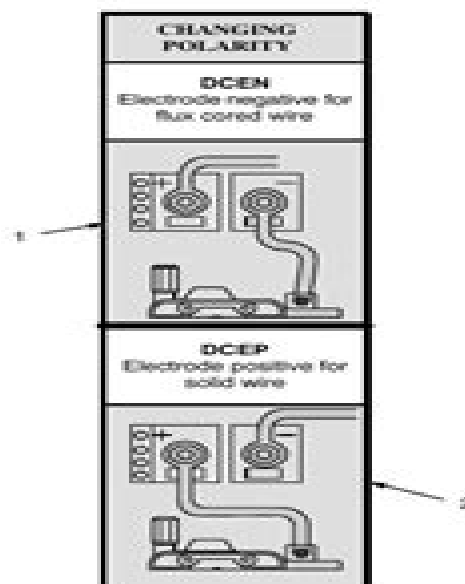


5-4. Process/Polarity Table

Process	Polarity	Cable Connections	
		Cable To Gun	Cable To Work
GMAW – Solid wire with shielding gas	DCEP – Reverse polarity	Connect to positive (+) output terminal	Connect to negative (-) output terminal
FCAW – Self-shielding wire – no shielding gas	DCEN – Straight Polarity	Connect to negative (-) output terminal	Connect to positive (+) output terminal

5-5. Changing Polarity



Turn off welding power source.

1. Lead Connections For Direct Current Electrode Negative (DCEN)
2. Lead Connections For Direct Current Electrode Positive (DCEP)

Always read and follow wire manufacturer's recommended polarity, and see Section 5-4. Close door.

Ref. 209 228 / Ref. 209 229

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