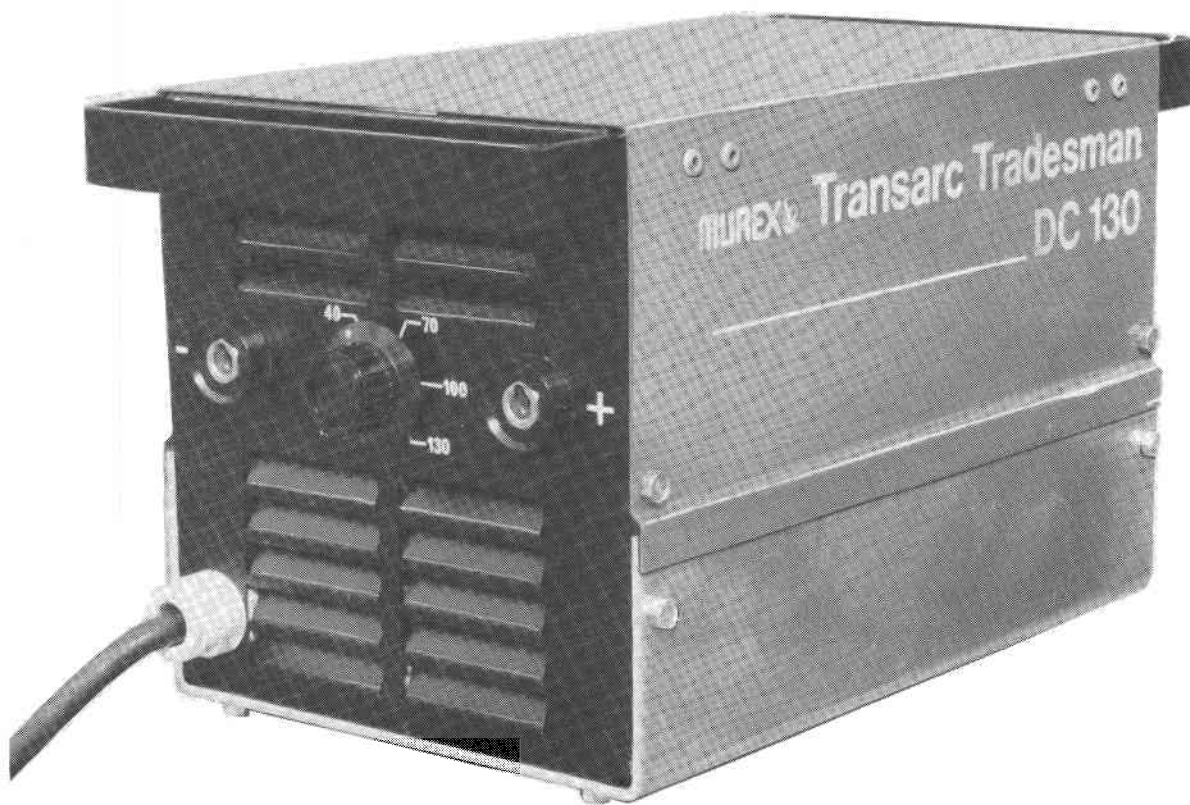




Operating Manual

Transarc Tradesman DC 130



**Please ensure that this
Instruction Manual
is made available
to the user
of the equipment.**

£2:50

INTRODUCTION

Specially Designed Unit

The Transarc Tradesman is specially designed to run low Hydrogen, Stainless Steel, Cast Iron, Bronze and Aluminium electrodes. This new product will prove particularly useful in the maintenance and repair workshops.

Good Performances

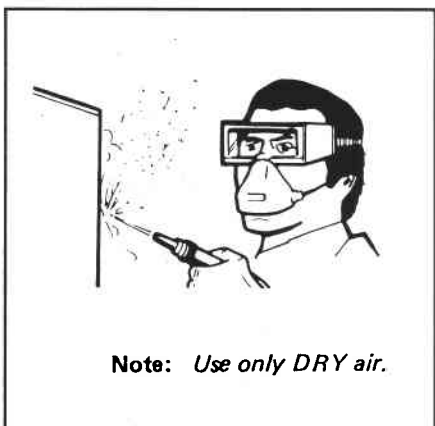
Despite its small size, the Transarc Tradesman is capable of handling electrodes up to 3.25mm (10 gauge) in size giving excellent welding performance even in the hands of a non-professional operator. With the use of a scratch start kit the Tradesman can be used for TIG welding.

Light and Compact

The Transarc Tradesman weighs a mere 29Kg(64lb), thus making it extremely easy to transport. With 450mm (17.3/4in.) as its largest dimension it will probably be the smallest welding unit in the workshop.

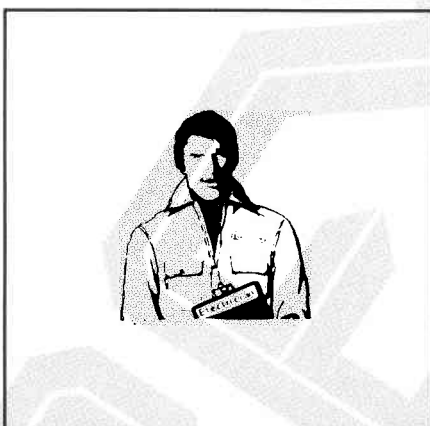
WARNING

This welding equipment has been designed, manufactured and tested to the highest quality standards to ensure long and trouble free life. However, regular maintenance is an essential part of keeping the machine operating in a reliable and safe manner and your attention is drawn to any maintenance instructions that are contained in this manual. In general, all welding equipment should be thoroughly inspected, tested and serviced at least annually. More frequent checking will be required when the equipment is heavily used. Wear and tear, particularly in electro-mechanical and moving components, are gradual processes. Caught in time, repair costs are small and the benefits in performance, reliability and safety are significant. Left alone, they can put the equipment, and you, at risk. Have this equipment regularly inspected and maintained by an approved service centre.

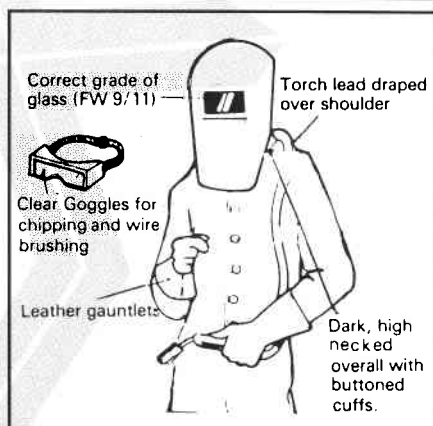


Note: Use only DRY air.

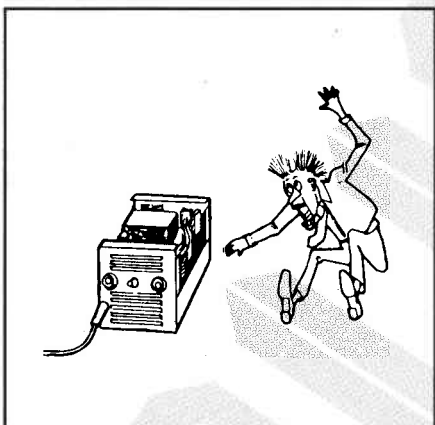
Wear goggles and mask when removing dust with an airline



Call in the experts if you don't know what to do.



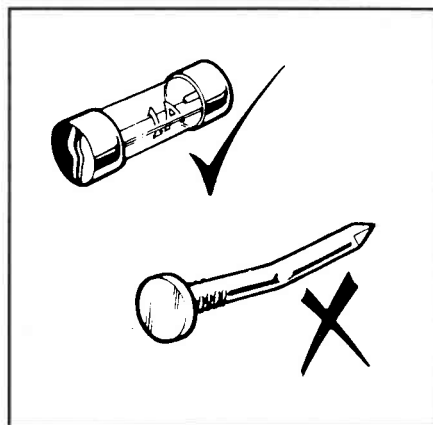
Dress correctly when welding and preparing the weld.



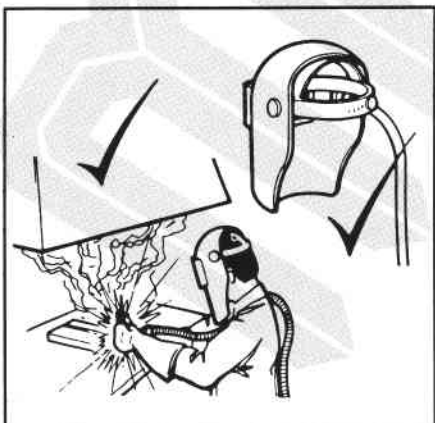
Don't work with the cover off. Leave it to the experts.



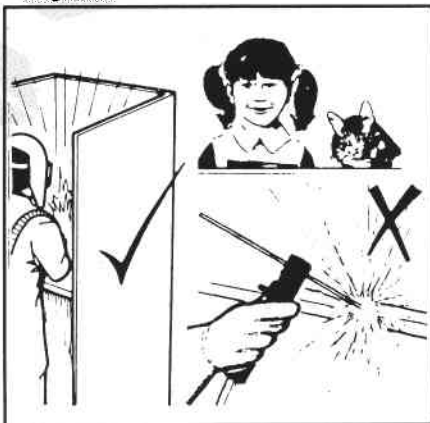
Don't allow leads to lie in oil, water or corrosive liquid or extend them with extension leads - fit a longer cable.



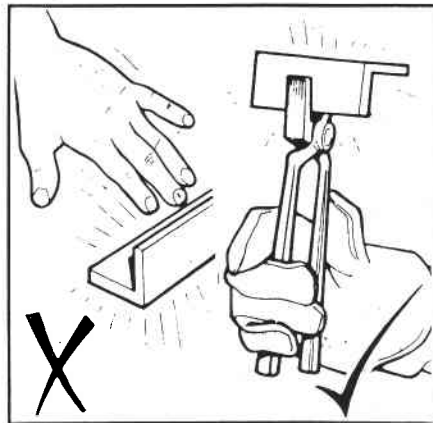
Don't replace a fuse with the wrong value (especially too high a value).



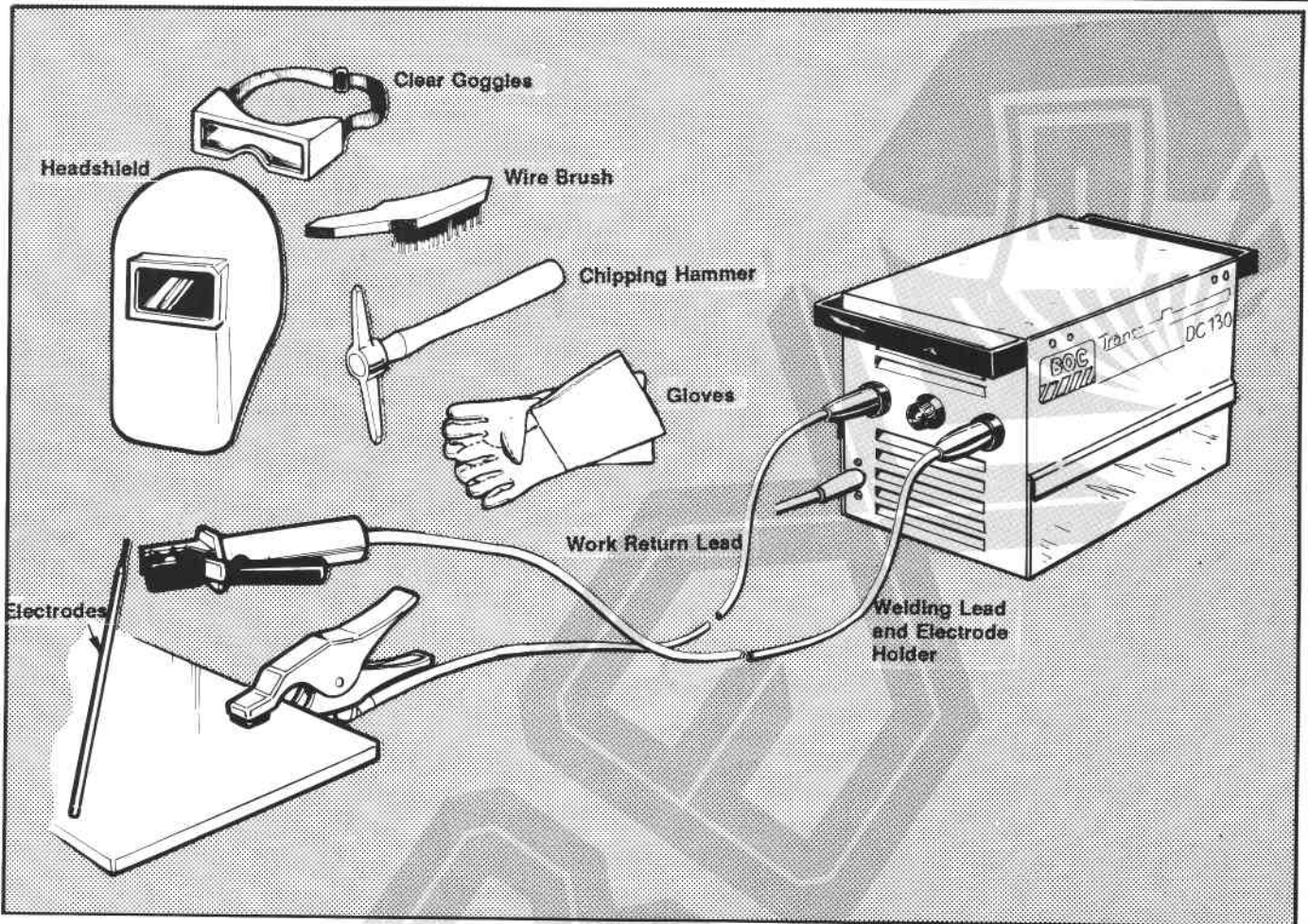
Ventilate the welding area to prevent a build-up of gas and fumes.



Wear your headshield (or face screen and screen the welding area.

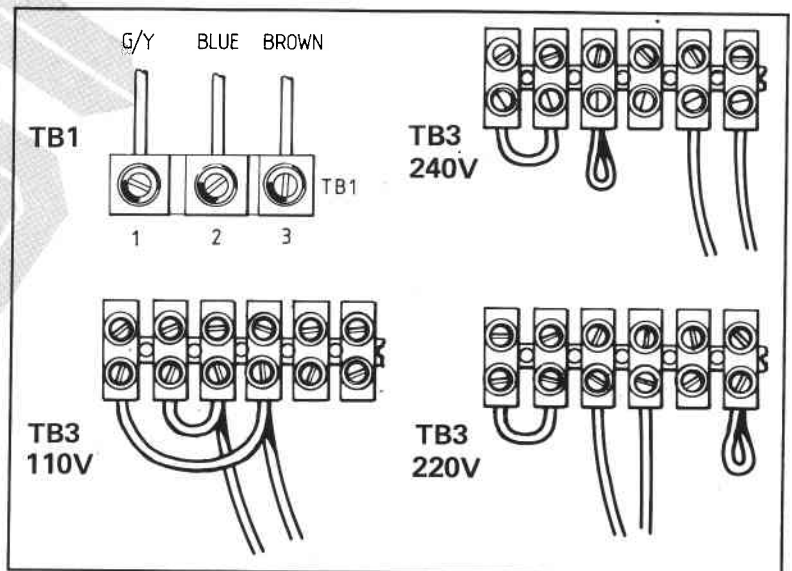
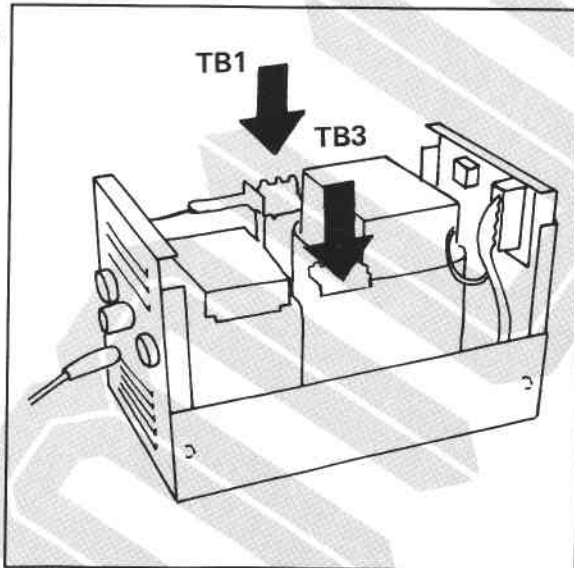


Don't burn yourself!
Wear gauntlets and use tongs.



INSTALLATION

It is recommended that installation of the Transarc Tradesman is undertaken only by a competent electrician or suitable trained person.

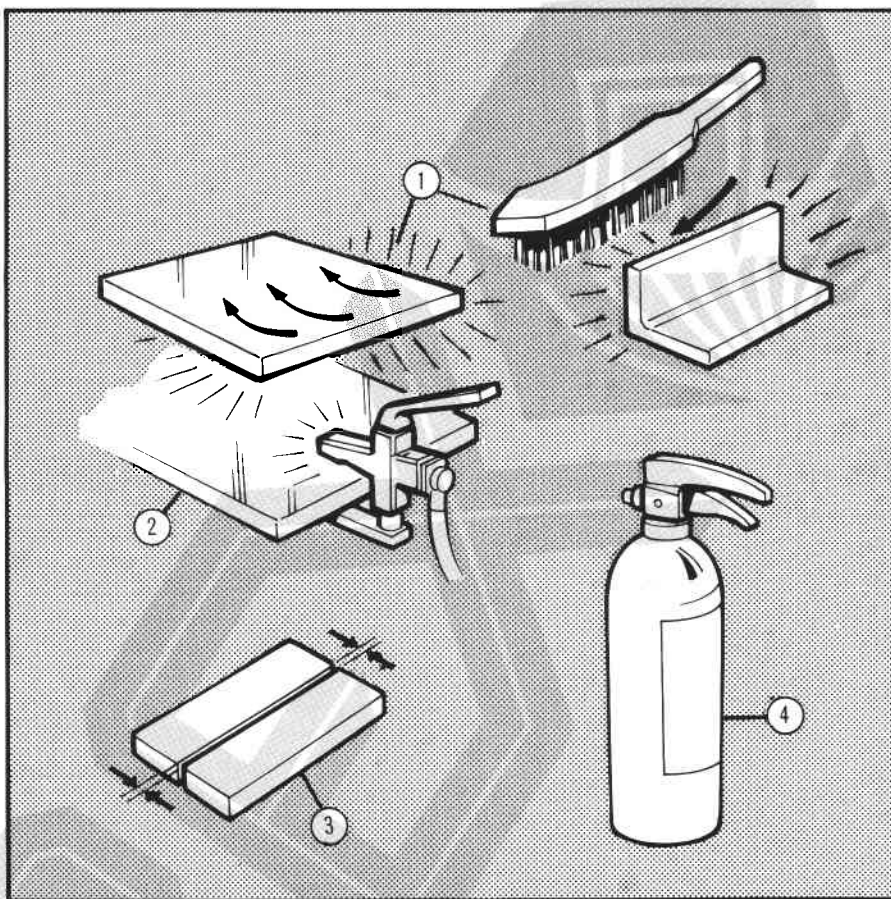


1. Remove the cover and locate TB1 and TB3.
2. Connect the mains cable to TB1.
3. On TB3 connect the two wires and links as shown.
4. Remove all inflammable material from the welding area.
5. Connect the welding leads as shown.

PREPARATION

Read again the safety notes on Page 2.

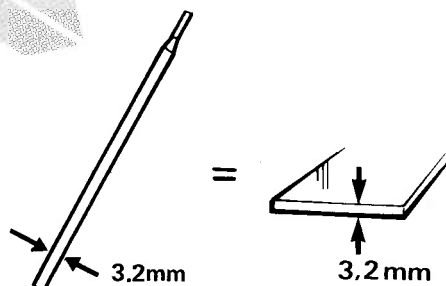
1. Connect the welding cables to the 'electrode work' terminals (as shown on page 3).
2. Fit an appropriate size electrode (see Manual Metal Arc 'Stick' ELECTRODE SECTION below).
3. Clean the material to be welded with a wire brush.
4. Clamp the work return cable to a clean area of the workpiece.
5. Keep the gap between pieces to be welded to a minimum.
6. Clear the welding area and check that a fire extinguisher is available.



MANUAL METAL ARC ('Stick') ELECTRODES

As a rough guide, select the electrode which is approximately the same size as the material thickness.

Start with a 2.5mm electrode (at 70-120A) for satisfactory results.



Electrode Type	dia. (mm)	a.c. (min ocv)	Materials
Zodian Universal or Satinex	2.5 to 6.3	ac (50v) dc +	Mild steel Medium tensile steels and mild steels
Fortrex 7018	2.5 to 6.0	ac (80v) dc +	Carbon and low alloy Mild steel and medium tensile steels
Ferex 7018LT	2.5 to 6.0	dc +/- (- preferred)	Medium tensile steels and mild steels
Nicrex E316L-16	2.0 to 5.0	ac (60v) dc +	Stainless Steel

Electrode Type	dia. (mm)	a.c. (min ocv)	Materials
Bronzoid 1	2.5-5.0	dc +	Bronzes, Brass & Copper
Armoid 1	2.5 to 6.0	ac (75) dc +	High tensile Stainless Steels Dissimilar metals
Cinex or Ferroloid 3	2.5 to 5 2.5 to 4	ac (80v) dc + ac (60v) dc -	Cast Iron-normal grades Cast Iron-high duty grades
Hardex 800	4.0 & 5.0	ac (70v) dc +	Hardfacing

This chart is given as a general guide to the MUREX electrodes. For more detailed information, contact your local MUREX branch.