Grizzly Industrial, Inc.®

MODEL T34311
3-IN-1 WELDER MIG, MMA, TIG
OWNER'S MANUAL
(For models manufactured since 08/24)



⚠ WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.

Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

⚠ WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

MODEL T34311 3-IN-1 WELDER MIG, MMA, TIG

Product Dimensions:

Weight	9 lbs.
Width (side-to-side) x Depth (front-to-back) x Height	6 x 11-1/2 x 6-1/2 in.

Shipping Dimensions:

Type	Cardboard
Content	Machine
Weight	13 lbs.
Length x Width x Height	15 x 11 x 13 in.
Must Ship Upright	Yes

Electrical:

Power Requirement	110V, Single-Phase, 60 Hz
Minimum Circuit Size	20A
Output Current Range (MMA)	20 - 100A
Output Current Range (MIG)	20 - 120A
Output Current Range (TIG)	20 - 120A
Output Voltage Range	10 - 24V
Duty Cycle - MMA	30% @ 120A
Duty Cycle - MIG	60% @ 90A
Duty Cycle - TIG	100% @ 80A
Power Cord Length	60 in.
Power Cord Gauge	16 AWG
Included Plug Type	5-15
Switch Type	ON/OFF Switch

Operation Information:

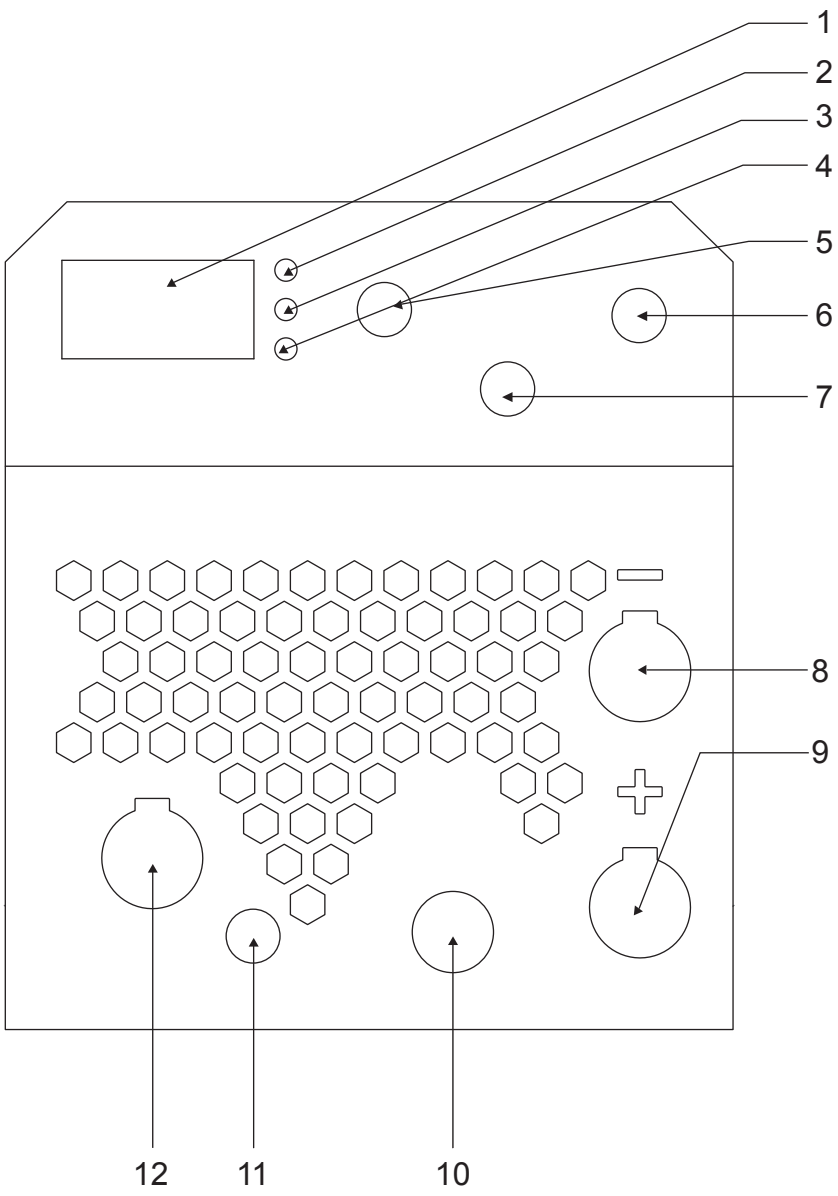
Minimum Material Thickness	0.39 in.
Maximum Material Thickness	1.96 in.
Wire Feed Speed Range (Inches Per Minute)	4-1/2 - 44-1/2 IPM
Wire Diameter Range	0.030 - 0.039 in.
Maximum Wire Spool Diameter	21½ in.
Torch Cable Length	118 in.
Ground Cable Length	60 in.
Electrode Cable Length	60 in.
Electrode Diameter Range	1/16 - 1/8 in.

Other Specifications:

Country of Origin	China
Warranty	1 Year
Approximate Assembly & Setup Time	15 Minutes
Serial Number Location	Machine ID Label
Housing Protection Class	IP21S

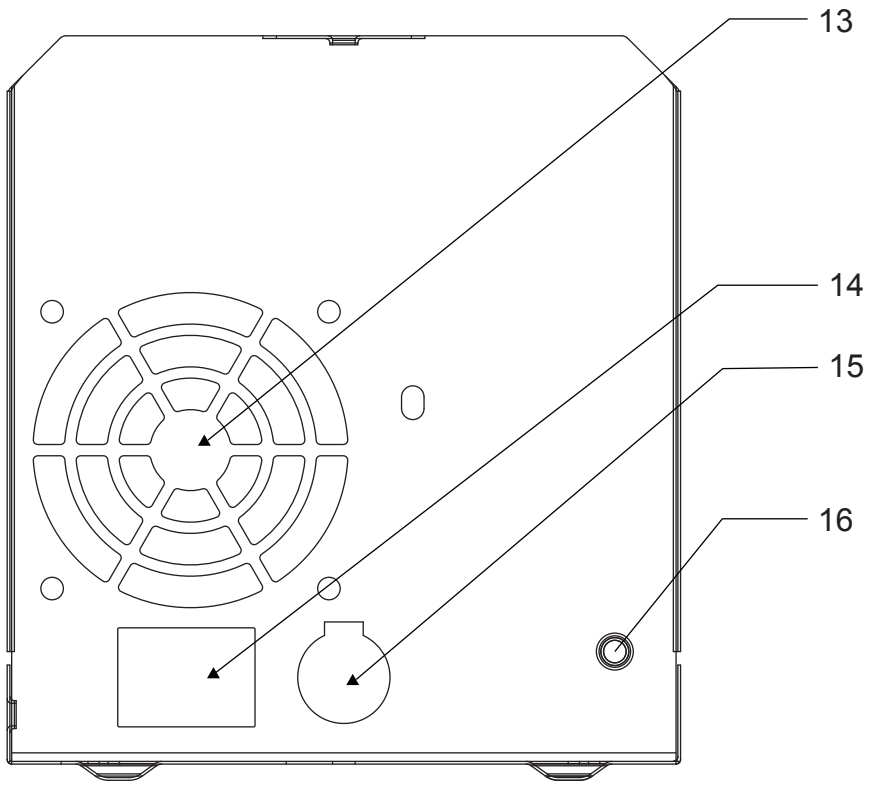
Controls

Front panel



1. Digital Display
2. MIG Mode LED
3. MMA Mode LED
4. TIG Mode LED
5. MIG/MMA/TIG Switch
6. Current Adjustment Knob
7. Voltage Adjustment Knob
8. Negative Socket
9. Positive Socket
10. Polarity Selection Plug
11. Torch Switch Cord
12. Torch Socket

Rear Panel



13. Fan
14. Power Switch
15. Input Power
16. Ground Screw

⚠WARNING

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

⚠CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

For Your Own Safety, Read Instruction Manual Before Operating This Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures. Always use common sense and good judgment.

⚠DANGER **Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.**

⚠WARNING **Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.**

⚠CAUTION **Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.**

NOTICE **Alerts the user to useful information about proper operation of the machine to avoid machine damage.**

Safety Instructions for Machinery

⚠WARNING

OWNER'S MANUAL. Read and understand this owner's manual BEFORE using machine.

TRAINED OPERATORS ONLY. Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make your workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

MENTAL ALERTNESS REQUIRED. Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

ELECTRICAL EQUIPMENT INJURY RISKS. You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To reduce this risk, only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

DISCONNECT POWER FIRST. Always disconnect machine from power supply BEFORE making adjustments, changing tooling, or servicing machine. This prevents an injury risk from unintended startup or contact with live electrical components.

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are NOT approved safety glasses.

⚠WARNING

WEARING PROPER APPAREL. Do not wear loose clothing, gloves, neckties, or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

HAZARDOUS DUST. Dust created by machinery operations may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material. Always wear a NIOSH-approved respirator to reduce your risk.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

USE CORRECT TOOL FOR THE JOB. Only use this tool for its intended purpose—do not force it or an attachment to do a job for which it was not designed. Never make unapproved modifications—modifying tool or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

CHILDREN & BYSTANDERS. Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly BEFORE operating machine.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

NEVER STAND ON MACHINE. Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

USE RECOMMENDED ACCESSORIES. Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn machine ***OFF*** and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

DAMAGED PARTS. Regularly inspect machine for damaged, loose, or mis-adjusted parts—or any condition that could affect safe operation. Immediately repair/replace BEFORE operating machine. For your own safety, DO NOT operate machine with damaged parts!

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

EXPERIENCING DIFFICULTIES. If at any time you experience difficulties performing the intended operation, stop using the machine! Contact our Technical Support at (570) 546-9663.

Additional Safety for Welders

⚠WARNING

Serious injury, burns, electric shock, or death can occur from misuse of the welder. Welding fumes can cause suffocation or poisoning if operating in an enclosed space. Arc rays can cause eye injury. Sparks and spatter can cause nearby flammable materials to ignite. To reduce the risks of welding, anyone operating this machine MUST completely heed the hazards and warnings below.

WELDING FUMES. Breathing welding fumes can cause suffocation or poisoning without warning. Keep your head out of welding fumes. Use adequate ventilation at arc to safely remove fumes from your breathing zone and general area. Use ANSI-approved respirators recommended for type of welding operation. Protect others from these fumes.

ELECTRIC SHOCK. Connect welder to power source with approved earth ground. Make sure all electrical connections are tight, clean, and dry. Connect workpiece to approved earth ground. Work lead is NOT a ground connection and is to be used only to complete working welding circuit. Welding in wet and humid conditions drastically increases risk of electrical shock.

PREVENT FIRES. Keep welding work zones clear of flammable liquids, such as gasoline and solvents; combustible solids, such as paper and wood; and flammable gases, such as acetylene and hydrogen. Provide approved fire barriers and fire extinguishing equipment for welding zone of at least 35' radius. Stay alert for sparks and spatter thrown into cracks and crevices that can start smoldering fire.

HANDLING GAS CYLINDERS. Regardless of content, pressurized gas cylinders can explode. Always secure protector cap in place over outlet valve assembly when moving cylinder. Broken valve could release pressurized contents and cause cylinder to be hurled about at dangerously high speeds, causing serious property damage, personal injury, or death. Always use safe methods when moving gas cylinders. Secure gas cylinder to wall or approved cylinder cart with chain before using or storing.

PROTECTING GAS CYLINDERS. Excessive heat can cause pressurized gas to expand and explode cylinder. Never weld on gas cylinder. Damaging cylinder can cause cylinder to crack and explode. Exploding pressurized gas cylinders can cause serious property damage, personal injury, or death.

WORK AREA. Keep working area clear of any material not involved in welding operation. Keep all equipment, workpieces, and work surfaces clean, dry, and free of entanglements. Keep lead cables organized and away from your body.

WORKPIECE. Take proper precautions and think about workpiece you are welding on. Welding certain treated metals, such as galvanized steel, can create severely toxic fumes. DO NOT weld, burn, or heat sealed or pressurized containers. Observe specific guidelines when welding workpiece to ensure safe practice has not been overlooked.

ARC BURNS, SPARKS, SPATTER, AND HOT MATERIALS. Welding without complete and approved body protection can cause severe damage to eyes and body. Wear non-flammable protective clothing, welding gloves, cap, long-sleeve shirt, cuffless pants, and leather boots. DO NOT wear jewelry or frayed clothing. Use welding helmet with correct shade of filter for operation. Protect bystanders and property in working zone from exposure to arc radiation, sparks, and spatter. Welding operations create extreme amounts of heat. Make sure to allow for cooling before handling welded materials.

WELDING IN CONFINED SPACES. Always open all covers, sustain forced ventilation, remove toxic and hazardous materials, and provide a power disconnect to the welder inside the work space. Always work with someone who can give you help from outside the space. Welding can displace oxygen. Always check for safe breathing atmosphere and provide air-supplied respirators if necessary. Keep in mind that all normal welding hazards are intensified in a confined space.

ELECTROMAGNETIC FIELDS (EMF). Welding operations create EMF around welding equipment and workpieces. Operators with pacemakers must consult their physician before using this equipment, or being within 50' of welding operations.

Additional Sources for Welding Codes and Standards

American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33166-6672, (305) 443-9353, Website: *www.aws.org*.

—Safety in Welding, Cutting, and Allied Processes, ANSI Standard Z49.1

—Safe Practices for the Preparation of Containers and Piping for Welding, Cutting, and Allied Processes, AWS F4.1

National Fire Protection Association, P. O. Box 9101, 1 Batterymarch Park, Quincy, MA 02169-7471, (617) 770-3000, Website: *www.nfpa.org* and *www.sparky.org*.

—National Electrical Code, NFPA Standard 70

—Standard for Fire Prevention During Welding, Cutting, and Other Hot Work, NFPA Standard 51B

Compressed Gas Association, 8484 Westpark Dr., Ste. 220, McLean, VA 22102, (703) 788-2700, Website: *www.cganet.com*.

—Standard for Safe Handling of Compressed Gases in Containers, CGA Pamphlet P-1

Canadian Standards Association, Standards Sales, 178 Rexdale Blvd., Ontario, Canada M9W 1R3, (416) 747-4000, Website: *www.csa-international.org*.

—Safety in Welding, Cutting, and Allied Processes, CSA Standard W117.2-06

American National Standards Institute (ANSI), 1180 Avenue of the Americas, 10th Fl., New York, NY 10036, (212) 642-4900, Website: *www.ansi.org*.

—Standard for Occupational and Educational Personal Eye and Face Protection Devices, ANSI Z87.1-2020

Occupational Safety and Health Administration (OSHA)

— Code of Federal Regulations, Title 29 Labor, Parts 1910.1 to 1910.1450, available from the U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250-7954, (800) 321-6742, Website: *www.osha.gov*

American Conference of Government Industrial Hygienists (ACGIH), 3640 Park 42 Dr., Cincinnati, OH 45241, (513) 742-2020, Website: *www.acgih.org*.

—Threshold Limit Values and Biological Exposure Indices (Booklet)

National Institute for Occupational Safety and Health (NIOSH), 1090 Tusculum Ave., Cincinnati, OH, 45226, (800) 356-4674, Website: *www.cdc.gov/niosh*

— Safety and Health in Arc Welding and Gas Welding and Cutting, NIOSH Publication No. 78-138

⚠WARNING

DO NOT start machine until all installation and operation instructions have been performed. Operating an improperly set up machine may result in malfunction or unexpected results that can lead to serious injury, death, or machine/property damage.



⚠WARNING

Always wear an ANSI-approved welding helmet, safety goggles, and hearing protection when using this machine.

Power Supply

Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by an electrician or qualified service personnel in accordance with all applicable codes and standards.



⚠WARNING

Electrocution, fire, shock, or equipment damage may occur if machine is not properly grounded and connected to power supply.

Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating at 110V ..... 20 Amps

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the specified circuit requirements.

⚠WARNING

Serious injury could occur if you connect machine to power before completing setup process. DO NOT connect to power until instructed later in this manual.

110V Circuit Requirements

This machine is prewired to operate on a power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 110V, 115V, 120V
Cycle ..... 60 Hz
Phase ..... Single-Phase
Power Supply Circuit ..... 20 Amps
Plug/Receptacle ..... NEMA 5-15

A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)

⚠CAUTION

For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or electrical codes in your area.

Note: *Circuit requirements in this manual apply to a dedicated circuit—where only one machine will be running on the circuit at a time. If machine will be connected to a shared circuit where multiple machines may be running at the same time, consult an electrician or qualified service personnel to ensure circuit is properly sized for safe operation.*

Grounding & Plug Requirements

This machine MUST be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug. Only insert plug into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances. DO NOT modify the provided plug!

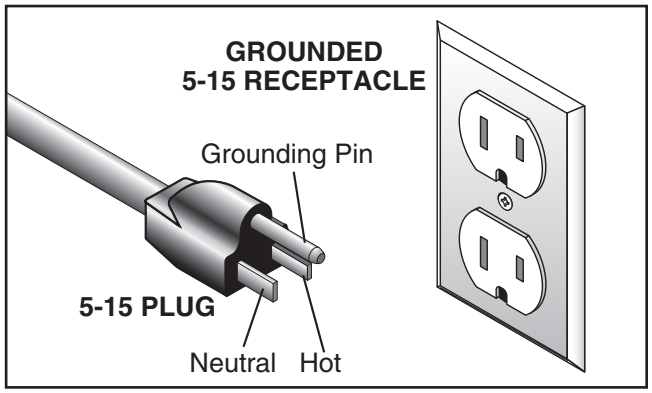
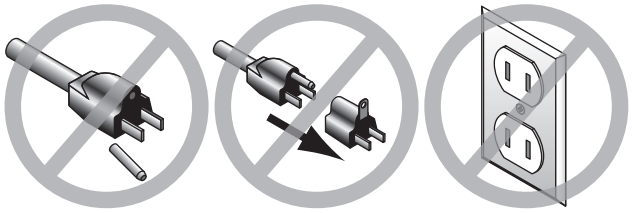


Figure 1. Typical 5-15 plug and receptacle.

⚠CAUTION



SHOCK HAZARD!

Two-prong outlets do not meet the grounding requirements for this machine. Do not modify or use an adapter on the plug provided—if it will not fit the outlet, have a qualified electrician install the proper outlet with a verified ground.

Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

Extension Cords

We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must be in good condition and contain a ground wire and matching plug/receptacle. Additionally, it must meet the following size requirements:

Minimum Gauge Size.....14 AWG
Maximum Length (Shorter is Better).....50 ft.

Installation & Operation

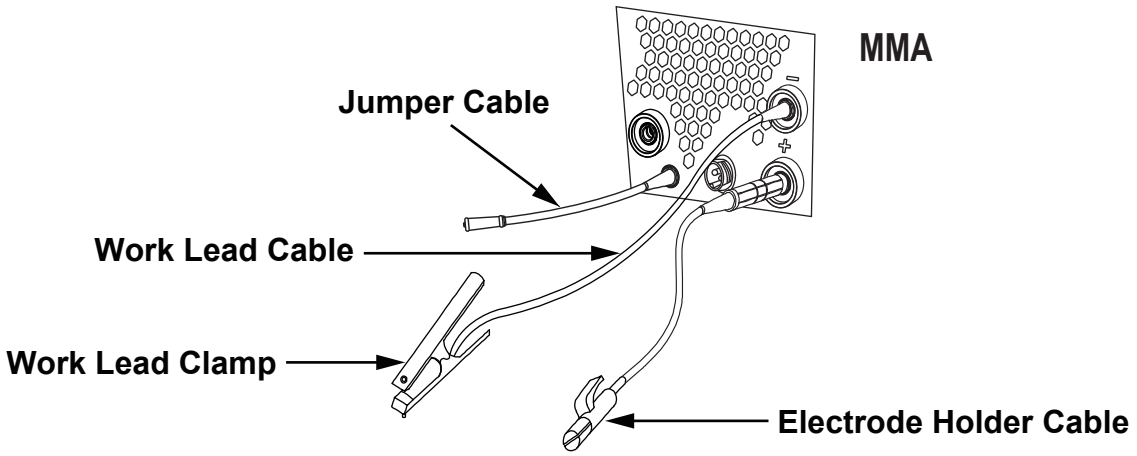
Note: · Please install the machine strictly according to the following steps.
· Ensure the ON/OFF switch is in the OFF position before connecting the machine to power.
· The protection class of this machine is IP21S, so avoid using it in rain.

Connecting Input Cable

(1) Connect the power cord to a grounded power source that meets the power supply requirements for this machine.
(2) The primary wire should be connected to the corresponding socket to avoid oxidization.
(3) Use a multi-meter to see whether the voltage value varies within the given range.

Installing MMA Welding Components

(1) Locate the positive and negative sockets on the front panel.
(2) Plug the electrode holder cable and work lead into the negative or positive sockets as required for positive or negative connection, as indicated below. Then connect the work lead clamp to the workpiece. The jumper cable will not be used.
There are two modes for connecting DC welding equipment:
● Positive connection: electrode holder to "-" / work lead to "+"
● Negative connection: work lead to "-" / electrode holder to "+" (as shown below)
Choose the mode that best suits the requirements of the job. An incorrect connection can cause an unstable arc, splash, and joining of rod and workpiece.
(3) If the distance between the workpiece and the welding equipment is more than 160 feet, use a larger gauge extension cord to avoid voltage drop.

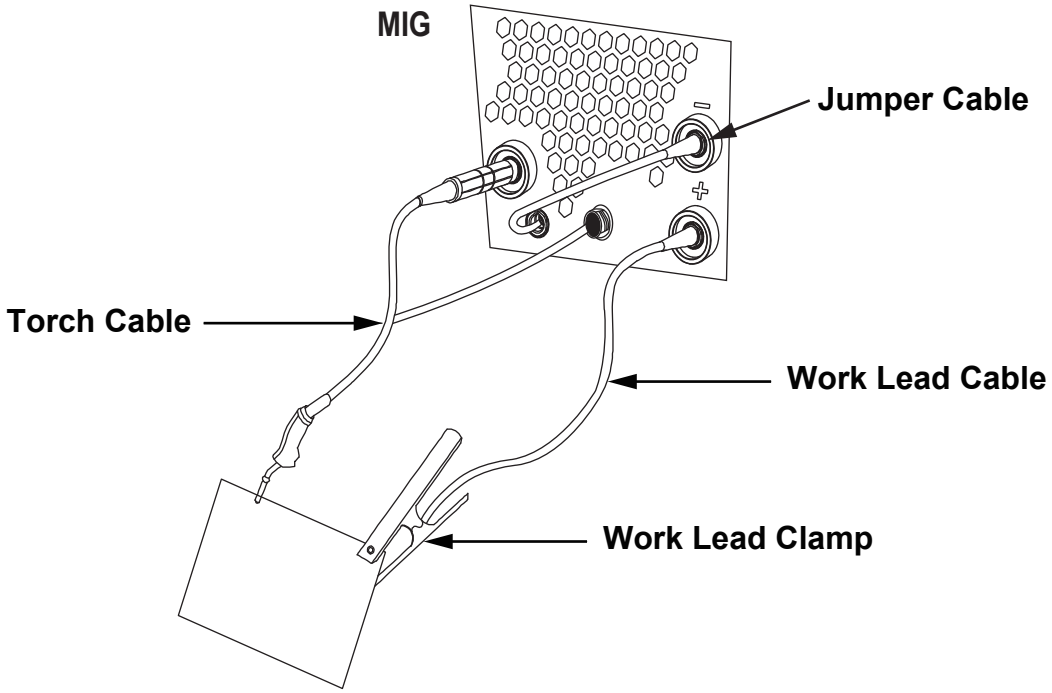


MMA Operations

(1) Turn the power switch on the back panel to the ON position after completing the preceding steps. The LED will illuminate, and the fan will begin to turn.
(2) Select “MMA” function on the front panel, and adjust the welding current adjustment knob according to the workpiece thickness to get the desired welding performance.
Generally, the required welding current is as follows:
Φ2.5: 70-100A; Φ3.2: 110-160A; Φ4.0: 170-220A; Φ5.0: 230-280A

Installing MIG Welding Components

(1) Remove the generic tip from the welding torch and install the pink ceramic tip.
(2) Plug the welding torch cable into the torch socket “” on the front panel, and tighten it. Insert the torch switch cord into the polarity selection socket on the front panel.
(3) Plug the work lead cable into the positive socket “+” on the front panel, and tighten it. Then attach the work lead clamp to the workpiece.
(4) Plug the jumper cable into the negative socket “–” on the front panel, and tighten it.
(5) Fix the flux wire coil to the rack axis on the wire feeder; make sure the hole on the wire feeding wheel lines up with the bolt on the rack axis and the welding wire diameter. Unfasten the screw on the wire wheel, press the wire into the groove of the wire feed wheel, press the wire firmly, and thread the wire into the torch. Press the trigger on the torch to feed the wire out of the welding gun.

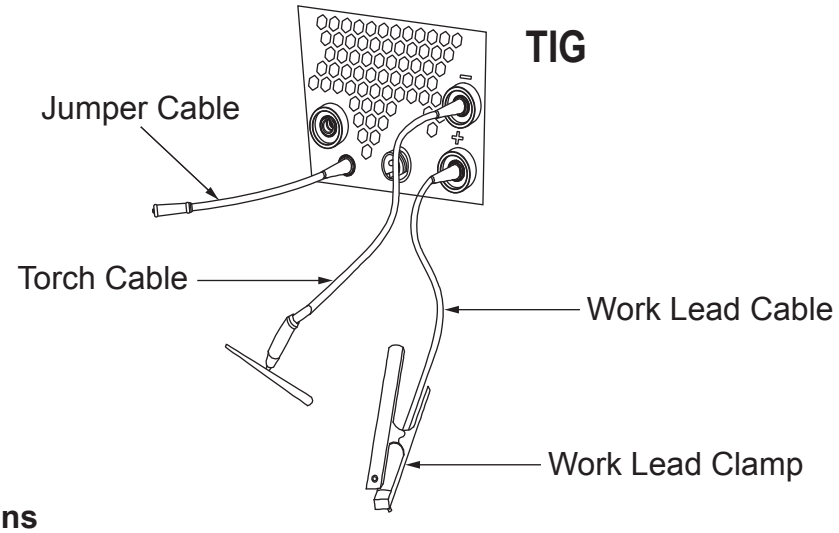


MIG Operations

(1) After completing the preceding steps, turn the power switch on the back panel to the “ON” position. The LED will illuminate, and the fan will begin to turn.
(2) Select “MIG” function on the front panel. Because of the SYN function, the welding current adjustment knob will adjust welding current and voltage together.
(3) Use the voltage adjustment knob to fine tune the voltage setting.
(4) Press the welding torch trigger and begin operations.

Installing TIG Welding Components

(1) Remove the generic tip from the welding torch and install the pink ceramic tip.
(2) Plug the welding torch cable into the negative socket “–” on the front panel, and tighten it.
(3) Plug the work lead cable into the positive socket “+” on the front panel, and tighten it. Then attach the work lead clamp to the workpiece. The jumper cable will not be used.



TIG Operations

(1) Turn the power switch on the back panel to the ON position. The LED will illuminate, and the fan will begin to turn.
(2) Select the “Lift-TIG” function on the front panel, and adjust the welding current.
(3) Use the voltage adjustment knob to fine tune the voltage setting.
(4) Press the welding torch trigger and begin operations.

CAUTION

Working Environment

Weld in relatively dry environments with humidity of 90% or less.
The ambient working temperature should fall between 14°F – 104°F.
Avoid welding in the open air unless sheltered from sunlight and rain, and never let rain or water penetrate the machine.
Avoid welding in dusty areas or environments with corrosive chemical gasses.

Good Ventilation

For optimal performance and to ensure a long service life, the fan on the back of the machine should be kept clear of any obstructions. The minimum distance between the fan and any nearby objects is 12". Good ventilation is critical to the performance of the machine.

No Overvoltage

If the voltage exceeds the permitted limit, the machine will be damaged. So pay attention to the changes in voltage. Once overvoltage occurs, stop welding and switch off the power.

No Overload

Remember to maintain awareness of the duty cycle (see the data sheet). Do not exceed this range. It can damage components and shorten the life of the machine.

Overheating Protection

If the machine experiences overheating, it will automatically shut down. Give the machine adequate time to cool down before attempting to restart it. Monitor the LED screen to determine when the overheating light goes out.

Maintenance



WARNING

Disconnect the machine from power before opening the cabinet and attempting any of the steps outlined below.

1. Check periodically whether inner circuit connection is ok (esp. plugs). Tighten the loose connection. If there is oxidization, remove it with sandpaper and then reconnect.
2. Keep hands, hair and tools away from the moving parts such as the fan to avoid personal injury or machine damage.
3. Clean off dust periodically with dry and clean compressed air. If welding in an environment with heavy smoke and pollution, the machine should be cleaned daily. The pressure of compressed air should be kept so that no particles are forced more deeply into the machine.
4. Do not use the machine in wet environments. If it gets wet, disconnect the machine from power and allow it to dry completely before using it again.
5. Periodically check the insulation on the cords for cracks or other damage, and repair or replace them as necessary.

Troubleshooting



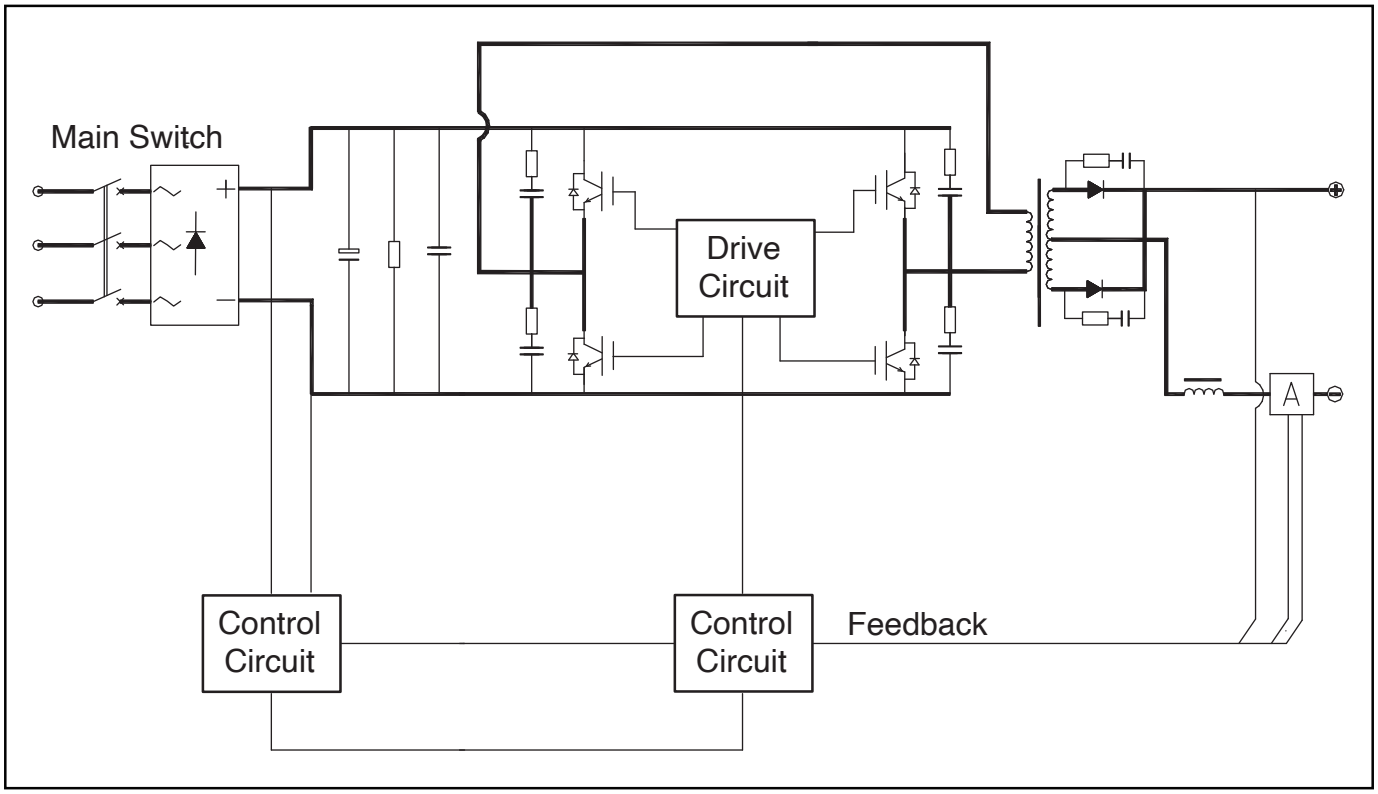
WARNING

The following operations require a professional knowledge of electrical systems. The solutions provided here should be accomplished by licensed electricians. Before attempting any troubleshooting actions, always disconnect the machine from power.

Symptom	Solution
1. The overheating LED flashes.	1. Check the working current and the working time, and use the machine according to the parameters in this manual. 2. Check the fan. If the fan is not working, check the power supply. If the power supply is correct, repair/replace the fan. If the If the power supply is wrong, use correct power and cord/plug. 3. Replace the thermal switch if it is damaged.
2. The power LED is off, and there is no current output.	1. Check if the fan works. If not, the power cord does not have a good connection. 2. If the fan works, the control board PCB QK-64-A3 inside the machine may have failed.
3. No response when pressing welding torch switch; the overheating LED is off.	1. Check if the welding torch switch has a good connection. 2. Check the connection condition of the welding torch and the Euro socket and check the control jack of the Euro socket. 3. The control board PCB QK-64-A3 inside the machine may have failed.
4. Press the welding torch but no current output and the overheating LED is off.	1. Check if the work lead clamp has a good connection with workpiece. 2. Check if the plug connection is good. 3. Check if the wire feeder has a good connection. 4. Check if the welding torch is damaged. 5. The control board PCB QK-64-A3 inside the machine may have failed.
5. Press the welding torch to start. There is current output, but the wire feeder does not work.	1. Check if the wire feeder is blocked or damaged. 2. Check if the contact tip of the welding torch is damaged or blocked. 3. The control board PCB QK-64-A3 inside the machine may have failed.

6. Press the welding torch trigger. Welding can be carried out, but the voltage cannot be adjusted.	1. Check if the voltage feedback cable inside the machine is ok. 2. The board PCB QK-63-A3 inside the machine may have failed.
7. Welding current is unstable.	1. Check if the pressure of the wire feeder pole is appropriate. 2. Check if the wire feed wheel matches the welding wire. 3. Check if the contact tip is badly abraded. If it is, replace it and tighten it. 4. Check the quality of the welding wire. 5. Check if the welding torch cable is damaged. 6. Check if the metal connection part of the plug is loose.
8. The weld bead is not well protected.	1. Prolong the post-flow time.

Circuit Diagram



WARRANTY & RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

In the event you need to use this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

For further information about the warranty, visit **https://www.grizzly.com/forms/warranty** or scan the QR code below to be automatically directed to our warranty page.

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