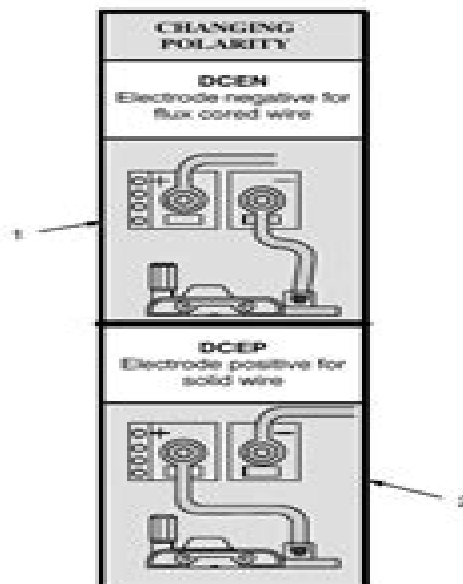


5-4. Process/Polarity Table

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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R Bogdan



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