

Eastwood[®]

DO THE JOB RIGHT.[®]

Item #20565

TIG200 AC/DC WELDER

SERVICE MANUAL



TIG Welding is the most controllable, efficient and most versatile method of welding many metals including steel, stainless steel, aluminum and more. Your **EASTWOOD TIG 200 WELDER** with High-Frequency Inverter Technology is capable of welding thin or heavy gauge steel and aluminum with precision and ease. The Voltage self-sensing circuitry automatically detects a power source range of 110 to 240 Volts and delivers from 10 up to 200 Amps of AC or DC current at super-high frequency with the added advantage of a light weight unit. The included foot pedal provides the operator with the precise Amperage control required when welding. A high frequency start feature guarantees an instant arc strike with no tungsten contamination.

STATEMENT OF LIMITED WARRANTY

The Eastwood Company (hereinafter "Eastwood") warrants to the end user (purchaser) of all new welding and cutting equipment (collectively called the "products") that it will be free of defects in workmanship and material. This warranty is void if the equipment has been subjected to improper installation, improper care or abnormal operations.

WARRANTY PERIOD:

All warranty periods begin on the date of purchase from Eastwood. Warranty Periods are listed below, along with the products covered during those warranty periods:

3 Year Warranty on Material, Workmanship, and Defects:

- Eastwood TIG 200 AC/DC Welder

Items not covered under this warranty: Collets, collet bodies, tungsten, nozzles, and ground clamp and cable.
All other components are covered by the warranty and will be repaired or replaced at the discretion of Eastwood.

2 Years:

- All Welding Helmets.

CONDITIONS OF WARRANTY TO OBTAIN WARRANTY COVERAGE:

Purchaser must first contact Eastwood at 1-800-345-1178 for an RMA# before Eastwood will accept any welder returns.
Final determination of warranty on welding and cutting equipment will be made by Eastwood.

WARRANTY REPAIR:

If Eastwood confirms the existence of a defect covered under this warranty plan, Eastwood will determine whether repair or replacement is the most suitable option to rectify the defect. At Eastwood's request, the purchaser must return, to Eastwood, any products claimed defective under Eastwood's warranty.

FREIGHT COSTS:

The purchaser is responsible for shipment to and from Eastwood.

WARRANTY LIMITATIONS:

EASTWOOD WILL NOT ACCEPT RESPONSIBILITY OR LIABILITY FOR REPAIRS UNLESS MADE BY EASTWOOD. EASTWOOD'S LIABILITY UNDER THIS WARRANTY SHALL NOT EXCEED THE COST OF CORRECTING THE DEFECT OF THE EASTWOOD PRODUCT. EASTWOOD WILL NOT BE LIABLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES (SUCH AS LOSS OF BUSINESS, ETC.) CAUSED BY THE DEFECT OR THE TIME INVOLVED TO CORRECT THE DEFECT. THIS WRITTEN WARRANTY IS THE ONLY EXPRESS WARRANTY PROVIDED BY EASTWOOD WITH RESPECT TO ITS PRODUCTS. WARRANTIES IMPLIED BY LAW SUCH AS THE WARRANTY OF MERCHANTABILITY ARE LIMITED TO THE DURATION OF THIS LIMITED WARRANTY FOR THE EQUIPMENT INVOLVED. THIS WARRANTY GIVES THE PURCHASER SPECIFIC LEGAL RIGHTS.
THE PURCHASER MAY ALSO HAVE OTHER RIGHTS WHICH VARY FROM STATE TO STATE.

SPECS

Function	Output Amperage Range	Maximum Output No Load Voltage	Input Voltage	Rated Duty Cycle	Pre Gas Flow	Post Gas Flow	Weight	Overall Dimensions
TIG	10-145A AC/DC	56V DC	120VAC	60% @ 145 Amps	0.1-1.0 Sec	2-8 Sec	45 lbs. [20.4kg]	19.1" [486mm] x 9.8" [248mm] x 20.0" [504mm]
	10-200A AC/DC		220VAC	60% @ 190 Amps				
STICK	10-140A		120VAC	60% @ 140 Amps	NA	NA		
	10-185A		220VAC	60% @ 185 Amps				

DUTY CYCLE

The Rated Duty Cycle refers to the amount of welding that can be done within an amount of time. The Eastwood TIG 200 has a duty cycle of 60% at 190 Amps. It is easiest to look at your welding time in blocks of 10 Minutes and the Duty Cycle being a percentage of that 10 Minutes. If welding at 190 Amps with a 60% Duty Cycle, within a 10 Minute block of time you can weld for 6 Minutes with 4 Minutes of cooling for the welder. To increase the Duty Cycle you can turn down the Amperage Output control. Going above 190 Amps will yield a lower duty cycle.

SAFETY INFORMATION

⚠ DANGER

DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.

⚠ WARNING

WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

⚠ CAUTION

CAUTION used with the safety alert symbol, indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

⚠ NOTICE

NOTICE is used to address practices not related to personal injury.



⚠ READ INSTRUCTIONS

- Thoroughly read and understand this manual before using.
- Save for future reference.



⚠ WARNING ELECTRIC SHOCK CAN CAUSE INJURY OR DEATH!

- Improper use of an electric welder can cause electric shock, injury and death! Read all precautions described in the Welder Manual to reduce the possibility of electric shock.
- Disconnect welder from power supply before assembly, disassembly or maintenance of the torch, contact tip and when installing or removing nozzles.
- Always wear dry, protective clothing and leather welding gloves and insulated footwear. Use suitable clothing made from durable flame-resistant material to protect your skin.
- If other persons or pets are in the area of welding, use welding screens to protect bystanders from sparks.
- Always operate the welder in a clean, dry, well ventilated area. Do not operate the welder in humid, wet, rainy or poorly ventilated areas.
- The electrode and work (or ground) circuits are electrically “hot” when the welder is on. Do not allow these “hot” parts to come in contact with your bare skin or wet clothing.
- Separate yourself from the welding circuit by using insulating mats to prevent contact from the work surface.
- Be sure that the work piece is properly supported and grounded prior to beginning an electric welding operation.
- Always attach the ground clamp to the piece to be welded and as close to the weld area as possible. This will give the least resistance and best weld.



⚠ WARNING WELDING SPARKS CAN CAUSE FIRE OR EXPLOSION!

- Electric welding produces sparks which can be discharged considerable distances at high velocity igniting flammable or exploding vapors and materials.
- Do not operate electric arc welder in areas where flammable or explosive vapors are present.
- Do not use near combustible surfaces. Remove all flammable items within 35 feet of the welding area.
- Always keep a fire extinguisher nearby while welding.
- Use welding blankets to protect painted and or flammable surfaces; rubber weather-stripping, dash boards, engines, etc.
- Ensure power supply has properly rated wiring to handle power usage.



⚠ WARNING ELECTROMAGNETIC FIELDS CAN BE A HEALTH HAZARD!

- The electromagnetic field that is generated during arc welding may interfere with various electrical and electronic devices such as cardiac pacemakers. Anyone using such devices should consult with their physician prior to performing any electric welding operations.
- Exposure to electromagnetic fields while welding may have other health effects which are not known.

SAFETY INFORMATION



⚠ WARNING FUMES & WELDING GASES CAN BE A HEALTH HAZARD!

- Fumes and gasses released during welding are hazardous. Do not breathe fumes that are produced by the welding operation. Wear an OSHA-approved respirator when welding.
- Always work in a properly ventilated area.
- Never weld coated materials including but not limited to: cadmium plated, galvanized, lead based paints.



⚠ WARNING BUILDUP OF GAS CAN INJURE OR KILL!

- Shut off shielding gas supply when not in use.
- Ensure adequate ventilation. Do not weld in confined spaces.
- Always turn your face away from valve outlet when opening cylinder valve.



⚠ WARNING CYLINDERS CAN EXPLODE IF DAMAGED!

Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. As gas cylinders are a normal component of the welding process, use extra care to handle them carefully.

- Protect compressed gas cylinders from excessive heat, mechanical shocks, physical damage, slag, open flames, sparks and arcs. Keep away from any welding or other electrical circuits.
- Install cylinders in an upright position by securing to a specifically designed rack, cart or stationary support to prevent falling or tipping over.
- Never weld on a pressurized cylinder or explosion will occur.
- Use only correct shielding gas cylinders, regulators, hoses and fittings designed for the specific application; maintain them and all related components in good condition.
- Keep protective cap in place over valve except when cylinder is in use.
- Use proper equipment, procedures and have adequate help when moving or lifting cylinders.



⚠ CAUTION HOT METAL & TOOLS WILL BURN!

- Electric welding heats metal and tools to temperatures that will cause severe burns!
- Use protective, heat resistant gloves and clothing when using Eastwood or any other welding equipment. Never touch welded work surface, torch tip or nozzle until they have completely cooled.



⚠ WARNING ARC RAYS CAN BURN!

- Arc rays produce intense ultraviolet radiation which can burn exposed skin and cause eye damage. Use a shield with the proper filter (a minimum of #11) to protect your eyes from sparks and the rays of the arc when welding or when observing open arc welding (see ANSI Z49.1 and Z87.1 for safety standards).
- Use suitable clothing made from durable flame-resistant material to protect your skin.
- If other persons or pets are in the area of welding, use welding screens to protect bystanders from sparks and arc rays.



⚠ CAUTION FLYING METAL CHIPS CAN CAUSE INJURY!

- Grinding and sanding will eject metal chips, dust, debris and sparks at high velocity. To prevent eye injury wear approved safety glasses.
- Wear an OSHA-approved respirator when grinding or sanding.
- Read all manuals included with specific grinders, sanders or other power tools used before and after the welding process. Be aware of all power tool safety warnings.

REQUIRED ITEMS

Before you begin using the Eastwood TIG Welding System, make sure you have the following:

- Our TIG 200 is supplied with the popular NEMA 6-50P plug, requiring a NEMA 6-50R receptacle.
- The TIG 200 will also operate on a 110-120 VAC 20 Amp circuit. To operate on this voltage it is necessary to connect the included adaptor cord to the plug hard wired to the TIG 200.
- A clean, safe, well-lit, dry and well-ventilated work area.
- A non-flammable, long sleeve shirt or jacket (Eastwood #12762L, XL, XXL).
- Heavy Duty Welding Gloves (#12590)
- An Auto Darkening Welding Mask (Eastwood #13203, #13212, #14425 or equivalent) to provide eye protection during welding operations. **NOTE:** MUST be a #11 lens or darker.
- A compressed gas cylinder containing 100% Argon (must be used when TIG welding and is available at any welding supply facility).
- Dedicated stainless steel wire welding brush for each material to be welded.
- A dedicated fine grit synthetic stone grinding wheel or a Tungsten Sharpener.

POWER REQUIREMENTS

The Eastwood TIG 200 AC/DC is Voltage sensing; it will automatically operate on 110-120 VAC, 50/60 Hz., or 220-240 VAC, 50/60 Hz. Eastwood recommends at a minimum a properly grounded 110-120 VAC 50/60Hz., 20 Amp circuit or 220-240 VAC 50/60Hz., 30 Amp circuit.

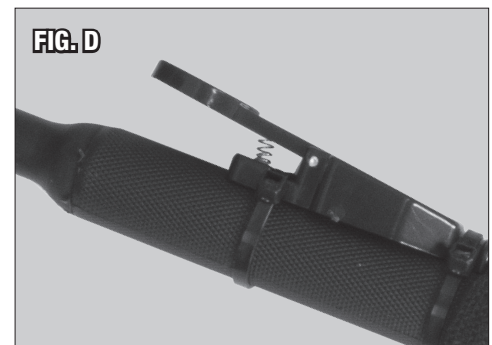
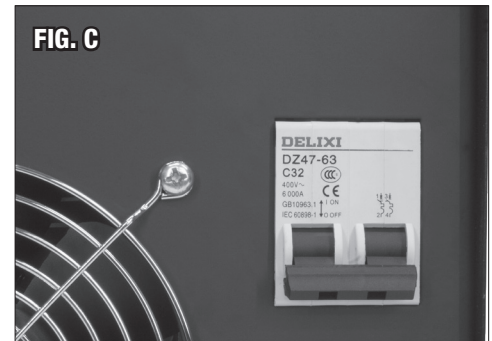
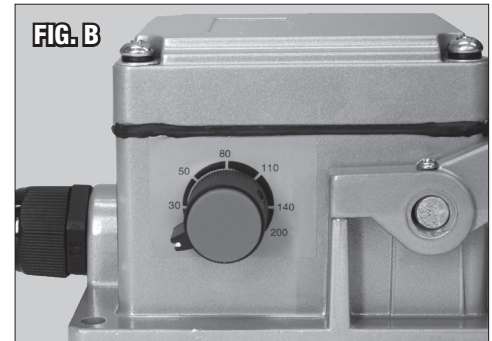
BEFORE YOU BEGIN

Remove all items from the box. Compare with list below to make sure unit is complete.

- (1) TIG 200 AC/DC Welder with NEMA6-50P Plug
- (1) Shielding Gas Regulator
- (1) Shielding Gas Hose
- (1) Ground Cable with Clamp (10')
- (1) TIG Torch (17 Series) which accepts industry standard cups, collets and collet bodies (14')
- (1) Foot Pedal for Amperage Control
- (1) 110-120 VAC to 220-240 VAC Adaptor Plug
- (1) Instruction Manual
- (1) Hand Held Shield
- (1) Hammer/Brush
- (1) #7 Gas Nozzle (7/16")
- (1) #6 Gas Nozzle (3/8")
- (1) #5 Gas Nozzle (5/16") (Installed)
- (1) Long Back Cap
- (1) Short Back Cap (Installed)
- (1) 3/32" Collet Body (Installed)
- (1) 3/32" Collet (Installed)
- (1) 2mm Collet
- (1) 1/16" Collet
- (1) 3/32" Red Thoriated Tungsten
- (1) 3/32" Green Pure Tungsten

COMPONENTS AND CONTROLS

- Power Switch** – The Power Switch also serves as the overload Circuit Breaker and is located at the right of the rear panel (**FIG. C**).
- Amperage (Front Panel)** – Set the Output Amperage Knob marked “A” (**FIG. A**), located at upper left of the top panel, to an appropriate setting based on the thickness and type of the metal being welded. (Refer to Data Chart for actual settings.)
- Amperage (Foot Pedal)** – Same operation as the panel control but is used while the foot pedal is in use (**FIG. B**).
- Clearance Effect** – The Clearance Effect Knob (**FIG. A**) is located at the upper right of the top panel. Clearance Effect will control how much cleaning versus penetration occurs. The more negative the value will result in greater penetration and less cleaning and the more positive the value will result in less penetration but greater cleaning.
- Pre Flow** – The Pre Flow Knob located at the lower left of the top panel (**FIG. A**) controls the time (in seconds) that the shielding gas starts to flow after the trigger or foot pedal is pressed before the arc starts. (Refer to Data Chart for actual settings.)
- Post Flow** – The Post Flow Knob located at the lower right of the top panel (**FIG. A**) controls the time (in seconds) that the shielding gas continues to flow after the trigger or foot pedal is released. (Refer to Data Chart for actual settings.)
- Gas Flow** – The included regulator limits the shielding gas flow from the bottle and also displays how much gas is left in the bottle. The Gas Flow Indicator Gauge is located on the left side and is generally set between 12 to 21 SCFH. (Refer to Data Chart for actual settings.) This is explained in further detail in the Preparing to Weld section of this manual. The gauge on the right indicates the pressure left in the tank.
- AC/DC** – The DC setting is used for welding steel and stainless steel while the AC setting is used for welding aluminum (**FIG. A**). (Refer to Data Chart for actual settings.)
- TIG/Stick Switch** – The TIG/Stick Switch allows selection between TIG Welding or Stick Welding configuration. **NOTE:** Stick Weld Torch is **Not Included**.
- Foot Pedal/Panel Control** – The Foot Pedal/Panel Control selection switch is located at the upper right of the top panel and when set in the ‘Foot Pedal’ position, the Foot Pedal control is activated. When set to the ‘Panel Control’ position, the Torch Trigger is activated (**FIG. A**).
- Torch Switch** – The switch on the torch (Fig. D) controls starting and stopping the arc. When using the torch switch the Amperage is set on the adjustment knob on the front panel of the welder.
- Foot Pedal** – The foot pedal is for starting and stopping the arc as well as controlling the Amperage during the weld. When using the foot pedal the Amperage is set by the adjustment knob on the side of the foot pedal (**FIG. B**).



DATA CHART (ALSO LOCATED ON TOP OF WELDER)

MATERIAL	MATERIAL THICKNESS	POLARITY	AMPERAGE	TUNGSTEN COLOR	TUNGSTEN DIA.	FILLER METAL	FILLER METAL DIA.	PRE FLOW (sec)	POST FLOW (sec)	TORCH CUP SIZE	GAS FLOW RATE (scfh)	CLEARANCE EFFECT
Aluminum	1/16"	AC	55-75	Green, Purple	1/16"	4043	1/16"	0.4	5	1/4 - 3/8"	15	-3 to 0
Aluminum	3/32"	AC	70-100	Green, Purple	1/16"	4043	1/16"	0.4	5	1/4 - 3/8"	15	-3 to 0
Aluminum	1/8"	AC	90-140	Green, Purple	3/32"	4043	3/32"	0.4	6	3/8 - 7/16"	17	-3 to 0
Aluminum	3/16"	AC	125-180	Green, Purple	3/32"	4043	3/32"	0.4	6	7/16 - 1/2"	21	-3 to 0
Steel	1/16"	DC-	45-80	Gray, Red, White, Purple	1/16"	ER70S-2	1/16"	0.4	5	1/4 - 3/8"	12	0
Steel	3/32"	DC-	70-110	Gray, Red, White, Purple	1/16"	ER70S-2	1/16"	0.4	5	1/4 - 3/8"	12	0
Steel	1/8"	DC-	75-125	Gray, Red, White, Purple	1/16"	ER70S-2	3/32"	0.4	6	1/4 - 3/8"	12	0
Steel	3/16"	DC-	110-200	Gray, Red, White, Purple	3/32"	ER70S-2	1/8"	0.4	6	1/4 - 3/8"	14	0
Stainless Steel	1/16"	DC-	50-90	Gray, Red, White, Purple	1/16"	ER308/308L	1/16"	0.4	5	1/4 - 3/8"	12	0
Stainless Steel	3/32"	DC-	80-120	Gray, Red, White, Purple	1/16"	ER308/308L	1/16"	0.4	5	1/4 - 3/8"	12	0
Stainless Steel	1/8"	DC-	85-140	Gray, Red, White, Purple	1/16"	ER308/308L	3/32"	0.4	6	1/4 - 3/8"	12	0
Stainless Steel	3/16"	DC-	125-200	Gray, Red, White, Purple	3/32"	ER308/308L	1/8"	0.4	6	1/4 - 3/8"	14	0

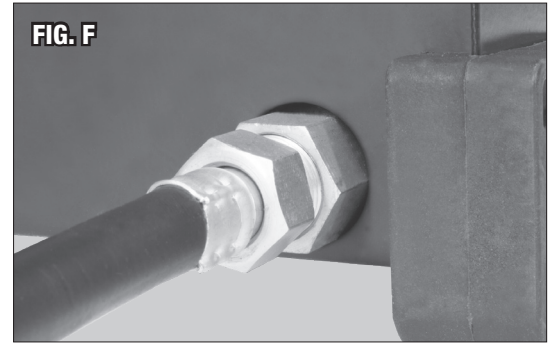
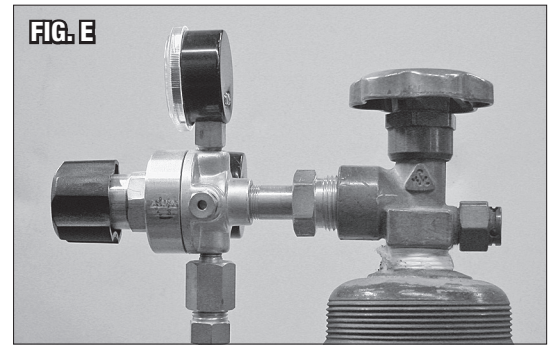
SETUP

SHIELDING GAS CONNECTION

⚠ WARNING BUILDUP OF GAS CAN INJURE OR KILL!
Shut off shielding gas supply when not in use.
Ensure adequate ventilation. Do not weld in confined spaces.
Always turn your face away from valve outlet when opening cylinder valve.

A Shielding Gas Bottle is not included with your Eastwood TIG 200 but is necessary while TIG welding. A Shielding Gas Bottle can be bought at most local Welding Supply Stores. Eastwood recommends the use of 100% Argon shielding gas when TIG welding Steel, Aluminum, and Stainless Steel.

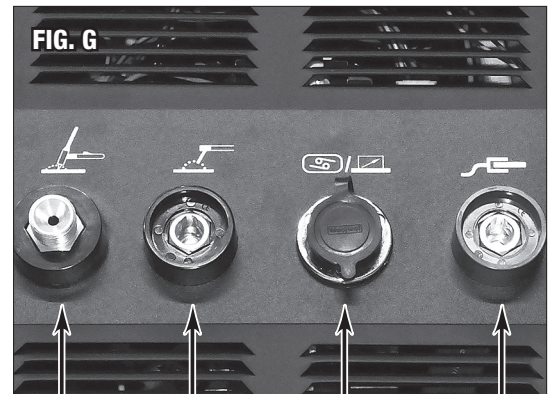
1. Place the Eastwood TIG 200 in its dedicated area or on a welding cart.
2. Secure your Shielding Gas Bottle to a stationary object or mount to your welding cart, if it is equipped to hold one, so that the cylinder cannot fall over.
3. Remove the cap from the Shielding Gas Bottle.
4. Insert the large brass male fitting on the Shielding Gas Regulator into the female fitting on the Shielding Gas Bottle (**FIG. E**).
5. Tighten the fitting with a wrench till snug, do not over tighten.
6. Connect either end of the Gas Line included with your Eastwood TIG 200 to the fitting on the regulator and tighten with a wrench until snug.
7. Connect the other end of the gas line to the fitting on the rear of the Eastwood TIG 200 and tighten with a wrench until snug (**FIG. F**).



TORCH CONNECTION

⚠ WARNING ELECTRIC SHOCK CAN CAUSE INJURY OR DEATH!
Disconnect Welder from power supply before assembly or disassembly of Torch and Cables.

1. Install the plastic connection cover onto the brass torch fitting on the torch cable.
2. Connect the female brass fitting on the torch cable to the male brass fitting on the welder (**FIG. G**).
3. Use a wrench and tighten until snug. DO NOT OVERTIGHTEN.
4. Connect the black 5 pin plug to the Torch Switch/Foot Pedal Connection as shown in (**FIG. G**). **NOTE:** Omit this step if you will be using the foot pedal for Amperage control.



Gas Flow Through Power Cable **Stick Torch** **TIG Torch Switch/Foot Pedal** **Ground Cable**

GROUND CABLE CONNECTION

1. Locate the Ground Cable and Clamp.
2. The Ground Cable connection is located at the far right of the front panel as shown in (**FIG. G**). With the Key on the connector in the 12 O'clock position, insert the connector and turn 180° clockwise to lock in the connector.

FOOT PEDAL CONNECTION

1. If you are going to be using the switch on the torch to start the welding arc, omit this step.
2. Connect the Black 5 pin plug on the Foot Pedal to the Torch Switch/Foot Pedal Connection as shown in (**FIG. G**).

STICK WELD CONNECTION WITH OPTIONAL 20517 EASTWOOD STICK WELD TORCH.

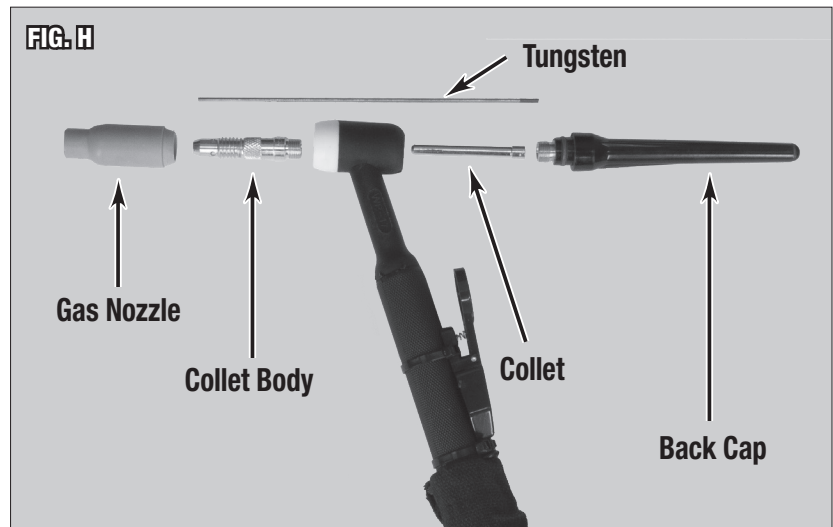
1. Disconnect and remove the TIG Torch/Foot Pedal Connections if in place.
2. Insert the BLACK Stick Weld Connector into the BLACK Stick Weld Connection located at the far left of the Front Panel (**FIG. F**). With the Key of the Connector at the 12:00 position, push in and rotate 180° Clockwise to lock the connector in.
3. Insert the RED Ground Connector into the RED Ground Connection located at the far right of the Front Panel (**FIG. F**). With the Key of the Connector at the 12:00 position, push in and rotate 180° Clockwise to lock the connector in. **NOTE:** The above connections are the standard default for Stick Welding. If your material or rod preference dictates it, the Stick Weld and Ground Connections may safely be reversed.

PREPARING TO TIG WELD

TORCH DISASSEMBLY

⚠ WARNING **ELECTRIC SHOCK CAN CAUSE INJURY OR DEATH!**
Disconnect Welder from power supply before assembly or disassembly of Torch and Cables.

1. Make sure the welder is turned off and unplugged.
2. Remove the back cap from the torch.
3. If there is a tungsten installed in the torch pull it out of the front of the torch
4. Slide the collet out of the torch.
5. Unscrew and remove the gas nozzle.
6. Unscrew and remove the collet body.



TORCH ASSEMBLY

1. Select a collet body that matches your tungsten diameter size and thread it back into the front of the torch.
2. Select a collet that matches your tungsten diameter size. Insert the tungsten into the collet and put the collet and tungsten back into the torch.
3. The Gas Nozzle size should be selected according to shielding gas requirements for the material being welded. This size can be referenced on the suggested settings chart. Select the correct gas nozzle and thread it onto the collet body.
4. Reinstall the back cap to lock the tungsten in place. Always make sure the tungsten protrudes 1/8" to 1/4" beyond the gas nozzle.

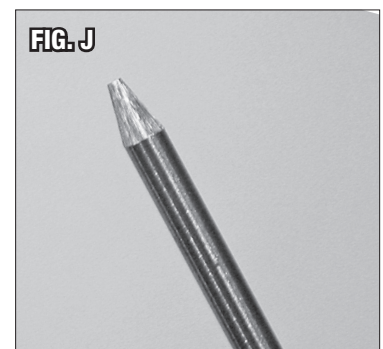
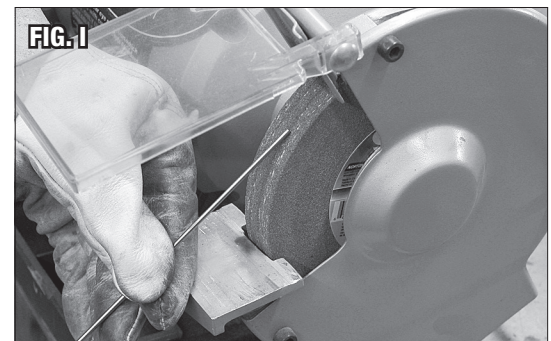
SHARPENING THE TUNGSTEN

To avoid contamination of the Tungsten and ultimately the weld, it is imperative to have a dedicated grinding wheel used for Tungsten grinding only. A fine grit standard 6" synthetic stone grinding wheel on a bench top grinder is sufficient, or specifically designed Tungsten Grinders are available.

1. Shut off the welder.
2. Make sure the Tungsten and Torch are sufficiently cooled for handling, then loosen and remove the Back Cap then the Collet (FIG. H) and remove the Tungsten from the FRONT of the Torch only (Removing from the rear will damage the Collet).

⚠ CAUTION **FLYING METAL CHIPS CAN CAUSE INJURY!**
Grinding and sanding will eject metal chips, dust, debris and sparks at high velocity. To prevent eye injury wear approved safety glasses.
Wear an OSHA-approved respirator when grinding or sanding.
Read all manuals included with specific grinders, sanders or other power tools used before and after the welding process. Be aware of all power tool safety warnings.

3. If the Tungsten is used and the end is contaminated, use pliers or a suitable tool to grip the tungsten above the contaminated section and snap off the end of the Tungsten.
4. Holding the Tungsten tangent to the surface of the grinding wheel, rotate the Tungsten while exerting light pressure until a suitable point is formed (FIG. I).
5. The ideal tip will have the length of the conical portion of the sharpened area at 2-1/2 times the Tungsten rod diameter (FIG. J).
6. Replace the Tungsten in the Collet with the tip extending 1/8"-1/4" beyond the Gas Nozzle, then re-tighten the Back Cap.



SETTINGS SELECTION

With the materials selected of which you will be welding you can begin to set up the welder for the specific material.

1. **AC/DC** – The type of current will need to be selected depending on the type of material being welded. For the most part when welding steels the switch will be set to DC and when welding aluminum the switch will be set to AC.
2. **Clearance Effect** – This step can be omitted if welding in DC. If welding in AC this will need to be set. The more negative the value will result in greater penetration and less cleaning and the more positive the value will result in less penetration but greater cleaning. For suggested settings refer to the data chart on the welder.
3. **Foot Pedal/Panel Control** – Determine whether you will be using the switch on the torch or the foot pedal for arc starting and stopping and put the selector switch in the appropriate position. Note that some connections changes will be necessary also when switching the control type. These connection changes are covered in the Set-Up section of this manual.
4. **Amperage** – If welding using the switch on the torch to control the arc, set the Output Amperage Knob marked “A” (**FIG. A**) located at upper left of the top panel to an appropriate setting based on the thickness and type of the metal being welded. (**Refer to Data Chart for actual settings**). If welding using the foot pedal to control the arc, it uses the same operation as the panel control but is adjusted on the side of the foot pedal rather than the front panel (**FIG. A**).
5. **Pre Flow** – This adjustment controls the time (in seconds) that the shielding gas starts to flow before the arc starts. (**Refer to Data Chart for actual settings**).
6. **Post Flow** – This adjustment controls the time (in seconds) that the shielding gas flows after the arc stops. (**Refer to Data Chart for actual settings**).
7. **Power Switch** – Once all of the settings have been selected and the torch is assembled and ready to use, the welder can be plugged in and turned on.
8. **Shielding Gas Flow** – Set the Gas Flow Rate to the appropriate value with the Knob located at the left side of the regulator.

SHIELDING GAS FLOW ADJUSTMENT

⚠ WARNING BUILDUP OF GAS CAN INJURE OR KILL!
Shut off shielding gas supply when not in use.
Ensure adequate ventilation. Do not weld in confined spaces.
Always turn your face away from valve outlet when opening cylinder valve.

After connecting your Shielding Gas Regulator, the gas flow rate needs to be adjusted so that the proper amount of Shielding Gas is flowing over your weld. If there is too little gas flow there will be porosity in your welds as well as excessive spatter, if there is too much gas flow you will be wasting gas and may affect the weld quality. The included regulator has 2 gauges on it; the gauge on the left is your flow rate while the gauge on your right is your tank pressure.

1. Open your Shielding Gas tank valve all the way.
2. Adjust the knob on the regulator to ~20 CFH.
3. Turn on the welder and trigger the torch switch or foot pedal which will start the gas flow.
4. As you trigger the torch switch or foot pedal, you will notice that as the gas flow starts the needle on the gauge drops to a steady reading. The reading while flowing is the value you want to read.
5. The gas flow should be set to 12-21 CFH while flowing depending on the material and thickness being welded. The CFH (Cubic Feet per Hour) scale is the inside scale in red on your flow gauge. 20 CFH is the most typical flow rate but it may need to be adjusted in some cases depending if there is a slight breeze or some other instance where additional shielding gas is required to prevent porosity in the weld.
6. When finished welding remember to close the gas valve on the bottle.

TIG WELDING

IMPORTANT NOTE: These instructions are intended only to provide the user with some familiarity of the Eastwood TIG 200. TIG welding is a highly complex procedure with many variables. If you have no experience with TIG welding; it is extremely important to seek the advice of someone experienced in TIG welding for instruction, enroll in a local technical school welding course or study a comprehensive how-to DVD and obtain a good quality reference book on TIG welding as there is a moderate learning curve necessary before achieving proficiency in TIG Welding. Before attempting to use this unit on an actual project or object of value, practice on a similar material as there are many variables present and settings required when TIG welding different metals such as steel or aluminum. It is also strongly recommended that the user adhere to the American Welding Society guidelines, codes and applications prior to producing welds where safety is affected.

⚠ WARNING WELDING SPARKS CAN CAUSE FIRE OR EXPLOSION!

Electric welding produces sparks which can be discharged considerable distances at high velocity igniting flammable or exploding vapors and materials.

Do not operate electric arc welder in areas where flammable or explosive vapors are present.

Do not use near combustible surfaces. Remove all flammable items within 35 feet of the welding area.

Always keep a fire extinguisher nearby while welding.

Use welding blankets to protect painted and or flammable surfaces; rubber weather-stripping, dash boards, engines, etc.

Ensure power supply has properly rated wiring to handle power usage.

⚠ WARNING FUMES & WELDING GASES CAN BE A HEALTH HAZARD!

Fumes and gasses released during welding are hazardous. Do not breathe fumes that are produced by the welding operation.

Wear an OSHA-approved respirator when welding.

Always work in a properly ventilated area.

Never weld coated materials including but not limited to: cadmium plated, galvanized, lead based paints.

⚠ WARNING ELECTRIC SHOCK CAN CAUSE INJURY OR DEATH!

Improper use of an electric welder can cause electric shock, injury and death! Read all precautions described in the Welder Manual to reduce the possibility of electric shock.

Disconnect welder from power supply before assembly, disassembly or maintenance of the torch, contact tip and when installing or removing nozzles.

Always wear dry, protective clothing and leather welding gloves and insulated footwear. Use suitable clothing made from durable flame-resistant material to protect your skin.

If other persons or pets are in the area of welding, use welding screens to protect bystanders from sparks.

Always operate the welder in a clean, dry, well ventilated area. Do not operate the welder in humid, wet, rainy or poorly ventilated areas.

The electrode and work (or ground) circuits are electrically "hot" when the welder is on. Do not allow these "hot" parts to come in contact with your bare skin or wet clothing.

Separate yourself from the welding circuit by using insulating mats to prevent contact from the work surface.

Be sure that the work piece is properly supported and grounded prior to beginning an electric welding operation.

Always attach the ground clamp to the piece to be welded and as close to the weld area as possible. This will give the least resistance and best weld.

⚠ CAUTION HOT METAL & TOOLS WILL BURN!

Electric welding heats metal and tools to temperatures that will cause severe burns!

Use protective, heat resistant gloves and clothing when using Eastwood or any other welding equipment. Never touch welded work surface, torch tip or nozzle until they have completely cooled.

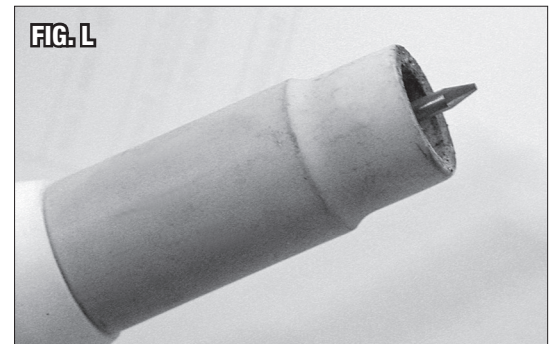
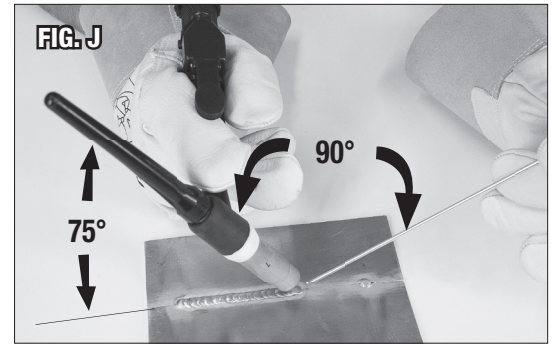
⚠ WARNING ARC RAYS CAN BURN!

Arc rays produce intense ultraviolet radiation which can burn exposed skin and cause eye damage. Use a shield with the proper filter (a minimum of #11) to protect your eyes from sparks and the rays of the arc when welding or when observing open arc welding (see ANSI Z49.1 and Z87.1 for safety standards).

Use suitable clothing made from durable flame-resistant material to protect your skin.

If other persons or pets are in the area of welding, use welding screens to protect bystanders from sparks and arc rays.

1. Turn the Power Switch/Circuit Breaker to the on position.
2. Slowly open the gas cylinder valve.
NOTE: Always open valve fully to avoid shielding gas leakage.
3. Depress gun trigger switch or foot pedal and adjust the flow regulator.
(Refer to Data Chart for actual settings).
4. Grounding is very important, place the Ground Cable Clamp on a clean, bare area of your work piece as close to the welding area as possible to minimize the chance of shock. Scrape, wire brush, file or grind a bare area to achieve a good ground to assure safety.
5. Use a dedicated stainless steel brush or flap-disc to clean the areas to be welded. This is particularly critical on aluminum as a microscopic layer of oxidation can prevent an arc and actually produce a poor-quality, contaminated weld. Do not use the brush or flap-disc for any other purpose and keep one for steel and one for aluminum.
6. Make sure all your safety gear is in place (Welding Mask, Welding Gloves, Non-Flammable Long Sleeve Apparel) and the area is completely free of flammable material.
7. Although it is a matter of developing a personal style, a good starting point for best results is achieved by holding the tip at a 75° angle. Hold the Filler Metal Rod at a 90° angle to the Tungsten Tip (**FIG. J**). Never allow the Tungsten Tip to touch the welding surface or material rod. Doing so will quickly destroy the tip and contaminate the weld. If this happens, remove the Tungsten and regrind the tip. It is best to hold the Tungsten 1/8" from the surface.
8. With your Welding Shield and all safety gear in place, depress the foot pedal or trigger and practice "Forming A Puddle" with the Tungsten Tip. Once you become familiar with this step. Practice the "Dip and Pull" technique with the Filler Metal Rod and Torch. "Dip and Pull" is the practice of forming a puddle, moving the torch while maintaining the puddle and adding filler rod metal to the puddle by "dipping and pulling" as you go; being careful not to allow the Tungsten to contact the puddle or rod.
9. Keep in mind that you **MUST** let the shielding gas flow over the weld after releasing the trigger or pedal. Failure to do so will allow the welded area to oxidize compromising the weld integrity.
10. Constantly be aware that TIG welding quickly generates heat in the work piece and torch. Severe burns can quickly occur by contacting hot metal pieces.
11. When done, shut off the Power Switch and close the Shielding Gas Tank valve completely.



WELDER CARE & MAINTENANCE

- Constantly inspect the torch tip for excessive erosion, molten metal accumulation burning. If damaged, it must be replaced.
- Before each use, inspect ALL electrical connections, cables, supply line, torch, air supply, housing and controls for damage. If any damage or wear is noted, DO NOT USE THE UNIT.
- If the welder requires service, it should be performed by a certified repair facility using only authorized replacement parts to maintain full safety and performance integrity of the welder.
- Always store the unit in a safe, clean and dry environment.

TORCH MAINTENANCE

⚠ WARNING ELECTRIC SHOCK CAN CAUSE INJURY OR DEATH!

Disconnect welder from power supply before assembly, disassembly or maintenance of the torch, contact tip and when installing or removing nozzles.

The Eastwood TIG 200 has a number of consumable parts that will need to be replaced over time. If wear or slag build up is noticed on any of the torch components, replace them immediately to avoid damage to the torch. Worn components will also contribute to poor performance. See the torch components (**FIG. H**) exploded view for a reference of all of the components and the assembly order.

STICK WELDING

⚠ WARNING WELDING SPARKS CAN CAUSE FIRE OR EXPLOSION!

Electric welding produces sparks which can be discharged considerable distances at high velocity igniting flammable or exploding vapors and materials.

Do not operate electric arc welder in areas where flammable or explosive vapors are present.

Do not use near combustible surfaces. Remove all flammable items within 35 feet of the welding area.

Always keep a fire extinguisher nearby while welding.

Use welding blankets to protect painted and or flammable surfaces; rubber weather-stripping, dash boards, engines, etc.

Ensure power supply has properly rated wiring to handle power usage.

⚠ WARNING FUMES & WELDING GASES CAN BE A HEALTH HAZARD!

Fumes and gasses released during welding are hazardous. Do not breathe fumes that are produced by the welding operation.

Wear an OSHA-approved respirator when welding.

Always work in a properly ventilated area.

Never weld coated materials including but not limited to: cadmium plated, galvanized, lead based paints.

⚠ WARNING ELECTRIC SHOCK CAN CAUSE INJURY OR DEATH!

Improper use of an electric welder can cause electric shock, injury and death! Read all precautions described in the Welder Manual to reduce the possibility of electric shock.

Disconnect welder from power supply before assembly, disassembly or maintenance of the torch, contact tip and when installing or removing nozzles.

Always wear dry, protective clothing and leather welding gloves and insulated footwear. Use suitable clothing made from durable flame-resistant material to protect your skin.

If other persons or pets are in the area of welding, use welding screens to protect bystanders from sparks.

Always operate the welder in a clean, dry, well ventilated area. Do not operate the welder in humid, wet, rainy or poorly ventilated areas.

The electrode and work (or ground) circuits are electrically "hot" when the welder is on. Do not allow these "hot" parts to come in contact with your bare skin or wet clothing.

Separate yourself from the welding circuit by using insulating mats to prevent contact from the work surface.

Be sure that the work piece is properly supported and grounded prior to beginning an electric welding operation.

Always attach the ground clamp to the piece to be welded and as close to the weld area as possible. This will give the least resistance and best weld.

⚠ CAUTION HOT METAL & TOOLS WILL BURN!

Electric welding heats metal and tools to temperatures that will cause severe burns!

Use protective, heat resistant gloves and clothing when using Eastwood or any other welding equipment. Never touch welded work surface, torch tip or nozzle until they have completely cooled.

⚠ WARNING ARC RAYS CAN BURN!

Arc rays produce intense ultraviolet radiation which can burn exposed skin and cause eye damage. Use a shield with the proper filter (a minimum of #11) to protect your eyes from sparks and the rays of the arc when welding or when observing open arc welding (see ANSI Z49.1 and Z87.1 for safety standards).

Use suitable clothing made from durable flame-resistant material to protect your skin.

If other persons or pets are in the area of welding, use welding screens to protect bystanders from sparks and arc rays.

1. Plug the power cord into a properly grounded, 110-120 Volt AC, 50/60Hz, 20 Amp or a 220-240 Volt AC 50/60Hz. 30 Amp circuit.
2. Move the TIG/Stick Switch to the "Stick" position.
3. Make sure the Electrode or "Stick" **is not making contact with the grounded workpiece.**
4. Switch the Power Switch to "On".
5. While wearing a properly functioning Auto Darkening Welding Helmet, lightly drag the tip of the Welding Rod along the workpiece surface to start an arc.
6. Feed the Welding Rod into the workpiece joint at a 15° angle.
7. Lift rod from workpiece when weld bead is completed.
8. Turn off Welder power switch.
9. Set the Electrode or "Stick" Holder on a safe, non-flammable, surface.

TROUBLESHOOTING TABLE



See page 18 for test points and values.
See page 20 for parts location.

SYMPTOM	POTENTIAL PROBLEM	DIAGNOSTIC TEST	SOLUTION
Nothing happens when power switched on	No or low A/C Voltage Source (120/240V AC)	Check A/C Voltage at Wall Outlet	Circuit breaker or wall circuit
	Loose or open connections at power switch	Visual and continuity test at switch connection	Repair loose/open connection
	Faulty power switch	Verify power switch function	Replace faulty power switch
Unit powers up but fan (upper or lower) not running	Open or Loose Connection in Fan Circuit of fan not running	Visual/Continuity Check of Fan Connections	Repair loose/open in Fan circuit
	Faulty Upper Fan	Check for 24V DC at X5 of Board PZ01-005	If 24V DC Present, Replace Fan
	Faulty Board PZ01-005		Replace Control Board
	Faulty Lower Fan	Check for 24V DC at X2 of Board PK02-018	If 0V DC, Replace Board PZ01-005
	Faulty Board PK02-018		If 0V DC, Replace Board PK02-018
Unit trips circuit breaker immediately when switched on	Short Circuit in Power Circuit	Inspect Power Circuit for Short Circuit	Repair Wiring or Replace Board PZ01-005 if Connector Damaged
	Short Circuit on Board PZ01-005	Inspect Silicon Bridge Socket (D4/D15) on Board PZ01-005 for Short/Damage	Replace Board PZ01-005
	Short Circuit on Board PM01-005	Inspect Board PM01-005 for Signs of Damage	Replace Board PM01-005
Unit turns on but power light not on	Open or Loose Connection	Check X9 on Board PM01-005 for loose or open connection	Repair loose/open circuit
	Faulty Board PM01-005	Check for 24V DC across Pins 3 and 4 at X4 on Board PM01-005	If 0V DC, Replace Board PM01-005
	Faulty Power Indicator Light	Check for Voltage at Power Indicator Light on Board PK08-008	If Voltage present, replace Board PK08-008
Overload light on, machine not operating	Duty Cycle Exceeded	Wait 5 Minutes for Unit to Cool	Restart Unit after Cooling Off
	Unit not cooling properly	Overload light comes on without exceeding duty cycle	Clean out unit with high pressure air
	Open or Loose connection between Board PZ01-005 and Board PM01-005	Check connection between X12 on Board PZ01-005 and X3 on Board PM01-005	Repair loose/open circuit
	Faulty Board PZ01-005 – short circuit	Inspect Board PZ01-005 for signs of damage	Replace Board PZ01-005
	Faulty Board PD01-006 – short circuit	Check Rectifier Diodes D1 to D12 for signs of damage	Replace Board PD01-006
	Faulty Board PD01-006 – short circuit	Inspect Board PM01-005 (MOSFETs) for signs of damage	Replace Board PM01-005

TROUBLESHOOTING TABLE



See page 18 for test points and values.
See page 20 for parts location.

SYMPTOM	POTENTIAL PROBLEM	DIAGNOSTIC TEST	SOLUTION
Overload light on, machine operating normally	Faulty Board PM01-005	Inspect MOSFETs Q1-Q12 on Board PM01-005 for Damage	Replace Board PM01-005
	Faulty Middle Board	Check Rectifier (Diodes D1-12) on Middle Board for Damage	Replace Middle Board
No air flow or arc when trigger pulled	Faulty Torch Trigger	Measure resistance across trigger terminals when trigger pulled (should = 0 ohms)	Replace Torch if switch faulty
	Loose or Open Connection in Torch Trigger Circuit	Visual and continuity check of trigger wiring and connections	Repair loose/open connection
	Faulty Torch Trigger Isolation Board	Short across Pins 1 and 2 at X2 on Board PK08-008	If Unit operates replace Torch Trigger Isolation Board
	Loose connection between Board PZ01-005 and Board PM01-005	Check connection from X12 on Board PZ01-005 and X3 on Board PM01-005	Repair Loose Connection
	Faulty Board PZ01-005	Check Voltage across Pins 1 and 7 at X3 on Board PM01-005 (Should be 310V DC)	If Voltage = 0V DC, Replace Board PZ01-005
	Faulty Board PM01-005 or Board PZ01-005	On Board PM01-005, measure voltage across and metal top (drains) of MOSFETs Q14 and Q19. Voltage should drop from 27V DC to 15V DC when trigger is pulled.	If Voltage drops when trigger pulled, replace Board PM01-005. If Voltage doesn't drop replace Board PZ01-005
Pilot arc but no air flow when trigger pulled	Air Supply Off or Blocked	Check air lines and connections for blockage for loose connections (including torch)	Re-attached, unblock, or replace air supply lines as needed
	Faulty Torch Switch	Inspect Torch for loose or open internal and external connections. Check Torch switch for proper function.	Repair open or loose connection, replace torch if needed
	Faulty Air Solenoid or Loose Connection	When trigger pulled, listen for Gas Solenoid click and check for 24V DC at X8 on Board PZ01-005	If 24V DC at X8 and no Click, check connection at X8 on Board PZ01-005, If connection OK, Replace Gas Solenoid
	Faulty Board PZ01-005	Check for 24V DC at X8 on Board PZ01-005 with trigger pulled.	If 0V DC at X8 when trigger pulled, replace Board PZ01-005

TROUBLESHOOTING TABLE



See page 18 for test points and values.
See page 20 for parts location.

SYMPTOM	POTENTIAL PROBLEM	DIAGNOSTIC TEST	SOLUTION
Air flow but no High Frequency Arc when trigger pulled	Open or Loose Internal Connection Between Board PM01-005 and Board PZ01-005	Check connection between X2 on the Board PM01-005 and X7 on the Board PZ01-005 for Open or Loose Connection	Repair loose connection
	Open or Loose Connections on Board PZ01-005	Check Connectors CP3, CP4, and X13 on Board PZ01-005 for Loose Connections	Repair loose connection
	Incorrect Arc Gap on Board PZ01-005	Arc Gap should be 1/16" and free of dirt and oxidation	Clean and adjust Arc Gap as necessary
	Faulty Board PZ01-005 or Board PM01-005	Unplug X2 on Board PM01-005 and measure no-load torch voltage when torch trigger is pulled	If 0 VDC, replace Board PM01-005. If 56 VDC, replace Board PZ01-005.
Weak or unstable cutting arc	Low Supply Voltage (possible undersized wiring or extension cord)	Check input voltage 220-240V AC	If less than 220V AC address line voltage
	Loose internal connections	Check for loose connections in internal power circuit (cord, switch, connection to Board PZ01-005) and Socket X6 on Board PM01-005.	Repair loose connection
	Loose or Poor Ground Connection	Inspect ground circuit for poor or loose connections	Repair loose connection or clean work piece
	Tungsten Rod too short	Check distance of Tungsten to work piece	Adjust Tungsten as needed
	Faulty Current Potentiometer	Check function of Potentiometer, 0-10k Ohm	Replace Board PK08-008
	Faulty 2200µF on Board PZ01-005	Check Capacitor for signs of damage/leakage.	Replace Capacitor or Board PZ01-005
	Faulty Board PZ01-005	Check Voltage across Pins 1 and 7 at X3 on Board PM01-005	If <310V DC, Replace Board PZ01-005
	Faulty Board PM01-005		If 310V DC, Replace Board PM01-005
No delay in air flow shut off when trigger released	Faulty Board PK02-018	Operate unit. Ensure normal operation noting delay time in solenoid closing after trigger released. Delay should be approximately 10 sec.	If no delay, Replace Board PK02-018

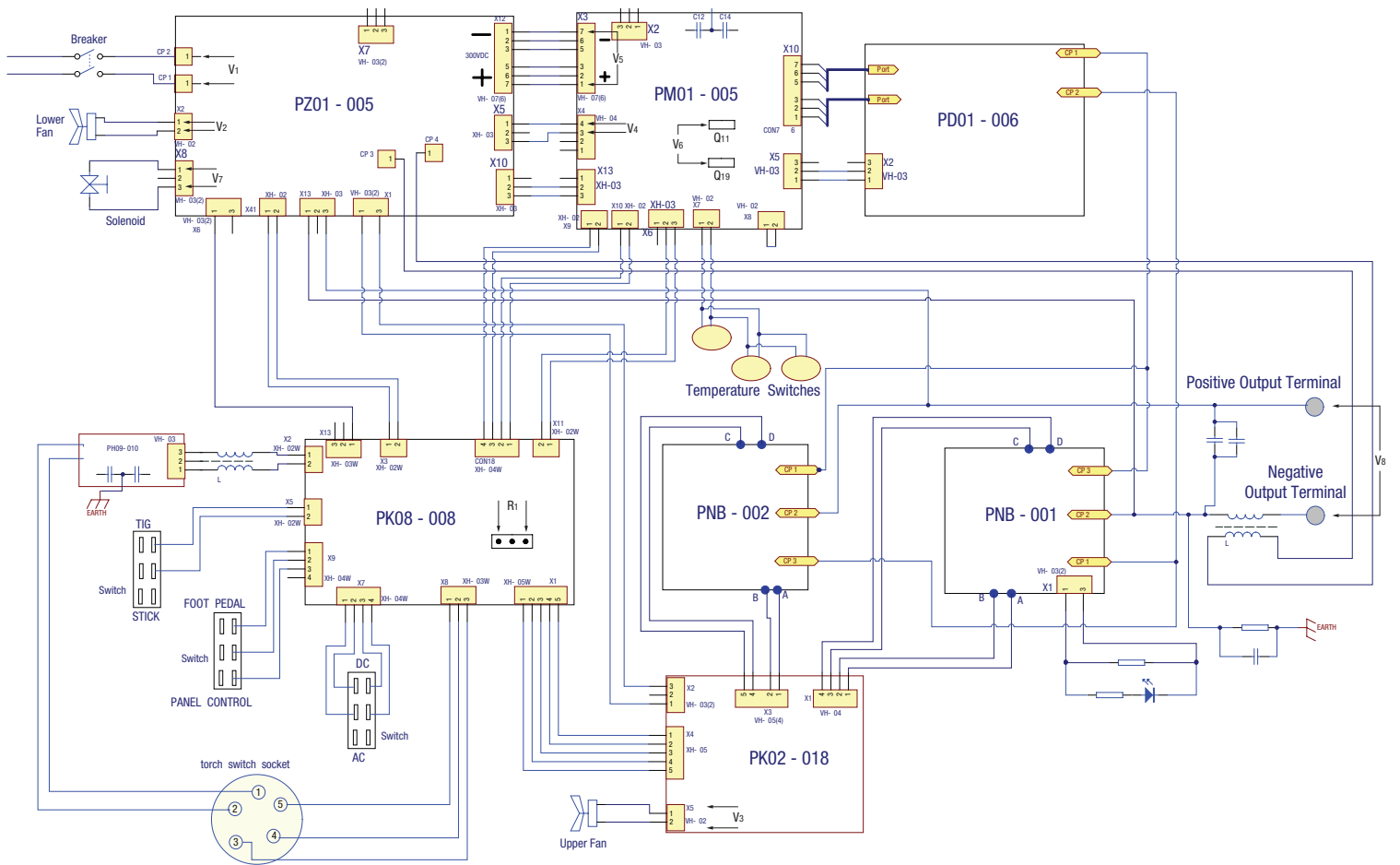
TROUBLESHOOTING TABLE



See page 18 for test points and values.
See page 19 for parts location.

SYMPTOM	POTENTIAL PROBLEM	DIAGNOSTIC TEST	SOLUTION
Pilot arc but no cutting arc	Loose or Damaged Torch Connections	Inspect Torch for damage or loose connections	Repair loose connections
	Loose or Poor Ground Connection	Inspect ground circuit for poor or loose connections	Repair loose connections
	Torch Nozzle or Electrode Damage	Inspect Torch nozzle and electrode for damage	Replace damaged components
	Damaged or loose connector on Board PK02-018	Check Connector X4 on Board PK02-018 for damage or looseness	Reconnect or repair connector X4
	Damaged Board PM01-005	Check for 24V DC on socket X4 on Board PM01-005	If 0V, replace Board PM01-005
	Damaged or loose connector on Board PM01-005	Check socket X9 on PM01-005	Reconnect or repair connector X9
	Faulty Arc Gap	Arc Gap should be 1/16" and free of dirt and oxidation.	Clean and adjust Arc Gap as necessary
HF Arc Continues while Welding	Faulty Board PZ01-005	Step above fails to resolve the problem	Replace Board PZ01-005

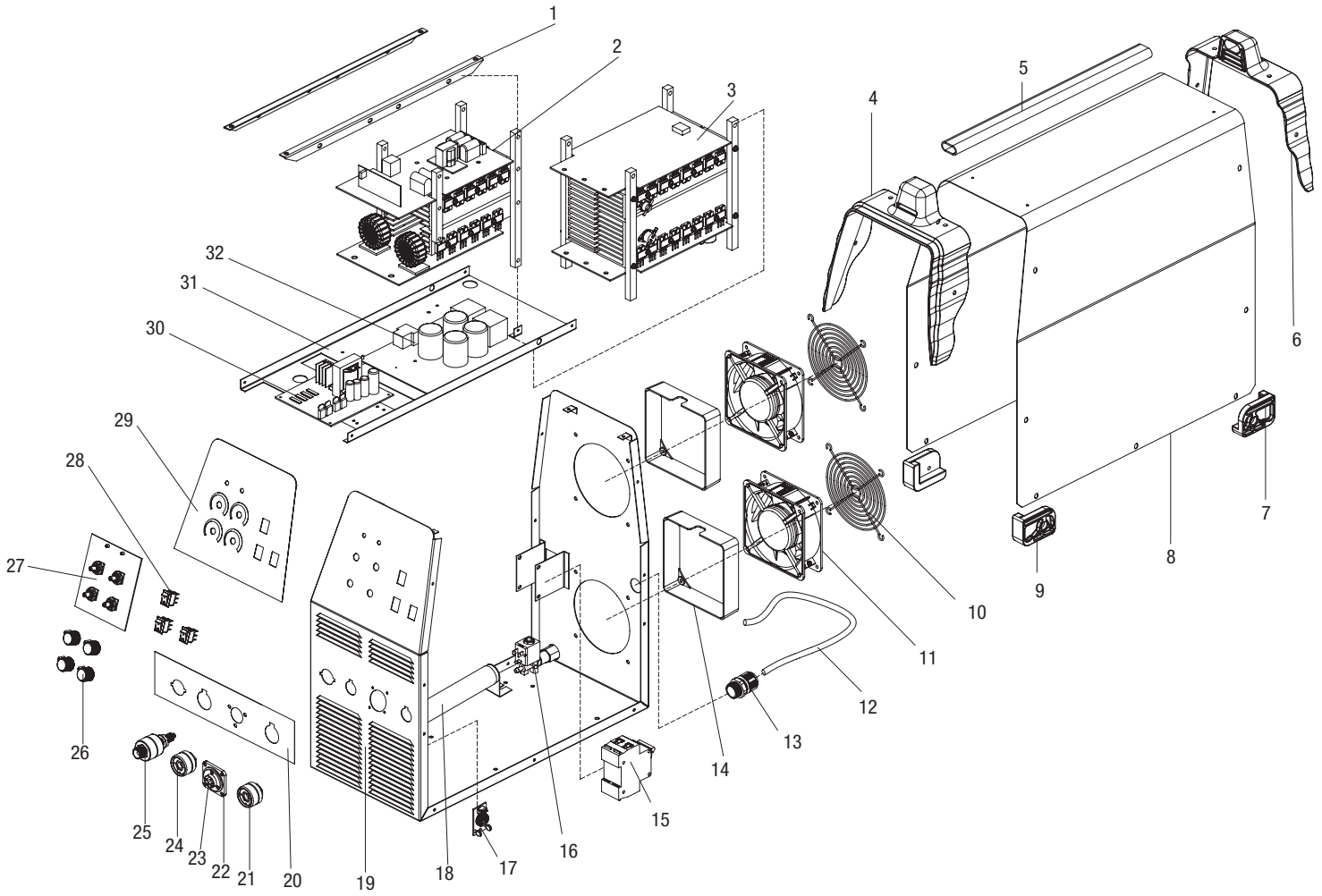
CIRCUIT DIAGRAMS WITH TEST VALUES



VOLTAGE READINGS

V1	Input Voltage – 120V AC or 240V AC
V2	Lower Fan Voltage – 24V DC
V3	Upper Fan Voltage – 24V DC
V4	24V DC
V5	310V DC
V6	27V DC changing to 15V DC when trigger pulled
V7	Solenoid Voltage – 24V DC
V8	No-load Output Voltage – 56V DC
R1	Current Potentiometer 0 – 10 kOhm

EXPLODED VIEW WITH PARTS LIST



REF #	ITEM #	DESCRIPTION
1	N/A	Board Support
2	N/A	Upper Inverter Module
	22502	Board PM01-005
	22503	Board PD01-006
3	N/A	Lower Inverter Module
	22504	Board PNB-02
	22505	Board PNB-01
4	N/A	Front Bezel
5	N/A	Handle
6	N/A	Rear Bezel
7	N/A	Left Foot
8	N/A	Upper Case
9	N/A	Right Foot
10	N/A	Fan Grill
11	22509	Fan
12	N/A	Cordset
13	N/A	Strain Relief
14	N/A	Fan Shroud
15	33097	Breaker
16	21266	Solenoid
17	N/A	Torch Switch Isolation Board
18	N/A	Resistor
19	N/A	Lower Case
20	N/A	Plug Backing Panel
21	N/A	Ground Cable Receptacle
22	N/A	Aviation Connector Insulator
23	N/A	Aviation Connector
24	N/A	Stick Electrode Holder Receptacle
25	N/A	TIG Torch Receptacle
26	N/A	Knob
27	22508	Potentiometer Board PK08-008
28	N/A	Rocker Switch
29	N/A	Front Panel Decal
30	22507	Secondary Drive PCB, PK02-018
31	N/A	Middle Partition
32	22506	Power Board, PZ01-005
Not Shown	21263	Ground Cable
Not Shown	21260	Tig Torch, Metal Plug
Not Shown	21258	Trigger with 5 Pin Connector
Not Shown	20284	#6/8 Gas Lens Component Kit
Not Shown	20652	#10/12 Gas Lens Component Kit
Not Shown	20653	#6 Gas Lens, 10-pack
Not Shown	20654	#8 Gas Lens, 10-pack
Not Shown	20655	#10 Gas Lens, 10-pack
Not Shown	20658	#12 Gas Lens, 10-pack
Not Shown	12238	Gas Regulator
Not Shown	22543	Gas Hose
Not Shown	12822	Collet, 1/16" (1.6 mm)
Not Shown	12824	Collet, 3/32 (2.4 mm)
Not Shown	13483	Collet Body, 1/16" (1.6 mm)
Not Shown	13484	Collet Body, 3/32" (2.4 mm)
Not Shown	12819	Ceramic Nozzle, 9.8 mm
Not Shown	12821	Ceramic Nozzle, 11.2 mm
Not Shown	12825	Long Black Cap
Not Shown	33097	Foot Pedal, Metal Plug
Not Shown	13953	TIG Accessories Kit

ACCESSORIES

TIG WIRE & TUNGSTEN:

- #12253 ER70S-2 Steel TIG Wire 1/16-36"
- #12254 ER70S-2 Steel TIG Wire 3/32-36"
- #12375 4043 Aluminum TIG Wire 1/16-36"
- #12376 4043 Aluminum TIG Wire 3/32-36"
- #12463 308L Stainless TIG Wire 1/16-36"
- #12464 308L Stainless TIG Wire 3/32-36"
- #20176 E3 Purple Tungsten 1/16-7" 2pc
- #20177 E3 Purple Tungsten 3/32-7" 2pc

NOTE: E³ Purple Tungsten is universal and can be used on steel, aluminum, and stainless steel.

REPLACEMENT ITEMS:

- #13483 TIG 200 Collet Body (1.6mm; 1/16")
- #13484 TIG 200 Collet Body (2.4mm; 3/32")
- #12822 TIG 200 Collet (1.6mm; 1/16")
- #12824 TIG 200 Collet (2.4mm; 3/32")
- #12825 TIG 200 Long Back Cap
- #12819 TIG 200 Gas Nozzle (9.8mm; 3/8")
- #12821 TIG 200 Gas Nozzle (11.2mm; 1/2")
- #13953 TIG Accessory Kit
- #20284 Gas Lens Kit

OTHER WELDING ACCESSORIES:

- #20493 Upgraded Foot Pedal
- #11947 Flap Disc 60 Grit 4.5" Diameter 7/8" Hole
- #12590 Welding Gloves Large
- #12589 Welding Gloves Medium
- #20189 Extra-Large-View Auto Darkening Welding Helmet
- #12099 Auto Darkening Welding Helmet
- #19079S Stainless Steel Brush
- #51139 Copper 3 x 3 Welders Helper Set
- #50739 Master Welder's Helper Panel Holding Kit
- #19015 Welders Pliers
- #12762L, XL, XXL Welding Jacket
- #11616 TIG 200 Welding Cart
- #20517 Stick Electrode Holder

If you have any questions about the use of this product, please contact

The Eastwood Technical Assistance Service Department: 800.343.9353 >> email: tech@eastwood.com

PDF version of this manual is available at eastwood.com

The Eastwood Company 263 Shoemaker Road, Pottstown, PA 19464, USA 800.343.9353 eastwood.com

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