

ARC AIR GOUGING

LONGRUN[®] 1500WG

OPERATION MANUAL



DO NOT INSTALL, OPERATE OR MAINTAIN THIS MACHINE WITHOUT READING THIS MANUAL AND PLEASE ALWAYS THINK BEFORE YOU ACT.

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■ TECHNICAL SPECIFICATIONS

- Suitable to use for reforming of CO₂ Arc welding
- Various uses by different formation like hole expansion, cutting, grooving
- Verify output current during gouging by ammeter on front panel

ITEM	UNIT	1500WG
Rated Input Voltage	V	380V, 3-Phase, 50/60Hz
Input Current @ rated output	KVA	120
Rated Output Current	A	1500
Output Voltage @ rated output	V	52
No Load Voltage	V	92
Duty Cycle @ rated output	%	80
Dimension (W×D×H)	mm	710X1010X1290

General Safe Practices

- Wear approved safety glasses with side shields under your welding helmet or face shield and at all times in the work area.
- When working above floor level, use a safety belt to protect yourself from a fall should you get a shock.
- Do not install or place machine on or over combustible surfaces.
- **Be sure that all installation, operation, maintenance and repair procedures are performed only by qualified persons.**

Electric shock can kill.

- Wear Dry, hole-free insulating gloves and body protection. Do not touch electrode with bare hand. Do not wear wet or damaged gloves.
- Do not touch live electrical parts.
- Never dip the electrode in water for cooling.
- Properly install and ground all equipment.
- Protect yourself from electric shock by insulating yourself from work and ground. Use non-flammable, dry insulating material if possible, or use dry rubber mats, dry wood or plywood, or other dry insulating material big enough to cover your full area of contact with the work or ground, and watch for fire.
- Turn off input power using the disconnect switch at the fuse box before working on the equipment.
- Frequently inspect input power cable for damage or bare wiring and repair or replace cable immediately if damaged.

Fumes and gases can be dangerous.

- Cutting may produce fumes and gases hazardous to health. Avoid breathing these fumes and gases. When cutting, keep your head out of the fume. Use enough ventilation and/or exhaust at the arc to keep fumes and gases away from the breathing zone.
- Use enough forced ventilation or local exhaust (forced suction) at the arc to remove the fumes from your breathing area.
- Wear complete body protection. Wear oil-free protective clothing such as leather gloves, heavy shirt, cuffless pants and high boots.

Arc rays can burn eyes and skin.

- Use welding helmet with correct shade of filter to protect your eyes from sparks and the rays of the arc.
- Wear welders cap and safety glasses with side shields. Use ear protection when welding out of position or in confined spaces. Button shirt collar.
- Use a ventilating fan to remove the fumes from the breathing zone and welding area.

Welding sparks can cause fire or explosion.

- Remove fire hazards from the welding area. If this is not possible, cover them to prevent the welding sparks from starting a fire. Remember that welding sparks and hot materials from welding can easily go through small cracks and opening to adjacent areas. Avoid welding near hydraulic lines.
- When not use, make certain no part of the electrode circuit is touching the work or ground. Accidental contact can cause overheating and create a fire hazard.
- Do not cut on drums, tanks, or any closed containers unless a qualified person has tested it and declared it or prepared it to be safe.
- Connect the work cable to the work as close to the cutting area as practical. Work cables connected to the building framework or other locations away from the cutting area increase the possibility of the cutting current passing through lifting chains, crane cables or other alternate circuits. This can create fire hazards or overheat lifting chains or cables until they fail.

■ INSTALLATION

● The welding machine shall be installed at a place ;

- . free from the inflammables
- . less humidity, dirt and dust
- . protecting from influence of direct sunlight, wind and rain
- . not generated oil vapor and corrosive gas
- . operating temperature range is from -10°C to 40°C
- . least 30cm away from wall and other welding machine

● Input Connection (Rear of the machine)

Be sure the voltage, phase and frequency of the input power is as specified on the name plate located on the rear panel of the machine.

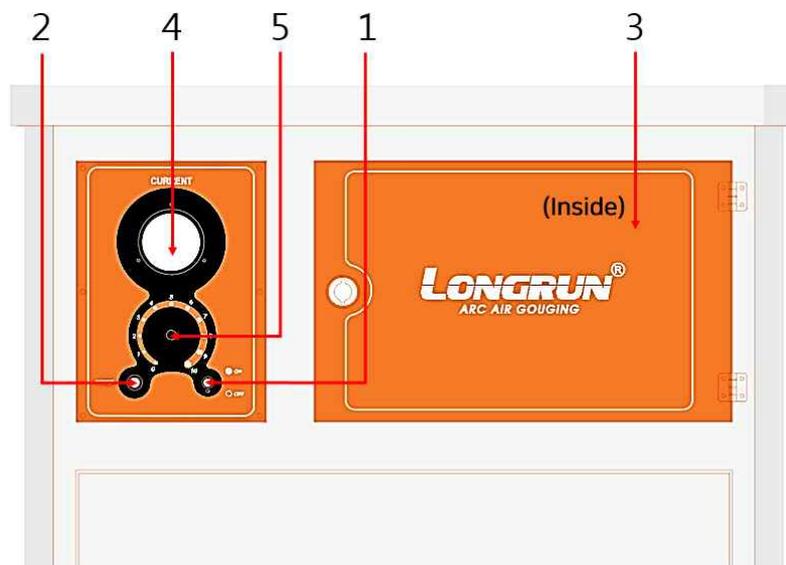
- . To connect the power cables, turn the power switch OFF
- . Verify the voltage to be supplied from main power.
- . Connect the power cables to the power input cables on the rear of the machine. For grounding the machine, connect a ground wire to the ground terminal marked with the symbol is located on the rear panel of the machine.

● Output Connection (Front of the machine)

- . Connect a work cable (which is connected to the workpiece) to the \ominus terminal.
- . To connect the gouging holder, connect a holder cable to the \oplus terminal.
- . If the remote controller is necessary, connect the connector of remote controller to REMOTE CONTROL terminal.
- . Connect a air hose from the air compressor to the gouging holder.

CABLE	UNIT	THICKNESS
POWER INPUT	mm ²	50
HOLDER		150
WORK		

■ FRONT PANEL



1	Power Switch	When it turns on, the cooling fan and all of electrical circuit inside the machine will be operated.
2	Power Lamp	It indicates that the machine is on and input voltage is within acceptable range.
3	Fuse (5/10A)	It will be broken by failure of the transformer for circuit inside machine.
4	welding current	Output welding current control
5	Ammeter	Displays the welding current

Thank you very much for choosing our machine

Please record your machine identification information below for future reference. This information can be found on the nameplate of your machine.

Product Name	AIR ARC GOUGING
Model Number	LONGRUN 1500WG
Date Manufactured	
Serial Number	
Date Purchased	
Where Purchased	
Where you use	

Whenever you request replacement parts or information on this machine, always supply the information you have recorded above. The date number is especially important when identifying the correct replacement parts.

Complete this form, please fax it to our selling agency in your country or us for warranty statement.



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