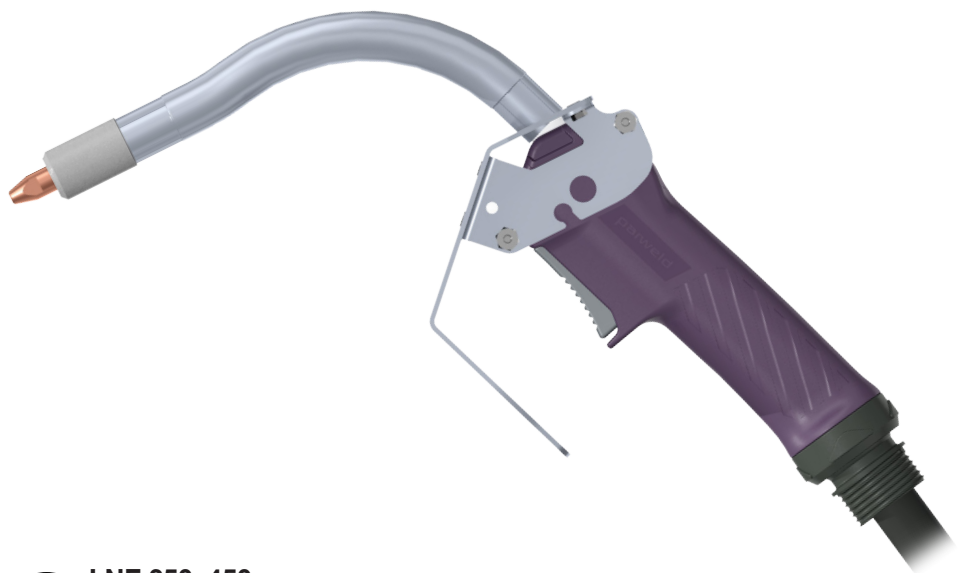


LNE 350, 450

User instructions



EN LNE 350, 450
User instructions

EN English

Safety



WARNING



Read Instructions

Before using this product, read the instructions and any related data sheets. (See www.parweld.com).



Fumes and Gases

Fumes and gases emitted during welding may be dangerous, use adequate ventilation and extraction equipment.



Arc Rays

Arc rays may burn eyes and skin. Wear protective clothing.



Electric Shock

Electric shocks can kill, use adequate protective equipment. Ensure a safe earth connection. Do not touch electrical parts or electrode.



Burn and Fire Hazard

Weld and metal parts are hot and cause serious burn injuries if touched. Sparks can cause burns and fire. Remove all flammable materials from the welding area.



Injury can occur from bodily contact with hot parts, sparks, fumes, dust, noise and vibration.



Protect your eyes and face with a mask fitted with a filter lens. Use welding screens.



Wear protective clothing to protect your body and ears.



Use adequate ventilation or wear respirator equipment to prevent dust, fumes and gases from entering your lungs.

Torch Key Features

The PRO-FC torch and cable assemblies have been designed specifically for welding with the self shielded (FCAW) process. The PRO-FC torches are designed to give extended life and improved wire feeding in heavy duty welding applications. The cable jacketing is made from a cross linked polymer which provides exceptional heat resistance and fatigue life. A round wound spring steel liner is used to optimise the wire feeding.

MODEL	PRO-FC 350A	PRO-FC 450A
SKU	LNE3500-08E LNE3500-10E LNE3500-15E	LNE4500-08E LNE4500-10E LNE4500-15E
COOLING	AIR	AIR
RATING	350A	450A
DUTY CYCLE	60%	60%
WIRE SIZE	1.0-1.20MM	1.6MM-3.2MM
STANDARDS	EN60974-7 ISO 21904-1	EN60974-7 ISO 21904-1

Introduction - Getting Started

Please read thoroughly and understand this user manual to ensure correct, safe and effective use of the equipment. Failure to do so can result in serious injury. Also keep the manual safely for future reference.

Warning: When welding, use additional safety equipment that provides suitable protection against harmful fumes and gasses, burns from hot objects and radiation.

Warning: Always disconnect from the equipment from power supply when setting up or performing maintenance checks.

Warning: Allow equipment to cool after use before handling to avoid burns.

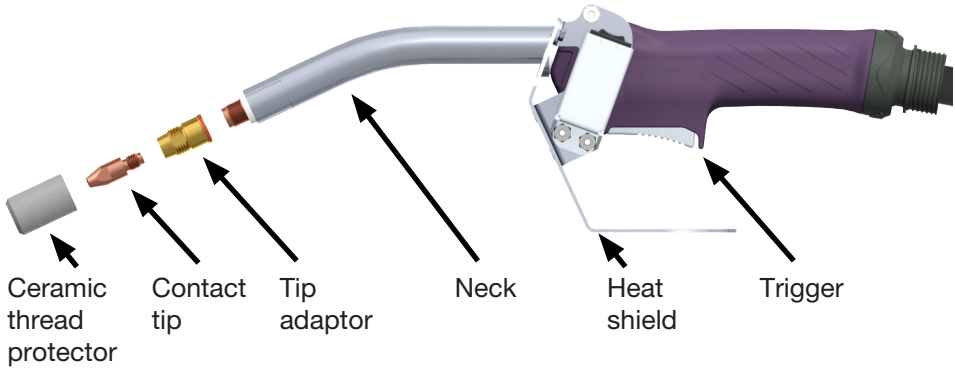
Warning: PRO-FC MIG torches must be used in conjunction with suitable fume extraction equipment capable of extracting fume, and the welder should be protected with appropriate PPE for the task.

Before use;

- Check equipment, that all parts are present and not damaged.
- Check front end is clean, free of debris and no spatter is trapped between mating parts that may cause short circuit.
- Check protection nozzle is clean, free of debris.
- Before welding commences check the area around you is free from flammable materials and un protected persons.

Parts Identification

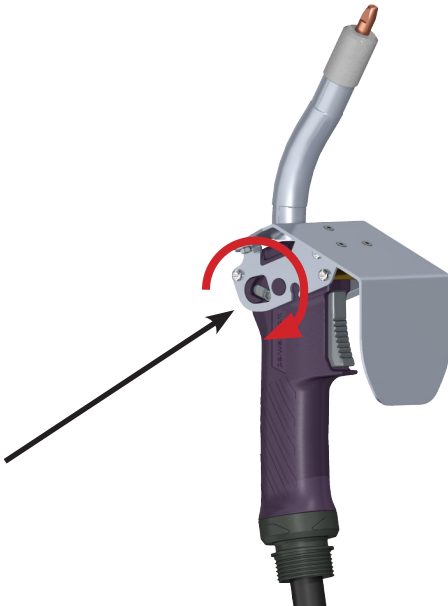
PARTS



Neck Removal and Adjustment

The neck can be rotated or removed quickly using a 5mm hex key.

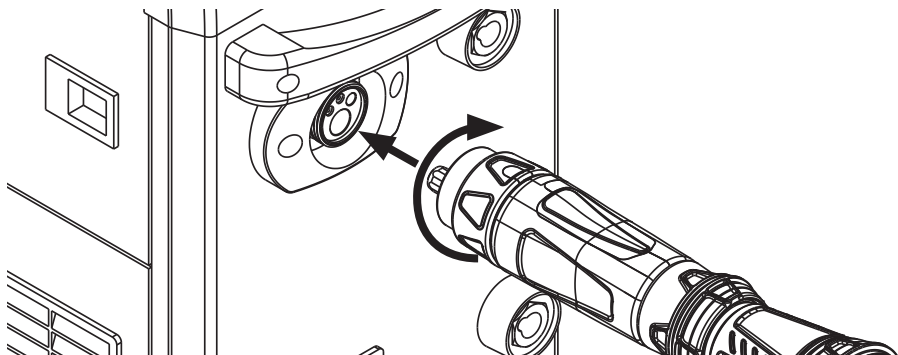
- 1) Rotate the cove on the side of the handle using a 5mm hex key to reveal the screw below.



- 2) Release the set screw and withdraw or rotate the neck as required.
- 3) Once complete tighten the setscrew (5mm) and close the protective cover.

Torch Set Up - Connecting Torch to Machine

Connect the torches rear gun plug to the MIG welding machines torch socket. Screwing the plug nut on tight.



Lay torch out straight and flat. Feed the wire through the torch, using the power source inching control, until it extends from the contact tip.

Trim back to about 10-to-12mm.

You are now ready to weld. With the power source switched on you can depress the trigger holding the torch approximately 15mm from the job.

Scheduled Maintenance and Cleaning

Allow equipment to cool after use before handling to avoid burns.

Wear the correct protective clothing and gloves.

Weekly or Monthly Maintenance Depending on the torches usage, the following must be made on the full torch assembly.

- Remove all front consumables, and clean threads with a cloth or soft wire brush, replace any damaged or defective parts.
- Check for damage to the torch neck insulation.
- Check harness for any damage, puncture holes, that may cause shorting of the cables.

Fault Finding

Fault	Cause and Remedy
Welding arc does not start when trigger is depressed	Check power supply is working Check torch connection Check torch trigger is working Ensure work lead is connected to the job Rectify or repair
Weld is poor	Check welding settings and adjust Check work lead connection Check front consumable parts for damage, clean and replace
Wire feed not working properly	Check wire feed roll pressure adjustment Check feed roll wear Replace fault rolls or torch liner

PRO-FC EURO CONNECTOR LINERS

LINERS	PLAIN	STOCK CODE	LENGTH	WIRE SIZE	LNE 350A	LNE 450A
		A	LNE5033-08	8ft	1.0-1.2mm (.040-.045")	■
			LNE5033-10	10ft	1.0-1.2mm (.040-.045")	■
			LNE5033-15	15ft	1.0-1.2mm (.040-.045")	■
		B	LNE5034-08	8ft	1.2-1.6mm (.045-1/16")	■
			LNE5034-10	10ft	1.2-1.6mm (.045-1/16")	■
			LNE5034-15	15ft	1.2-1.6mm (.045-1/16")	■
		C	LNE4033-08	8ft	2.0-2.4mm (5/64-3/32")	■
			LNE4033-10	10ft	2.0-2.4mm (5/64-3/32")	■
			LNE4033-15	15ft	2.0-2.4mm (5/64-3/32")	■
		D	LNE6033-08	8ft	1.6-2.4mm (1/16-3/32")	■
			LNE6033-10	10ft	1.6-2.4mm (1/16-3/32")	■
			LNE6033-15	15ft	1.6-2.4mm (1/16-3/32")	■
			LNE6034-08	8ft	2.4mm (3/32")	■
			LNE6034-10	10ft	2.4mm (3/32")	■
			LNE6034-15	15ft	2.4mm (3/32")	■
			LNE6035-08	8ft	2.8-3.2mm (.11-1/8")	■
			LNE6035-10	10ft	2.8-3.2mm (.11-1/8")	■
			LNE6035-15	15ft	2.8-3.2mm (.11-1/8")	■



■ Solid Box =
Recommended Liner

PRO-FC DIRECT PIN CONNECTOR LINERS

Only to be used in conjunction with modular power pins

LINERS	PLAIN	STOCK CODE	LENGTH	WIRE SIZE	LNE 350A	LNE 450A
		A	LNE5033-08P	8ft	1.0-1.2mm (.040-.045")	■
			LNE5033-10P	10ft	1.0-1.2mm (.040-.045")	■
			LNE5033-15P	15ft	1.0-1.2mm (.040-.045")	■
			LNE5034-08P	8ft	1.2-1.6mm (.045-1/16")	■
			LNE5034-10P	10ft	1.2-1.6mm (.045-1/16")	■
			LNE5034-15P	15ft	1.2-1.6mm (.045-1/16")	■
			LNE4033-08P	8ft	2.0-2.4mm (5/64-3/32")	■
			LNE4033-10P	10ft	2.0-2.4mm (5/64-3/32")	■
			LNE4033-15P	15ft	2.0-2.4mm (5/64-3/32")	■
		B	LNE6033-08P	8ft	1.6-2.4mm (1/16-3/32")	■
			LNE6033-10P	10ft	1.6-2.4mm (1/16-3/32")	■
			LNE6033-15P	15ft	1.6-2.4mm (1/16-3/32")	■
			LNE6034-08P	8ft	2.4mm (3/32")	■
			LNE6034-10P	10ft	2.4mm (3/32")	■
			LNE6034-15P	15ft	2.4mm (3/32")	■
			LNE6035-08P	8ft	2.8-3.2mm (.11-1/8")	■
			LNE6035-10P	10ft	2.8-3.2mm (.11-1/8")	■
			LNE6035-15P	15ft	2.8-3.2mm (.11-1/8")	■



■ Solid Box =
Recommended Liner

□ Clear Box =
Compatible Liner

0.6-0.9mm
Wire ■ Blue

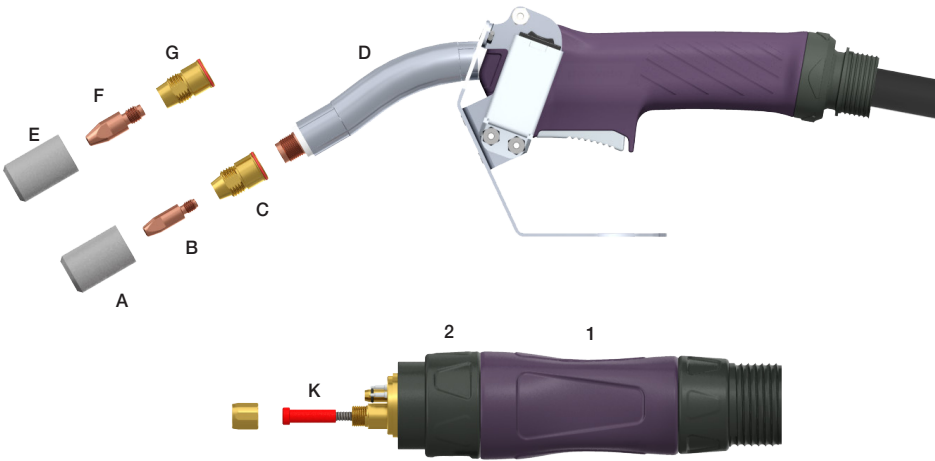
1.0-1.2mm
Wire ■ Red

1.2-1.6mm
Wire ■ Yellow

PRO-FC 350A

SELF SHIELDED FLUX CORE WELDING TORCH

350A @ 60% DUTY CYCLE, EN60974-7, 1.0MM-2.4MM (.040"-3/32") WIRES



Torch Package	
STOCK CODE	DESCRIPTION
LNE3500-08E	Torch Package x 8ft c/w Euro Fitting
LNE3500-10E	Torch Package x 10ft c/w Euro Fitting
LNE3500-15E	Torch Package x 15ft c/w Euro Fitting

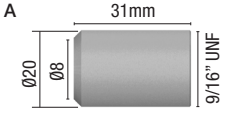
STOCK CODE	DESCRIPTION
1 LNE1518	Gun Plug Housing c/w Nut
2 LNE1519	Gun Plug Nut

K	Liners
STOCK CODE	DESCRIPTION
LNE5033-08	Plain, 1.0-1.2mm (.040-.045") x 8ft
LNE5033-10	Plain, 1.0-1.2mm (.040-.045") x 10ft
LNE5033-15	Plain, 1.0-1.2mm (.040-.045") x 15ft
LNE5034-08*	Plain, 1.2-1.6mm (.045-1/16") x 8ft
LNE5034-10*	Plain, 1.2-1.6mm (.045-1/16") x 10ft
LNE5034-15*	Plain, 1.2-1.6mm (.045-1/16") x 15ft
LNE4033-08	Plain, 2.0-2.4mm (5/64-3/32") x 8ft
LNE4033-10	Plain, 2.0-2.4mm (5/64-3/32") x 10ft
LNE4033-15	Plain, 2.0-2.4mm (5/64-3/32") x 15ft

EUROPEAN CONSUMABLES:

Thread Protector

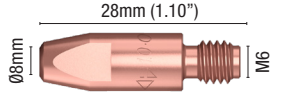
A



STOCK CODE	TIP SIZE
LNE3502*	M6

Contact Tips

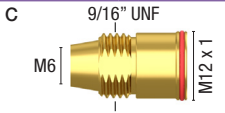
B



STOCK CODE	WIRE SIZE	MATERIAL
LNE2504-10	1.0mm (.040")	ECu
LNE2504-12	1.2mm (.045")	ECu
LNE2504-14	1.4mm (.055")	ECu
LNE2504-16*	1.6mm (1/16")	ECu

Tip Adaptor

C



STOCK CODE	TIP SIZE
LNE3506	M6

Swan Neck

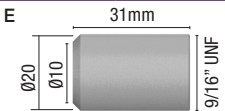
D



STOCK CODE	LENGTH	ANGLE
LNE35630	6"	30°

Thread Protector

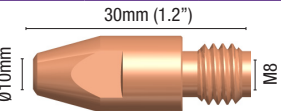
E



STOCK CODE	TIP SIZE
LNE4502	M8/M10

Contact Tips

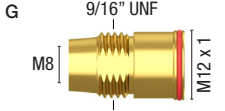
F



STOCK CODE	WIRE SIZE	MATERIAL
LNE4014-10	1.0mm (.040")	ECu
LNE4014-12	1.2mm (.045")	ECu
LNE4014-14	1.4mm (.055")	ECu
LNE4014-16	1.6mm (1/16")	ECu
LNE4014-20	2.0mm (5/64")	ECu
LNE4014-24	2.4mm (3/32")	ECu

Tip Adaptor

G



STOCK CODE	TIP SIZE
LNE4508	M8

Swan Neck

D



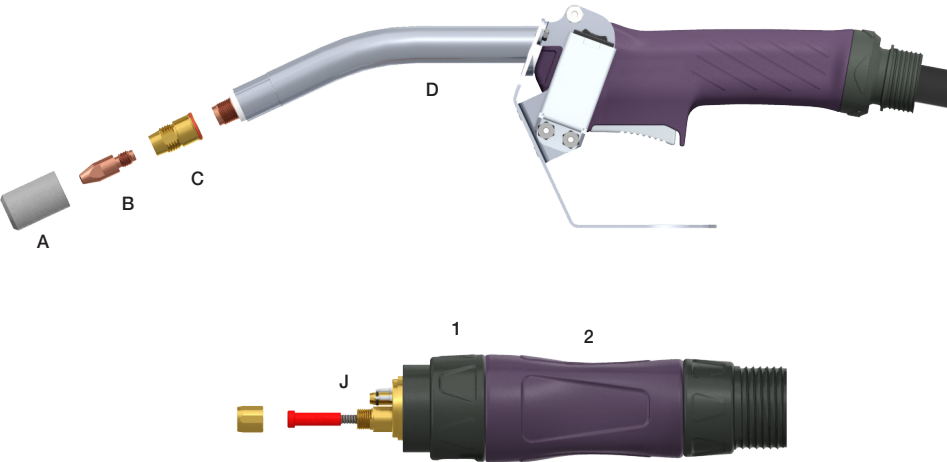
STOCK CODE	LENGTH	ANGLE
LNE35630	6"	30°

* Denotes standard build

PRO-FC 450A

SELF SHIELDED FLUX CORE WELDING TORCH

450A, @ 60% Duty Cycle, EN60974-7, 1.6mm-3.2mm (1/16"-1/8") Wires



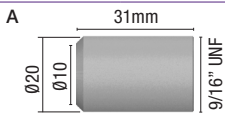
Torch Package	
STOCK CODE	DESCRIPTION
LNE4500-08E	Torch Package x 8ft c/w Euro Fitting
LNE4500-10E	Torch Package x 10ft c/w Euro Fitting
LNE4500-15E	Torch Package x 15ft c/w Euro Fitting

STOCK CODE	DESCRIPTION
1 LNE1518	Gun Plug Housing c/w Nut
2 LNE1519	Gun Plug Nut

J Liners	
STOCK CODE	DESCRIPTION
LNE6033-08*	Plain, 1.6-2.4mm (1/16-3/32") x 8ft
LNE6033-10*	Plain, 1.6-2.4mm (1/16-3/32") x 10ft
LNE6033-15*	Plain, 1.6-2.4mm (1/16-3/32") x 15ft
LNE6035-08	Plain, 2.8-3.2mm (.11-1/8") x 8ft
LNE6035-10	Plain, 2.8-3.2mm (.11-1/8") x 10ft
LNE6035-15	Plain, 2.8-3.2mm (.11-1/8") x 15ft

EUROPEAN CONSUMABLES:

Thread Protector



A

31mm

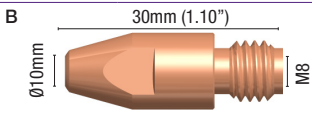
Ø20

Ø10

9/16" UNF

STOCK CODE	TIP SIZE
LNE4502	M8/M10

Contact Tips



B

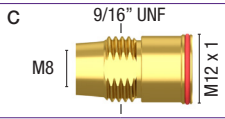
30mm (1.10")

Ø10mm

M8

STOCK CODE	WIRE SIZE
LNE4014-10	1.0mm (.040")
LNE4014-12	1.2mm (.045")
LNE4014-14	1.4mm (.055")
LNE4014-16	1.6mm (1/16")
LNE4014-20	2.0mm (5/64")
LNE4014-24	2.4mm (3/32")

Tip Adaptor



C

9/16" UNF

M8

M12 x 1

STOCK CODE	TIP SIZE
LNE4508	M8

Swan Neck



D

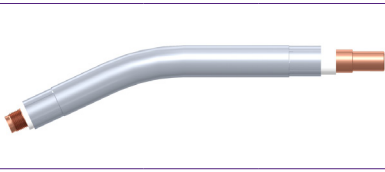
M2 x 1

STOCK CODE	LENGTH	ANGLE
LNE45925	9"	25°

PRO-FC SWAN NECK

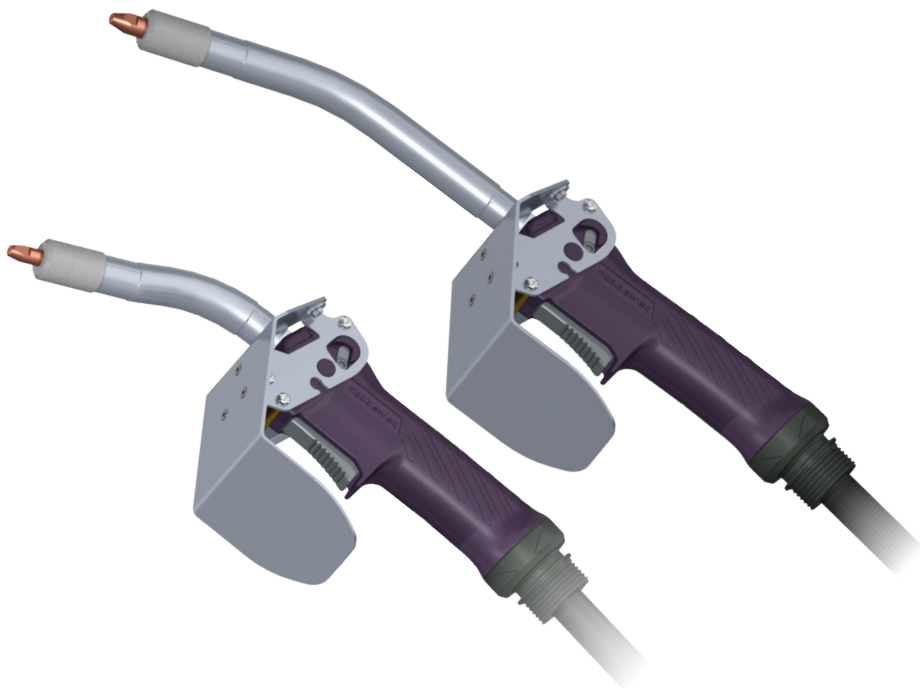
EUROPEAN SPECIFICATION:

Swan Neck



STOCK CODE	LENGTH	ANGLE
LNE45925	9"	25°

* Denotes standard build



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