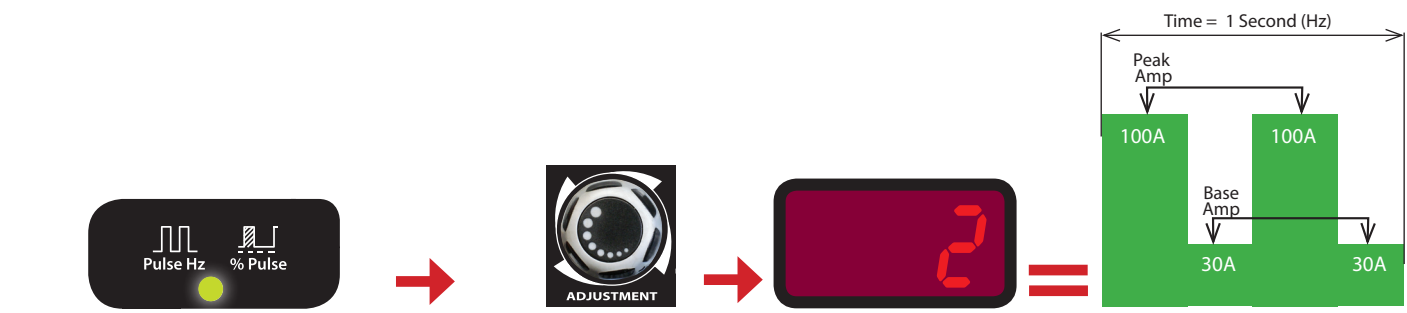
The following steps are a guide as a starting point for you to set the machine up in Pulse mode to give an example of welding in Pulse mode function. You can experiment by changing any of the variables to see what effect it has over the welding and what the end result can be, but it is suggested to change only one variable at a time and then check the welding to see what the result is, in this way you acquire a better understanding of how each variable affects the welding current.



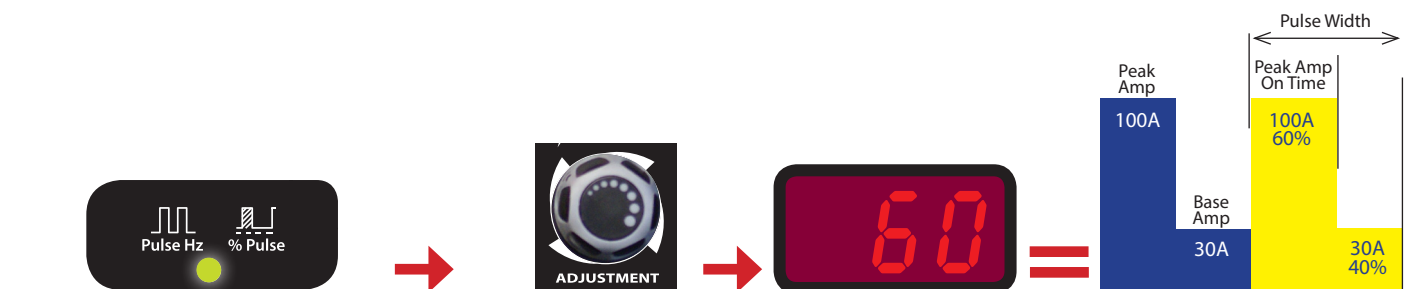
1. Select DC Pulse by pushing selector button to cycle through to illuminate DC Pulse icon.
2. Select Peak Amp by pressing the encoder knob to cycle through to illuminate the Peak Amp Icon
3. Rotate the Encoder Knob to set the Peak Amp at 100A, it will show in the digital display. (Range is 5-200 Amps)



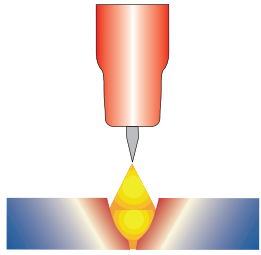
4. Select the Base Amp by pushing the encoder knob to cycle through to illuminate the Base Amp Icon
5. Rotate the Encoder Knob to set the Base Amp at 30A - (Range is 5-200 Amps)



6. Select the Pulse Frequency by pushing the encoder knob to cycle through to illuminate the Pulse Hz Icon
7. Rotate the Adjustment Encoder Knob to set the Pulse Frequency to 2 Hz - (0.5 - 200Hz)

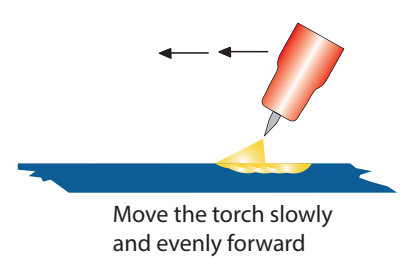
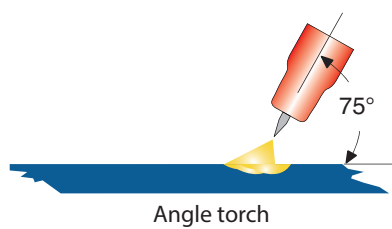
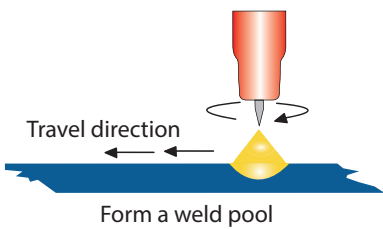


8. Select the Pulse Width (on time of the Peak Amp) by pushing the selector button to cycle through to illuminate the % Pulse Icon
9. Rotate the Adjustment Encoder Knob to set the Pulse Width at 60% - (Range is 10 - 90%).

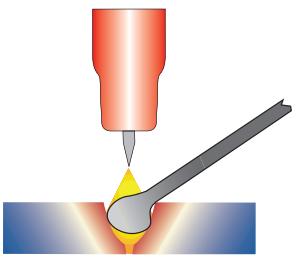


Manual TIG welding is often considered the most difficult of all the welding processes. Because the welder must maintain a short arc length, great care and skill are required to prevent contact between the electrode and the workpiece. Similar to Oxygen Acetylene torch welding, TIG welding normally requires two hands and in most instances requires the welder to manually feed a filler wire into the weld pool with one hand while manipulating the welding torch in the other. However, some welds combining thin materials can be accomplished without filler metal like edge, corner, and butt joints.

This is known as Fusion welding where the edges of the metal pieces are melted together using only the heat and arc force generated by the TIG arc. Once the arc is started the torch tungsten is held in place until a weld pool is created, a circular movement of the tungsten will assist in creating a weld pool of the desired size. Once the weld pool is established tilt the torch at about a 75° angle and move smoothly and evenly along the joint while fusing the materials together.

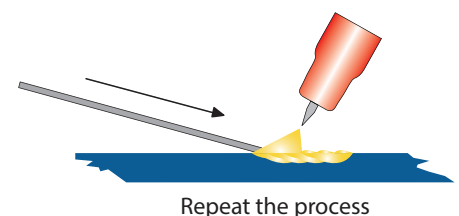
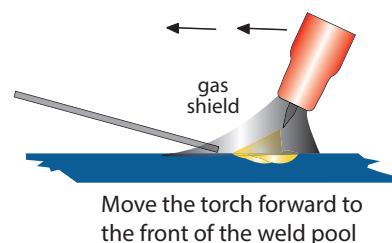
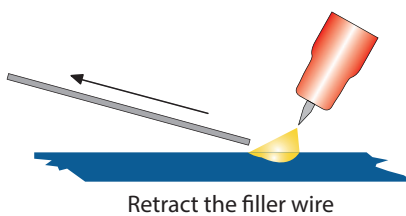
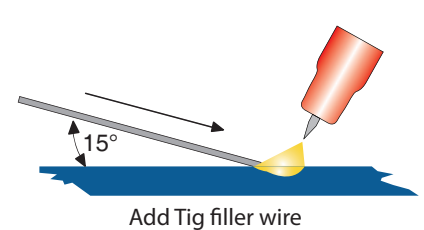
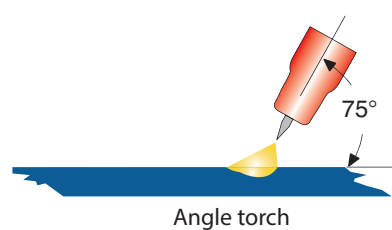
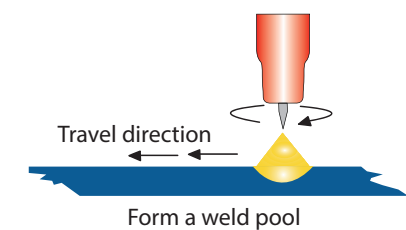


### TIG Welding with Filler Wire Technique



It is necessary in many situations with TIG welding to add a filler wire into the weld pool to build up weld reinforcement and create a strong weld. Once the arc is started the torch tungsten is held in place until a weld pool is created, a circular movement of the tungsten will assist in creating a weld pool of the desired size. Once the weld pool is established tilt the torch at about a 75° angle and move smoothly and evenly along the joint. The filler metal is introduced to the leading edge of the weld pool. The filler wire is usually held at about a 15° angle and fed into the leading edge of the molten pool, the arc will melt the filler wire into the weld pool as the torch is moved forward.

Also a dabbing technique can be used to control the amount of filler wire added, the wire is fed into the molten pool and retracted in a repeating sequence as the torch is moved slowly and evenly forward. It is important during the welding to keep the molten end of the filler wire inside the gas shield as this protects the end of the wire from being oxidised and contaminating the weld pool.





## AC HF TIG Welding Setup and Operation

1. Connect the TIG Torch connector to the negative terminal and tighten it.
2. Insert the torch gas connector into the quick lock gas receptacle.
3. Connect the torch switch remote lead into the torch remote socket.
4. Connect the Earth Cable connector into the positive terminal and tighten it.
5. Connect gas line to Gas Regulator and connect the gas regulator to the Gas Cylinder. Slowly open the valve on the gas cylinder and set gas flow to the required rate.
6. Connect the gas line to the quick lock gas inlet connector at the rear of the machine. Check for gas leaks - JASIC Technologies America Inc nor it's representatives will be responsible for any gas loss.
8. Switch on the machine using the On/Off switch at the rear of the machine.
9. Set the weld parameters using the front panel set procedure on the following page.



6. Connect the gas line to the 5/8" gas threaded socket at the rear of the machine

5. Connect the regulator to the cylinder, Connect the gas lead to the regulator. Set the flow to 5-25 CFH \* Depending on Application

(1) Turn on the machine using the ON/OFF switch at the rear of machine

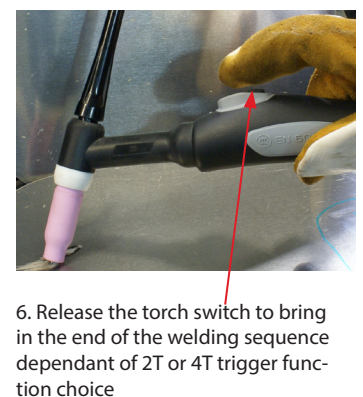
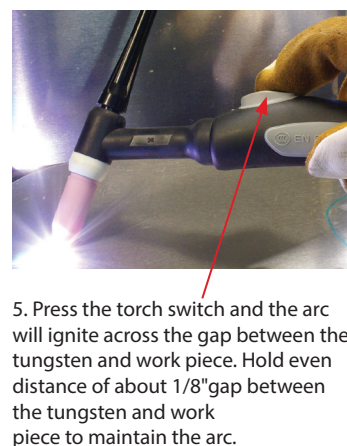
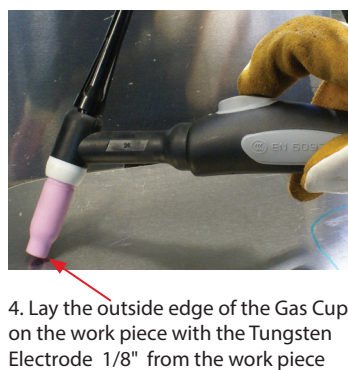
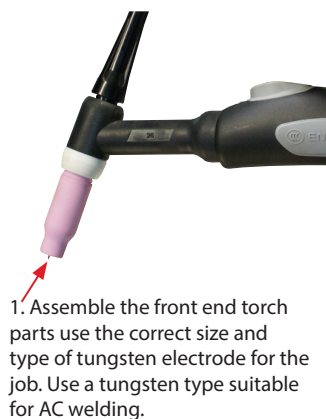
2. Install the threaded connector into into the gas fitting

1. Connect the TIG torch connector to the (-) terminal.

4. Connect the Earth cable connector to the (+) terminal

3. Connect the torch switch lead to the torch remote receptacle



## Weld start procedure for HF AC TIG welding



## Front panel set up procedure for basic AC HF TIG welding



### 1. Select AC TIG Function.



Select AC TIG by pressing the  button until the AC icon illuminates. Select 2T or 4T trigger function as required by the pushing the button  to cycle through the trigger options. The icon will illuminate for the selected trigger option.



### 2. Select Tungsten Diameter.



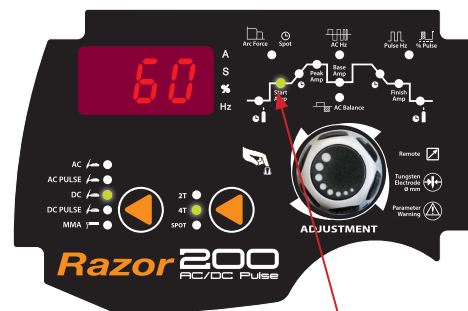
(2) Select the tungsten diameter required by pushing the encoder  repeatedly, cycle through to illuminate the Tungsten Electrode  icon. Set the size required by turning the encoder knob. The set size will appear in the digital display.


### 3. Set Pre-gas Time



Set the pre gas time by pushing the encoder  repeatedly, cycle through to illuminate the Pre Gas icon.  Set the time by turning the encoder knob. The set time will appear in the digital display



### 4. Set Start Amps



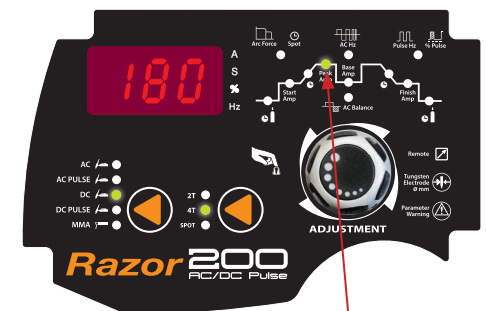
Set the Start Amps by pressing the encoder  to cycle through to illuminate the Start Amp icon. Set the start amps by turning the encoder knob. The set start amps will appear in the digital display


### 5. Set Up Slope Time



Set the Up Slope by pressing the encoder  to cycle through to illuminate the Up Slope  icon. Set the up slope time by turning the encoder knob. The set up slope time will appear in the digital display



### 6. Set Welding Amperage



Set welding amps by pressing the encoder  to cycle through to illuminate the Peak Amp icon. Set the amperage by turning the encoder knob. The set welding amperage will appear in the digital display



### 7. Set AC Square Wave Frequency (AC Hz)



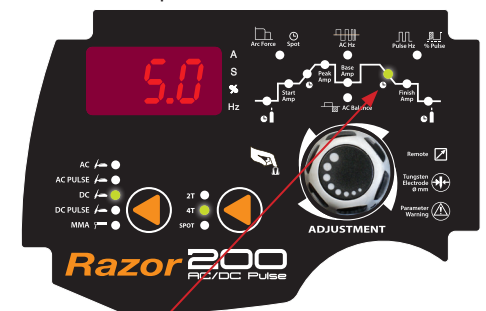
Set the AC Hz by pressing the encoder  cycle through to illuminate the AC Hz  icon. Set the AC Hz by turning the encoder knob. The set AC Hz will appear in the digital display



### 8. Set AC Balance



Set the AC Balance by pressing the encoder  to cycle through to illuminate the AC Balance  icon. Set the AC Balance by turning the encoder knob. The set AC balance will appear in the digital display

### 9. Set Down Slope Time



Set the down slope by pressing the encoder  to cycle through to illuminate the Down Slope  icon. Set the down slope time by turning the encoder knob. The set down slope time will appear in the digital display

continued - Front panel set up procedure for basic AC TIG welding

10. Set Finish Amps



Set the finish amps by pressing the encoder to cycle through to illuminate the Finish Amps icon. Set the finish amps by turning the encoder knob. The set finish amps will appear in the digital display

11. Set Post Gas Time



Set the post gas time by pressing the encoder to cycle through to illuminate the Post Gas Time icon. Set the post gas time by turning the encoder knob. The set post gas time will appear in the digital display

AC TIG Welding - AC Square Wave Frequency Control

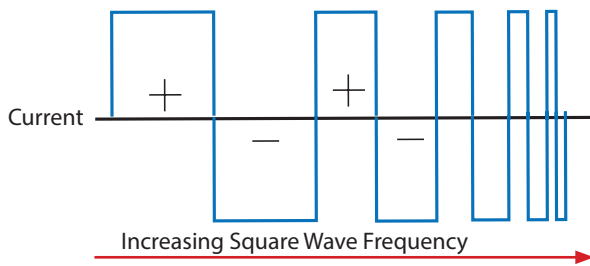
It is possible with the RAZOR200ACDC machine to adjust the frequency of the AC Square Wave output. It means that the amount of time that it takes the AC square wave to complete a full cycle switch from positive (+) to negative (-) can be adjusted from 20Hz (20 times per second) to 200Hz

Increasing frequency (Hz) causes the current to change direction more often, which means that it spends less time per cycle in both DC electrode negative and DC electrode positive mode. By spending less time at each polarity, the arc cone has less time to expand.

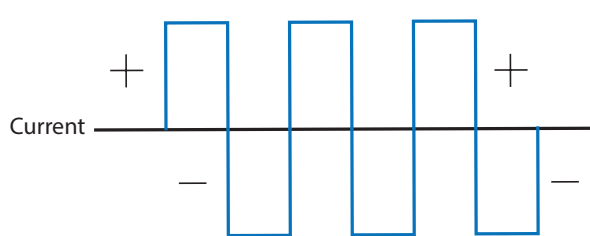
A higher frequency produces a narrower arc cone producing an arc that is tighter with more focus at the exact spot the electrode is pointing. The result is improved arc stability, ideal for fillet welds and other fit ups requiring precise penetration.

Decreasing the frequency softens the arc and broadens the weld pool producing a wider bead, produces good overall penetration and ideal for build up applications.

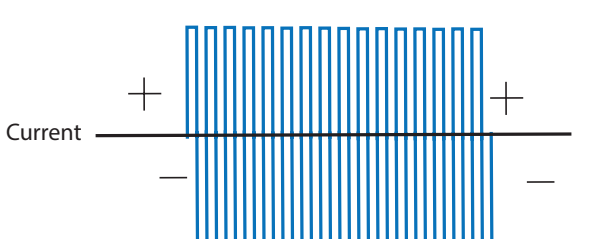
AC Square Wave Hz



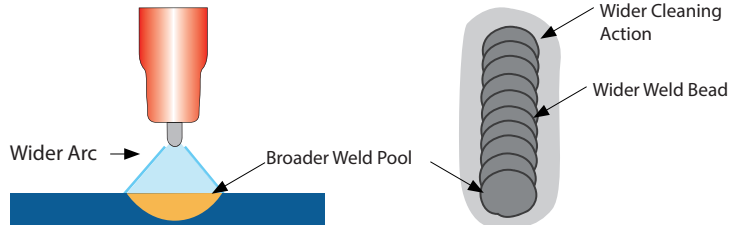
Slower AC Square Wave Hz



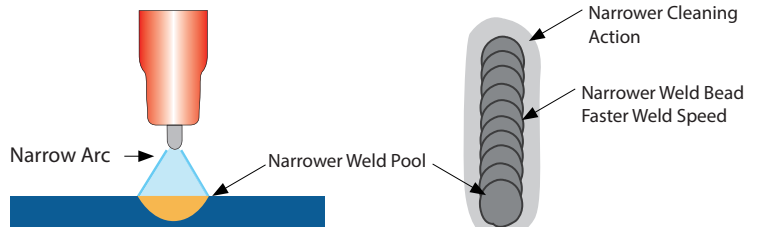
Faster AC Square Wave Hz



Slower AC Square Wave Hz

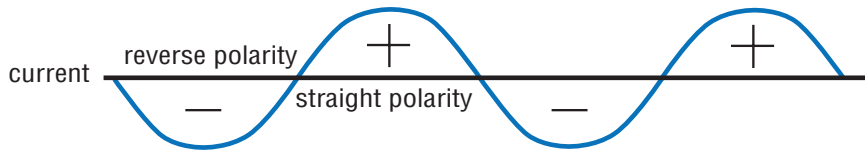


Faster AC Square Wave Hz



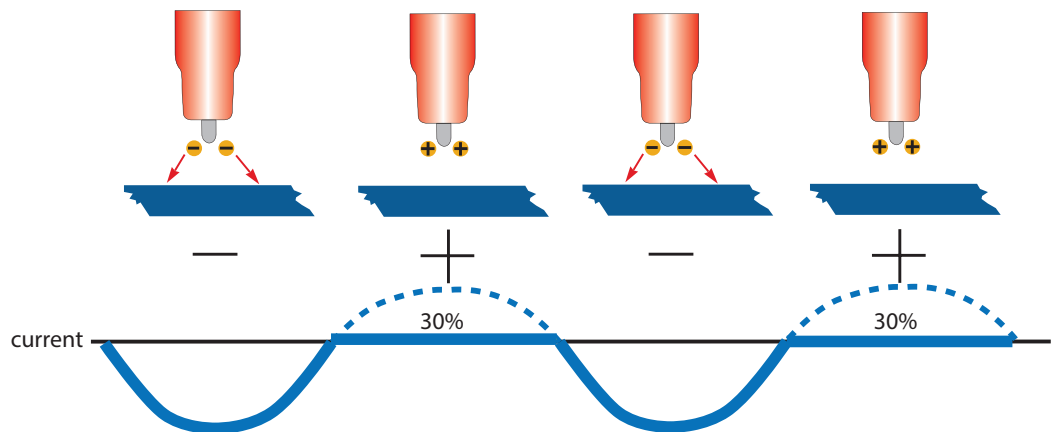
AC (alternating current) enables us to TIG weld non ferrous alloys like Aluminum, Magnesium and Aluminum Alloys. These materials have an insulating surface oxide layer that melts at a higher temperature than the base metal making it difficult to weld the base metal if the oxides are not removed. AC welding current is ideal because the nature of the AC wave form assists in breaking the surface oxide layer.

AC (alternating current) has a current cycle that flows from + (direct) polarity to - (reverse) polarity. The reversing of the polarity breaks the surface oxide while the direct polarity melts the base material.

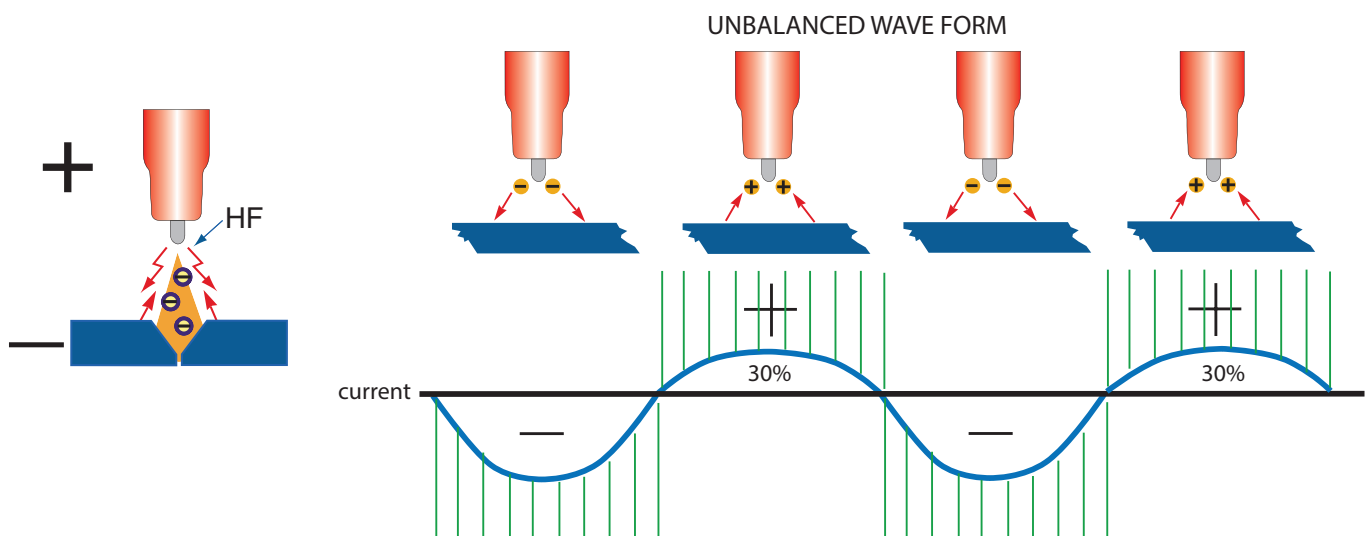


There are inherent problems that come with AC TIG arc rectification, arc stutter, arc wandering and arc stoppage. These problems typically occur during the transition between + and - cycles.

The current is less (30%) during the half of the cycle when the electrode is positive and there is a resistance of the electron flow during this half cycle (rectification). The lack of current flow during this half cycle makes the AC arc unstable.

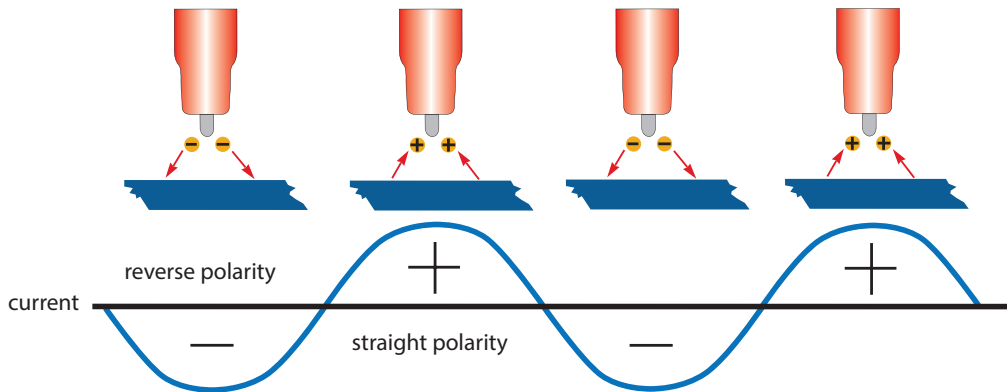


To overcome this lack of flow during one half of the cycle, a high-frequency (HF) voltage is generated and fed into the welding circuit. The HF maintains the arc stability during the half cycle when the electrode is positive.

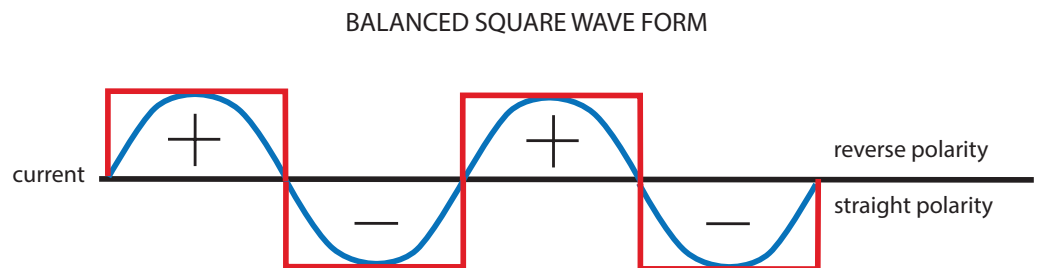
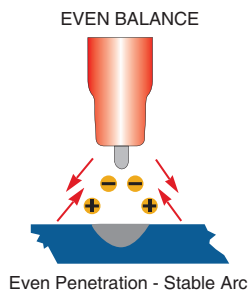


High-frequency voltage flows continually in the welding circuit and keeps the shielding arc in the welding area in an ionized state. When the arc is ionized the arc is maintained during the half of the cycle when the electrode is positive. However while the arc is maintained less current flows during this half of the AC cycle, producing an unbalanced wave.

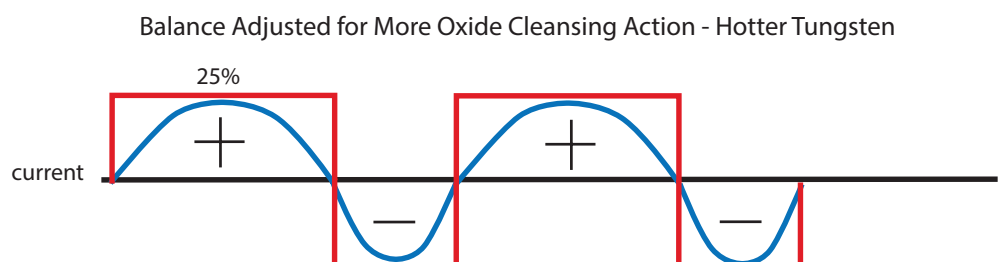
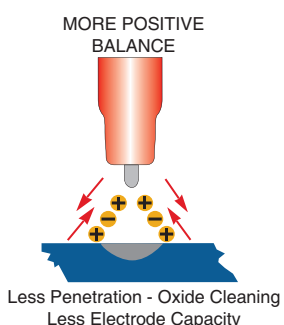
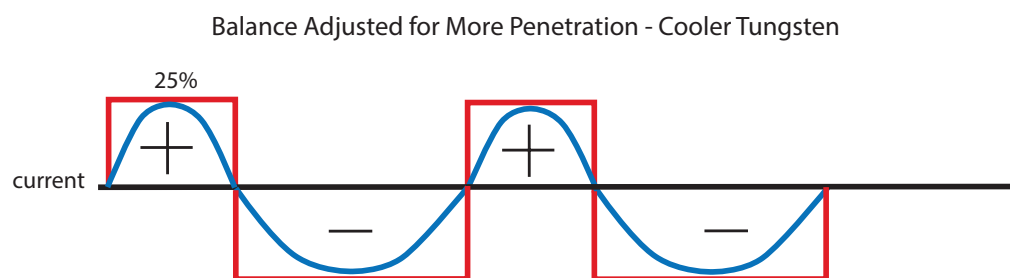
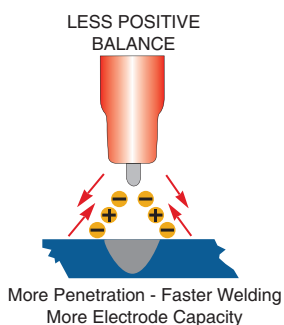
In older machines, a balanced current output wave was achieved using a large number of capacitors in series or a battery in the welding circuit. Modern TIG power sources use electronics to create and maintain a balanced wave and now most AC TIG power sources produce a square wave current output.



A square wave power supply can change the current from electrode + positive to electrode - negative very quickly. This produces high voltage as the current switches polarities allowing the arc to restart easily. The arc can be maintained without the use of high-frequency or any other arc stabilising methods.



The output current and voltage are controlled electronically so the balance between the amount of current electrode positive and the amount of current electrode negative can be adjusted. This allows the welder to adjust the amount of cleaning and the amount of penetration. This is achieved electronically by adjusting the balance control dial on the welding machine. More current flow from the + polarity produces stronger arc energy and current flow from the tungsten and is good for removing the oxidized surface of the work piece. However too much + current flow can drive too much energy to the tungsten causing it to overheat and melt the tungsten electrode.



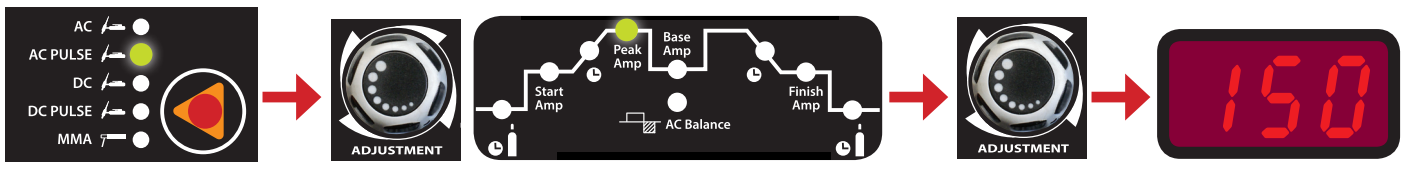
### AC Pulse Welding Set Up Procedure

The Razorweld 200ACDC machine has digital Pulse Frequency Control. All the parameters for AC Pulse TIG welding - Peak Amp, Base Amp, Pulse Frequency and Pulse Width are easy to set via the digital control panel.

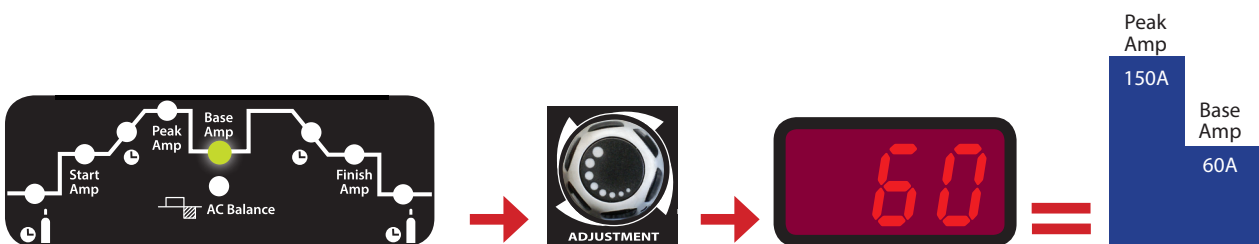
#### EXAMPLE OF PULSE AC TIG WELDING - SETUP PARAMETERS:

Material = Aluminum x 3/32" / Tungsten Electrode = 0.09 Zirconiated / Gas = Argon

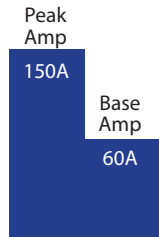
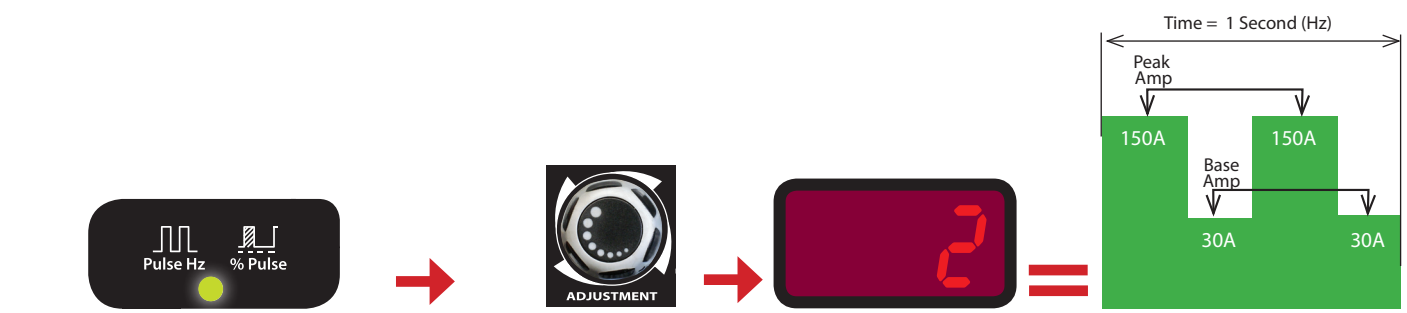
The following steps are a guide as a starting point for you to set the machine up in Pulse mode to give an example of welding in Pulse mode function. You can experiment by changing any of the variables to see what effect it has over the welding and what the end result can be, but it is suggested to change only one variable at a time and then check the welding to see what the result is, in this way you acquire a better understanding of how each variable affects the welding current.



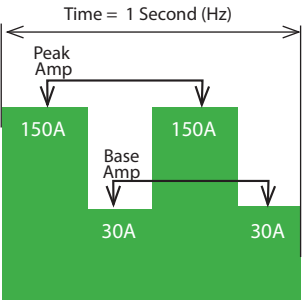
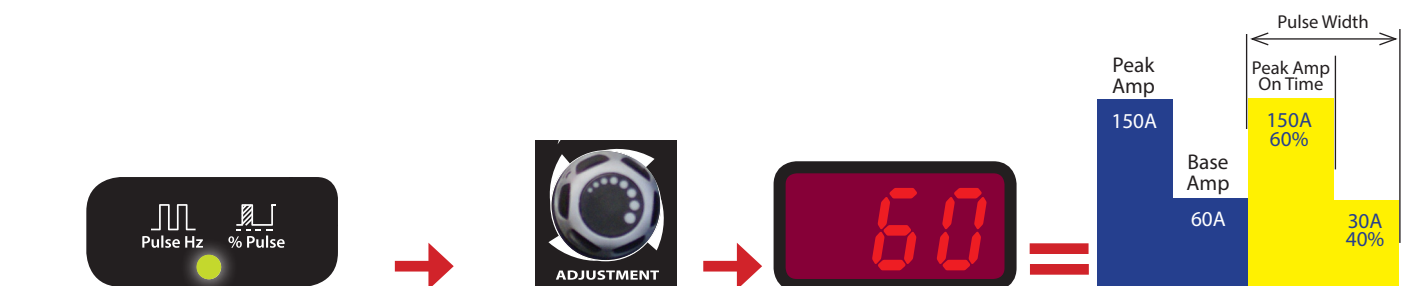
1. Select AC Pulse by pushing selector button to cycle through to illuminate AC Pulse icon.
2. Select Peak Amp by pressing the encoder knob to cycle through to illuminate the Peak Amp Icon
3. Rotate the Encoder Knob to set the Peak Amp at 150A, it will show in the digital display. (Range is 5-200 Amps)



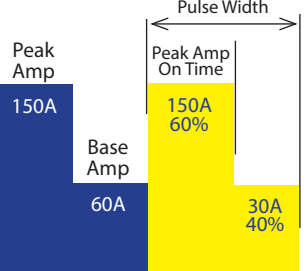
4. Select the Base Amp by pushing the encoder knob to cycle through to illuminate the Base Amp Icon
5. Rotate the Encoder Knob to set the Base Amp at 60A - (Range is 5-200 Amps)

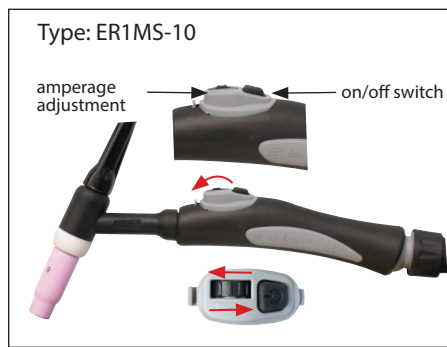
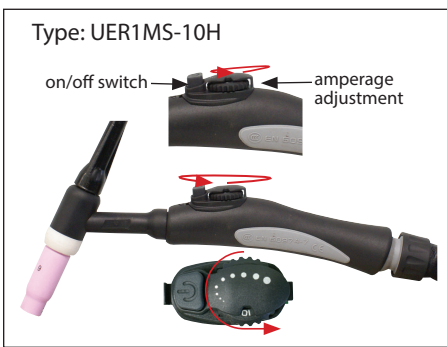
6. Select the Pulse Frequency by pushing the encoder knob to cycle through to illuminate the Pulse Hz Icon
7. Rotate the Adjustment Encoder Knob to set the Pulse Frequency to 2 Hz - (0.5 - 200Hz)

8. Select the Pulse Width (on time of the Peak Amp) by pushing the selector button to cycle through to illuminate the % Pulse Icon
9. Rotate the Adjustment Encoder Knob to set the Pulse Width at 60% - (Range is 10 - 90%).



Remote amperage controls allow remote welding current adjustment from the welding machine during welding.




### Connection and operation of the remote hand control



1. Connect the remote control 5 pin plug from the TIG Torch switch lead to the 5 pin remote receptacle on the front panel of the machine.



2. Select 4T trigger function by pushing the  button to cycle through until the 4T icon illuminates as the chosen option.



3. Activate the remote control. Press and hold the torch switch for 5 second until the machine beeps to indicate the remote function has activated. Repeat the procedure to de-activate the remote control.



(4) The thermal LED will illuminate Green to indicate the machine is in remote control mode. Note: The machine will default to non-remote mode when switched off.



5. Rotate the Remote Control Knob to adjust the amperage output of the machine. The remote can be used static or during welding to adjust the amps up or down.




6. The amps set by the remote control will show in the Digital Display of the machine.

### Connection and operation of the remote foot control



1. Connect the remote control 5 pin plug from the Tig Torch switch lead to the 5 pin remote receptacle on the front panel of the machine.



2. Select 2T trigger function by pushing the  button to cycle through until the 2T icon illuminates



3. Activate by holding down the foot pedal for 5 seconds, the remote icon will illuminate. Up & down travel of the foot pedal will adjust the welding amperage during welding. Note spot function does NOT work when power source is in remote!



Tungsten is a rare metallic element used for manufacturing TIG welding electrodes. The TIG process relies on tungsten's hardness and high-temperature resistance to carry the welding current to the arc. Tungsten has the highest melting point of any metal, 3,410 degrees Celsius.

Tungsten electrodes are nonconsumable and come in a variety of sizes, they are made from pure tungsten or an alloy of tungsten and other rare earth elements. Choosing the correct tungsten depends on the material being welded, the amount of amps required and whether you are using AC or DC welding current.

Tungsten electrodes are colour-coded at the end for easy identification.

Below are the most commonly used tungsten electrodes found in the World Market

## Thoriated

Thoriated tungsten electrodes (AWS classification EWTh-2) contain a minimum of 97.30 percent tungsten and 1.70 to 2.20 percent thorium and are called 2 percent thoriated. They are the most commonly used electrodes today and are preferred for their longevity and ease of use. Thorium increases the electron emission qualities of the electrode, which improves arc starts and allows for a higher current-carrying capacity. This electrode operates far below its melting temperature, which results in a considerably lower rate of consumption and eliminates arc wandering for greater stability. Compared with other electrodes, thoriated electrodes deposit less tungsten into the weld puddle, so they cause less weld contamination.

Thorium however is a low-level radioactive hazard and many users have switched to other alternatives. Regarding the radioactivity, thorium is an alpha emitter but when it is enclosed in a tungsten matrix the risks are negligible. Thus holding a stick of Thoriated tungsten in your hand should not pose a great threat unless a welder has open cuts on their skin. Thoriated tungsten should not get in contact with open cuts or wounds. The more significant danger to welders can occur when thorium oxide gets into the lungs. This can happen from the exposure to vapours during welding or from ingestion of material/dust in the grinding of the tungsten. Follow the manufacturer's warnings, instructions, and the Material Safety Data Sheet (MSDS) for its use.

## Ceriated (Color Code: Orange)

Ceriated tungsten electrodes (AWS classification EWCe-2) contain a minimum of 97.30 percent tungsten and 1.80 to 2.20 percent cerium and are referred to as 2 percent ceriated. Ceriated tungstens perform best in DC welding at low current settings. They have excellent arc starts at low amperages and become popular in such applications as orbital tube welding, thin sheet metal work. They are best used to weld carbon steel, stainless steel, nickel alloys, and titanium, and in some cases it can replace 2 percent thoriated electrodes. Ceriated tungsten is best suited for lower amperages it should last longer than Thoriated tungsten higher amperage applications are best left to Thoriated or Lanthanated tungsten.

## Lanthanated (Color Code: Gold)

Lanthanated tungsten electrodes (AWS classification EWLa-1.5) contain a minimum of 97.80 percent tungsten and 1.30 percent to 1.70 percent lanthanum, and are known as 1.5 percent lanthanated. These electrodes have excellent arc starting, a low burn off rate, good arc stability, and excellent re-ignition characteristics. Lanthanated tungstens also share the conductivity characteristics of 2 percent thoriated tungsten. Lanthanated tungsten electrodes are ideal if you want to optimise your welding capabilities. They work well on AC or DC electrode negative with a pointed end, or they can be balled for use with AC sine wave power sources. Lanthanated tungsten maintains a sharpened point well, which is an advantage for welding steel and stainless steel on DC or AC from square wave power sources.

## Zirconiated (Color Code: White)

Zirconiated tungsten electrodes (AWS classification EWZr-1) contain a minimum of 99.10 percent tungsten and 0.15 to 0.40 percent zirconium. Most commonly used for AC welding Zirconiated tungsten produces a very stable arc and is resistant to tungsten spitting. It is ideal for AC welding because it retains a balled tip and has a high resistance to contamination. Its current-carrying capacity is equal to or greater than that of thoriated tungsten. Zirconiated tungsten is not recommended for DC welding.

## Tungsten Electrodes Rating for Welding Currents

Tungsten Diameter inch/mm	DC Current Amps Torch Negative 2% Thoriated	AC Current Amps Un-Balanced Wave 0.8% Zirconiated	AC Current Amps Balanced Wave 0.8% Zirconiated
3/64" (0.040")	15 - 80	15 - 80	20 - 60
1/16" (.062" & .060")	70 - 150	70 - 150	60 - 120
3/32" (.93")	150 - 250	140 - 235	100 - 180
1/8" (.125")	250 - 400	225 - 325	160 - 250
5/32" (.156")	400 - 500	300 - 400	200 - 320



Always use DIAMOND wheels when grinding and cutting. While tungsten is a very hard material, the surface of a diamond wheel is harder, and this makes for smooth grinding. Grinding without diamond wheels, such as aluminum oxide wheels, can lead to jagged edges, imperfections, or poor surface finishes not visible to the eye that will contribute to weld inconsistency and weld defects.

Always ensure to grind the tungsten in a longitudinal direction on the grinding wheel. Tungsten electrodes are manufactured with the molecular structure of the grain running lengthwise and thus grinding crosswise is "grinding against the grain." If electrodes are ground crosswise, the electrons have to jump across the grinding marks and the arc can start before the tip and wander. Grinding longitudinally with the grain, the electrons flow steadily and easily to the end of the tungsten tip. The arc starts straight and remains narrow, concentrated, and stable.



## Electrode Tip/Flat

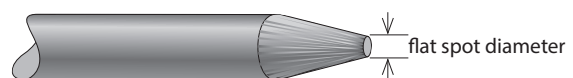
The shape of the tungsten electrode tip is an important process variable in precision arc welding. A good selection of tip/flat size will balance the need for several advantages. The bigger the flat, the more likely arc wander will occur and the more difficult it will be to arc start. However, increasing the flat to the maximum level that still allows arc start and eliminates arc wander will improve the weld penetration and increase the electrode life. Some welders still grind electrodes to a sharp point, which makes arc starting easier. However, they risk decreased welding performance from melting at the tip and the possibility of the point falling off into the weld pool.



## Electrode Included Angle/Taper - DC Welding

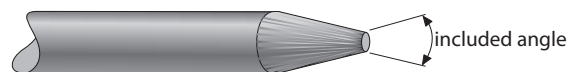
Tungsten electrodes for DC welding should be ground longitudinally and concentrically with diamond wheels to a specific included angle in conjunction with the tip/flat preparation. Different angles produce different arc shapes and offer different weld penetration capabilities. In general, blunter electrodes that have a larger included angle provide the following benefits:

- Last Longer
- Have better weld penetration
- Have a narrower arc shape
- Can handle more amperage without eroding.



Sharper electrodes with smaller included angle provide:

- Offer less arc weld
- Have a wider arc
- Have a more consistent arc



The included angle determines weld bead shape and size. Generally, as the included angle increases, penetration increases and bead width decreases.

Tungsten Diameter	Diameter at the Tip - mm	Constant Included Angle - Degrees	Current Range Amps	Current Range Pulsed Amps
3/64" (.040")	.250	20	05 - 30	05 - 60
1/16" (.062" & .060")	.500	25	08 - 50	05 - 100
1/16" (.062" & .060")	.800	30	10 - 70	10 - 140
3/32" (.93")	.800	35	12 - 90	12 - 180
3/32" (.93")	1.100	45	15 - 150	15 - 250
1/8" (.125")	1.100	60	20 - 200	20 - 300
1/8" (.125")	1.500	90	25 - 250	25 - 350



## Standard Front End Parts

Torch Model	Part Number
WP17 Pro-Grip Lite Tig Torch Package with hand remote	WP17-13
WP 17 Eco- Grip Torch for 160/200/200 C/DC Power Supply (use with Foot control)	WP17-13FC



### Cup Gasket

Part #	Description	QTY
18CG	Cup Gasket	2

### Collet

Part #	Description	QTY
10N22	Collet 1.0mm / 0.040"	2
10N23	Collet 1.6mm / ((1/16)	2
10N24	Collet 2.4mm / (3/32)	2
10N25	Collet 3.2mm / (1/8)	2

### Collet Body

Part #	Description	QTY
10N30	Collet Body 1.0mm / 0.040"	2
10N31	Collet Body 1.6mm / (1/16)	2
10N32	Collet Body 2.4mm / (3/32)	2
10N28	Collet Body 3.2mm / (1/8)	2

### Alumina Nozzle

Part #	Description	QTY
10N50	Alumina Nozzle Ø 6mm / (15/64) #4	2
10N49	Alumina Nozzle Ø 8mm / (5/16) #5	2
10N48	Alumina Nozzle Ø 10mm / (25/64) #6	2
10N47	Alumina Nozzle Ø 11mm / (7/16) #7	2
10N46	Alumina Nozzle Ø 13mm / (33/64) #8	2
10N45	Alumina Nozzle Ø 16mm / (5/8) #10	2
10N44	Alumina Nozzle Ø 19mm / (3/4) #12	2

### Back Cap

Part #	Description	QTY
57y02	Back Cap	2

### Gas Lens Gasket

Part #	Description	QTY
54N01	Gas Lens Gasket	2

### Gas Lens Body

Part #	Description	QTY
45V25	Gas Lens Body 1.6mm / (1/16)	2
45V26	Gas Lens Body 2.4mm / (3/32)	2
45V27	Gas Lens Body 3.2mm / (1/8)	2

### Gas Lens

Part #	Description	QTY
54N14	Gas lens ceramic 8.0mm / (5/16)	2
54N15	Gas lens ceramic 7.0mm / (9/32)	2
54N17	Gas lens ceramic 5.0mm / (13/64)	2

### Red Tungsten

Part #	Description	QTY
TR0004-10	1.0mm x 175mm / 0.040" x 6 57/64" thoriated tungsten electrode 2%	10
TR0004-16	1.6mm x 175mm / (1/16) x 6 57/64" thoriated tungsten electrode 2%	10
TR0004-24	2.4mm x 175mm / (3/32) x 6 57/64" thoriated tungsten electrode 2%	10
TR0004-32	3.2mm x 175mm / (1/8) x 6 57/64" thoriated tungsten electrode 2%	10

# TROUBLE SHOOTING - TIG WELDING

The following chart addresses some of the common problems of TIG welding. In all cases of equipment malfunction, the manufacturer's recommendations should be strictly adhered to and followed.

1: Tungsten burning away quickly	
Possible Reason	Suggested Remedy
Incorrect Gas	Check that pure Argon is being used
No gas	Check the gas cylinder contains gas and is connected
Inadequate gas flow	Check the gas is connected, check hoses, gas valve and torch are not restricted. Set the gas flow between 10 - 15 l/min flow rate
Back cap not fitted correctly	Make sure the torch back cap is fitted so that the o-ring is inside the torch body
Torch connected to DC +	Connect the torch to the DC- output terminal
Incorrect tungsten being used	Check and change the tungsten type if necessary
Tungsten being oxidised after weld is finished	Keep shielding gas flowing 10-15 seconds after arc stoppage. 1 second for each 10 amps of weld current.
Tungsten melting back into the nozzle on AC welding	Check that correct type of tungsten is being used. Check the balance control is not set too high on the balance - reduce to a lower setting
2: Contaminated tungsten	
Possible Reason	Suggested Remedy
Touching tungsten into the weld pool	Keep tungsten from contacting weld puddle. Raise the torch so that the tungsten is off of the work piece 2 - 5mm
Touching the filler wire to the tungsten	Keep the filler wire from touching the tungsten during welding, feed the filler wire into the leading edge of the weld pool in front of the tungsten
Tungsten melting into the weld pool	Check that correct type of tungsten is being used. Too much current for the tungsten size so reduce the amps or change to a larger tungsten
3: Porosity - poor weld appearance and colour	
Possible Reason	Suggested Remedy
Incorrect Gas	Check that pure Argon is being used
Inadequate gas flow / gas leaks	Check the gas is connected, check hoses, gas valve and torch are not restricted. Set the gas flow between 10 - 15 l/min flow rate. Check hoses and fittings for holes, leaks etc.,
Moisture on the base metal	Remove all moisture from base metal before welding
Contaminated base metal	Remove materials like paint, grease, oil, and dirt, including mill scale from base metal
Contaminated filler wire	Remove all grease, oil, or moisture from filler metal.
Incorrect filler wire	Check the filler wire and change if necessary
4: Yellowish residue / smoke on the alumina nozzle & discoloured tungsten	
Possible Reason	Suggested Remedy
Incorrect Gas	Use pure Argon gas
Inadequate gas flow	Set the gas flow between 10 - 15 l/min flow rate
Inadequate post flow gas	Increase the post flow gas time
Alumina gas nozzle too small for size of tungsten being used	Increase the size of the alumina gas nozzle
5: Unstable Arc during DC welding	
Possible Reason	Suggested Remedy
Torch connected to DC +	Connect the torch to the DC- output terminal
Contaminated base metal	Remove materials like paint, grease, oil, and dirt, including mill scale from base metal.
Tungsten is contaminated	Remove 10mm of contaminated tungsten and re grind the tungsten
Arc length too long	Lower torch so that the tungsten is off of the work piece 2 - 5mm
6: HF present but no welding power	
Possible Reason	Suggested Remedy
Incomplete welding circuit	Check earth lead is connected. Check all cable connections. If using a water cooled torch check that the power cable is not separated.
No gas	Check the gas is connected and cylinder valve open, check hoses, gas valve and torch are not restricted. Set the gas flow between 10 - 15 l/min flow rate
Tungsten melting into the weld pool	Check that correct type of tungsten is being used. Too much current for the tungsten size so reduce the amps or change to a larger tungsten

## TROUBLE SHOOTING - TIG WELDING

7: Arc wanders during DC welding	
Possible Reason	Suggested Remedy
Poor gas flow	Check and set the gas flow between 15-25 CFH flow rate
Incorrect arc length	Lower torch so that the tungsten is off of the work piece 2 - 5mm
Tungsten incorrect or in poor condition	Check that correct type of tungsten is being used. Remove 10mm from the weld end of the tungsten and re sharpen the tungsten
Poorly prepared tungsten	Grind marks should run lengthwise with tungsten, not circular. Use proper grinding method and wheel.
Contaminated base metal	Remove contaminating materials like paint, grease, oil, and dirt, including mill scale from base metal.
Contaminated filler wire	Remove all grease, oil, or moisture from filler metal.
Incorrect filler wire	Check the filler wire and change if necessary
8: Arc difficult to start or will not start DC welding	
Possible Reason	Suggested Remedy
Incorrect machine set up	Check machine set up is correct
No gas, incorrect gas flow	Check the gas is connected and cylinder valve open, check hoses, gas valve and torch are not restricted. Set the gas flow between 15-25CFH flow rate
Tungsten is contaminated	Remove 10mm of contaminated tungsten and re grind the tungsten
Incorrect tungsten size and or tungsten being used	Check and change the size and or the tungsten if required
Loose connection	Check all connectors and tighten
Earth clamp not connected to work	Connect the earth clamp directly to the work piece wherever possible
Loss of high frequency	Check torch and cables for cracked insulation or bad connections. Check spark gaps and adjust if necessary

## ARC (Stick) WELDING TROUBLE SHOOTING

The following chart addresses some of the common problems of MMA welding. In all cases of equipment malfunction, the manufacturer's recommendations should be strictly adhered to and followed.

1: No arc	
<b>Possible Reason</b>	<b>Suggested Remedy</b>
Incomplete welding circuit	Check earth lead is connected. Check all cable connections.
Wrong mode selected	Check the MMA selector switch is selected
No power supply	Check that the machine is switched on and has a power supply
2: Porosity – small cavities or holes resulting from gas pockets in weld metal.	
<b>Possible Reason</b>	<b>Suggested Remedy</b>
Arc length too long	Shorten the arc length
Work piece dirty, contaminated or moisture	Remove moisture and materials like paint, grease, oil, and dirt, including mill scale from base metal
Damp electrodes	Use only dry electrodes
3: Excessive Spatter	
<b>Possible Reason</b>	<b>Suggested Remedy</b>
Amperage too high	Decrease the amperage or choose a larger electrode
Arc length too long	Shorten the arc length
3: Weld sits on top, lack of fusion	
<b>Possible Reason</b>	<b>Suggested Remedy</b>
Insufficient heat input	Increase the amperage or choose a larger electrode
Work piece dirty, contaminated or moisture	Remove moisture and materials like paint, grease, oil, and dirt, including mill scale from base metal
Poor welding technique	Use the correct welding technique or seek assistance for the correct technique
4: Lack of penetration	
<b>Possible Reason</b>	<b>Suggested Remedy</b>
Insufficient heat input	Increase the amperage or choose a larger electrode
Poor welding technique	Use the correct welding technique or seek assistance for the correct technique
Poor joint preparation	Check the joint design and fit up, make sure the material is not too thick. Seek assistance for the correct joint design and fit up
5: Excessive penetration - burn through	
<b>Possible Reason</b>	<b>Suggested Remedy</b>
Excessive heat input	Reduce the amperage or use a smaller electrode
Incorrect travel speed	Try increasing the weld travel speed
6: Uneven weld appearance	
<b>Possible Reason</b>	<b>Suggested Remedy</b>
Unsteady hand, wavering hand	Use two hands where possible to steady up, practise your technique
7: Distortion – movement of base metal during welding	
<b>Possible Reason</b>	<b>Suggested Remedy</b>
Excessive heat input	Reduce the amperage or use a smaller electrode
Poor welding technique	Use the correct welding technique or seek assistance for the correct technique
Poor joint preparation and or joint design	Check the joint design and fit up, make sure the material is not too thick. Seek assistance for the correct joint design and fit up
7: Electrode welds with different or unusual arc characteristic	
<b>Possible Reason</b>	<b>Suggested Remedy</b>
Incorrect polarity	Change the polarity, check the electrode manufacturer for correct polarity

## WARRANTY

JASIC Technologies America Inc ('Us', 'We') warrants that the following products under RAZORWELD supplied by Us and purchased by you from an Authorised RAZORWELD Dealer throughout the U.S.A & Canada are free of Material and Faulty Workmanship defects except for those products listed under 'Warranty Exclusions'.

These terms and conditions supersede and exclude all former and other representations and arrangements relating to any warranties on these products.

## WARRANTY PERIOD

We offer the following 'Warranty Periods' from 'date of purchase':

An Extended Warranty Period of 6 months total shall apply only to Machinery where offered and warranty is registered online.

### RAZORWELD WELDING MACHINES

RAZORWELD DIY Series (Power Source Only)	3 Years	(Clause 3)
RAZORWELD JASIC Inverter MIG (Power Source Only)	3 Years	(Clause 3)
RAZORWELD JASIC Inverter MIG SWF (Power Source / Separate Wire Feeder Only)	3 Years	(Clause 3)
RAZORWELD JASIC Inverter TIG (Power Source Only)	3 Years	(Clause 3)
RAZORWELD Water Cooler	1 Year	(Clause 3)
RAZORWELD JASIC Series (Power Source Only)	3 Years	(Clause 3)
UNI-FLAME Regulators Argon/ Acetylene / Oxygen / LPG / Bobbin Flowmeter	1 Year	
UNI-FLAME Automatic Welding Helmet	2 Years	
RAZORWELD Automatic Welding Helmets	2 Years	
TORCHES -GMAW, GTAW, MMAW, PLASMA, EARTH LEADS, INTERCONNECTING CABLES, GAS HOSE	3 Months	(Clause 3)

(Clause 1) 3 year warranty on transformers, inductor and rectifier. 1 year warranty on PCB, and all other components.

(Clause 2) Gas Hose, Flashbacks are subject to and covered by the Manufacturer's Individual Warranty, Contact the manufacturer for details

(Clause 3) This only Covers Manufactures defaults on all accessories for the first three months after date of purchase.

• SELLER MAKES NO WARRANTIES EXPRESSED OR IMPLIED, INCLUDING BUT NOT BY WAY OF LIMITATION, ANY IMPLIED WARRANTY OF MERCHANTABILITY AND ANY IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE, ON ANY ORDER EXCEPT THAT SELLER WARRANTS TITLE TO ALL GOODS FURNISHED BY SELLER AND EXCEPT THAT SELLER WARRANTS FOR A PERIOD OF ONE YEAR FROM THE DATE MARK LOCATED ON THE SELLER'S IDENTIFICATION TAG THAT ALL GOODS DESCRIBED ON SELLER'S ACKNOWLEDGMENT OF PURCHASER'S PURCHASE ORDER WILL BE MANUFACTURED IN ACCORDANCE WITH THE SPECIFICATIONS, IF ANY, SET FORTH IN SAID PURCHASE ORDER AND EXPRESSLY ACCEPTED IN SELLER'S ACKNOWLEDGMENT SUBJECT TO SELLER'S STANDARD MANUFACTURING VARIATIONS AND PRACTICES. IN THE CASE OF COMPONENTS OR ACCESSORIES FURNISHED BY SUPPLIERS TO SELLER, PURCHASER'S WARRANTY FROM SELLER SHALL BE LIMITED TO THE WARRANTY OF THE COMPONENT OR ACCESSORY SUPPLIER. THE FOREGOING WARRANTIES ARE THE SOLE AND EXCLUSIVE WARRANTIES APPLICABLE TO THE GOODS DELIVERED, AND ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING WITHOUT LIMITATION ANY WARRANTY OF MERCHANTABILITY, ARE HEREBY EXPRESSLY DISCLAIMED AND NEGATED. WITHOUT LIMITING THE GENERALITY OF THE FOREGOING, PURCHASER ACKNOWLEDGES THAT SELLER'S PRODUCTS ARE NOT PACKAGED OR PROTECTED FOR LONG PERIODS OF STORAGE AND THUS MAY CORRODE OR RUST OVER TIME..

## WARRANTY / RETURNS / EXCHANGES

We understand that sometimes a product may need to be returned. If you have purchased from the RAZORWELD Authorised Dealer Network, to assist you in following the correct procedure enclosed is the returns policy.

Our Returns Policy includes the rights you have under the American consumer Law and other relevant laws.

. You are entitled to a replacement or refund for a major failure and for compensation for any other reasonably foreseeable loss or damage. You are also entitled to have the goods repaired or replaced if the goods fail to be of acceptable quality and the failure does not amount to a major failure.

- You shall inspect the Goods on delivery and shall within seven (7) days of delivery (time being of the essence) notify JASIC Technologies America Inc of any alleged defect, shortage in quantity, damage or failure to comply with the description or quote.
- You shall also afford JASIC Technologies America Inc the opportunity to inspect the Goods within a reasonable time following delivery if you believe the Goods are defective in any way.
- If you shall fail to comply with these provisions the Goods shall be presumed to be free from any defect or damage. For defective Goods, Which JASIC Technologies America Inc has agreed in writing that you are entitled to reject, JASIC Technologies America Inc 's liability is limited to, at the discretion of JASIC Technologies America Inc either replacing the Goods or repairing the Goods except where you have acquired Goods as a consumer within the meaning of the relevant State legislation and trade act policies and is therefore also entitled to, at the consumer's discretion either a refund of the purchase price of the Goods, or repair of the Goods, or replacement of the Goods.

Returns will only be accepted provided that:

- (a) You have complied with the provisions outlined above, and
- (b) where the Goods are unable to be repaired, the Goods are returned at your cost within thirty (30) days of the delivery date, and
- (c) JASIC Technologies America inc will not be liable for Goods which have not been stored or used in a proper manner, and
- (d) the Goods are returned in the condition in which they were delivered and with all packaging material, brochures and instruction material in as new condition as is reasonably possible in the circumstances.

- JASIC Technologies America Inc Accepts no responsibility for products lost, damaged or mislaid whilst in transit
- JASIC Technologies America Inc may (at their sole discretion) accept the return of Goods for credit but this may incur a handling fee of up to fifteen percent (15%) of the value of the returned Goods plus any freight costs.
- Where a failure does not amount to a major failure, JASIC Technologies America Inc is entitled to choose between providing you with a repair, replacement or other suitable remedy.

## PURCHASER'S REMEDIES :

WITH RESPECT TO ANY CLAIM ARISING OUT OF ANY ORDER, ANY GOODS DELIVERED PURSUANT TO ANY ORDER AND EXPRESSLY ACCEPTED IN SELLER'S ACKNOWLEDGMENT, OR SELLER'S PERFORMANCE IN CONNECTION WITH ANY ORDER, INCLUDING, WITHOUT LIMITATION, ANY CLAIM ARISING OUT OF ANY RECALL, DEFECT OR ALLEGED DEFECT IN ANY GOODS OR SERVICES FURNISHED BY SELLER, SHALL BE LIMITED EXCLUSIVELY TO THE RIGHT OF REPAIR OR REPLACEMENT OF SUCH GOODS OR SERVICES, AT SELLER'S OPTION. WITHOUT IN ANY WAY LIMITING THE GENERALITY OF THE FOREGOING, IN NO EVENT SHALL SELLER BE LIABLE FOR ANY CONSEQUENTIAL OR INCIDENTAL DAMAGES, INCLUDING, WITHOUT LIMITATION, ANY LOSS OF ANTICIPATED PROFITS INCURRED BY PURCHASER WITH RESPECT TO ANY GOODS OR SERVICES FURNISHED BY SELLER, OR ANY DAMAGES ARISING FROM INJURIES TO PERSONS AS A RESULT OF PURCHASER'S OR A THIRD PARTY'S NEGLIGENCE. SELLER'S WARRANTY DOES NOT COVER FAILURES RESULTING FROM THE IMPROPER INSTALLATION, MOUNTING DESIGN OR APPLICATION OR FROM CORROSION. THE PROVISIONS OF THIS PARAGRAPH ARE A MATERIAL TERM OF THIS TRANSACTION.

## MAKING A CLAIM

If you wish to make a claim under this Warranty, you should:

- Return the product to the point of purchase either in person or on a prepaid courier; or
- Contact Us by Telephone on (+1) 253-859-6277, 253-859-6278 or e-mail [service@razorweld.com](mailto:service@razorweld.com)
- When returned, the product must be accompanied with the original invoice including the purchase price and disclosing the purchase date
- All costs of installation, cartage, freight, travelling expenses, hiring tools and insurance are paid by the Customer.
- To the extent permitted by law, our total liability for loss or damage of every kind related to the product in any way whatsoever is limited to the amount paid to the retailer by you for the product or the value of the product.

No responsibility will be taken for products lost, damaged or mislaid whilst in transit.

## WARRANTY EXCLUSIONS

This Warranty covers Material and Faulty Workmanship defects only.

This Warranty does not cover damage caused by:

- Normal wear and tear due to usage
- Misuse or abusive use of the RAZORWELD instructions supplied with the product.
- Failure to clean or improper cleaning of the product
- Failure to maintain the equipment such as regular services etc
- Incorrect voltage or non-authorized electrical connections
- Improper installation
- Use of non-authorized/non-standard parts
- Abnormal product performance caused by any ancillary equipment interference or other external factors
- Failure or any breakage caused by overload, dropping or abusive treatment or use by the customer
- Repair, modifications or other work carried out on the product other than by an Authorized RAZORWELD Dealers

Unless it is a manufacturing fault, this Warranty does not cover the following parts:

### MIG Welding Torches and Consumables to suit, such as:

Gas Nozzles, Gas Diffusers, Contact Tip holder, Contact tip, Swan Necks, Trigger, Handle, Liners, Wire Guide, Drive Roller, Gas Nozzle Spring, Neck Spring, Connector Block, Insulator, Gas Nipple, Cap, Euro Block, Head Assembly, Gas Block, Trigger Spring, Spring Cable Support, Neck Insulator, Shroud Spring, Gun Plug Cover, Lock Nut, Snap On Head, Spring Cap, Ball, Motor 42 Volt, Pot 10K standard, Knob, Drive Roll Seat, Washer, Bow, Ball Bearing, Wire Conduit Nipple, Central Plug, Printed Circuit Board, Gun Plug House, Cable Support, Gas Connector, Handle To Suit PP36 with Knobs, & Electrodes, Arc Leads, Welding Cable, Electrode Holder, Earth Clamps

### TIG Welding Torches and Consumables to suit, such as:

Tungsten Electrodes, Collet, Collet Body, Alumina Nozzle, Torch Head, Torch Head water Cooled, Torch Head Flexible, Back Caps, Gas Lens, Torch Handle, Cup Gasket, Torch Body Gas Valve, O-ring, Arc Leads, Welding Cable, Electrode Holder, Earth Clamps.

### PLASMA Cutting Torches and Consumables to suit, such as:

All Cutting Tips, All Diffuser/Swirl Ring, All Electrode, Retaining Caps, Nozzle Springs, All Spacers, All Shield Caps, All Air and Power Cables, All Switches, All O-rings, All Springs, All Circle Guides and Cutting Kits, Torch Bodies, Air Filter Regulator, Arc Leads, Welding Cable, Electrode Holder, Earth Clamps

### STRAIGHT LINE CUTTING MACHINES and Consumables to suit, such as:

Hoses, Fittings, Track, Cutting Nozzles.

### HIT-8SS Welding Carriage Consumables to suit, such as:

Input Cord, Inter-connecting Cord, Triggering Cable.

This Warranty does not cover products purchased:

- From a non-authorized Dealer (such as purchases from unauthorized retailers and purchases over the Internet from unauthorized local/international sellers or sites such as EBay)
- At an auction;
- From a private seller Unless it is a manufacturing fault, this Warranty does not apply to any products sold to Hire Companies.

These conditions may only be varied with the written approval of the Directors of JASIC Technologies America Inc

**REMEMBER TO RETAIN YOUR ORIGINAL INVOICE FOR PROOF OF PURCHASE.**



NOTES.