K2696-1

Easy Core 125 Series Flux Core Welder

USER MANUAL

Introduction

This manual provides comprehensive instructions for the safe and effective operation, setup, maintenance, and troubleshooting of your Easy Core 125 Series Flux Core Welder. Please read this manual thoroughly before operating the welder to ensure proper use and to prevent injury or damage.

Safety Information

Welding can be hazardous. Always follow safety precautions to prevent electric shock, fire, burns, and other serious injuries. Ensure proper ventilation, wear appropriate personal protective equipment (PPE) including welding helmet, gloves, and protective clothing. Keep a fire extinguisher nearby. Do not operate in damp conditions or near flammable materials.

- **Electric Shock:** Can kill. Do not touch live electrical parts.
- **Fumes and Gases:** Can be hazardous to your health. Use adequate ventilation.
- **Arc Rays:** Can burn eyes and skin. Wear proper eye and body protection.
- **Fire and Explosion:** Welding can cause fire or explosion. Keep flammables away.

Product Overview

The Easy Core 125 Series is a portable flux-cored welder designed for various applications including farm, home, and shop use. It operates on 120V AC input and is capable of flux-cored welding (FCAW) processes.

This image displays the Easy Core 125 Series Flux Core Welder, a compact red and black unit with a top handle. Included accessories are visible: a welding gun with its cable, a ground clamp with its cable, a spool of flux-cored wire, and spare contact tips.

Key Components:

- **Control Panel:** Features voltage and wire feed speed adjustments.
- **Welding Gun:** Connects to the welder for wire feeding and arc initiation.
- **Work Clamp:** Connects to the workpiece to complete the electrical circuit.
- **Wire Spool Compartment:** Houses the flux-cored wire spool.
- **Power Cord:** For connecting to a 120V AC power source.

Setup

1. Unpacking and Inspection:

Carefully remove the welder and all accessories from the packaging. Inspect for any shipping damage. Report any damage to your supplier immediately.

2. Power Connection:

Ensure the welder's power switch is in the OFF position. Connect the 5-15P plug to a grounded 120V AC, 20A dedicated circuit. Avoid using extension cords if possible; if necessary, use a heavy-duty, properly rated extension cord.

3. Wire Installation:

1. Open the wire spool compartment.
2. Mount the flux-cored wire spool onto the spindle, ensuring it rotates freely.

3. Thread the wire through the drive roll system. Ensure the correct drive roll (0.030 in - 0.035 in for flux-core) is installed and tensioned properly.
4. Feed the wire through the gun liner until it exits the contact tip.

4. Work Clamp Connection:

Attach the work clamp securely to a clean, bare metal section of the workpiece. A good electrical connection is crucial for stable arc and quality welds.

Operating Instructions

1. Basic Welding Principles (FCAW):

Flux-cored arc welding (FCAW) uses a continuously fed consumable electrode containing a flux. The flux provides shielding gas and slag to protect the weld puddle from atmospheric contamination. This welder operates in DC polarity.

2. Controls and Adjustments:

- **Voltage Control:** Adjusts the welding voltage (output range 30 to 125A DC). Higher voltage generally results in a wider, flatter bead.
- **Wire Feed Speed Control:** Adjusts the rate at which the wire is fed (50 to 500 in/min). This directly affects the amperage. Match wire feed speed to voltage for optimal arc stability.

3. Welding Techniques:

Position the welding gun at a slight angle (push or drag technique depending on application). Maintain a consistent arc length and travel speed. Practice on scrap material to achieve desired results. The welder is suitable for mild steel from 20 gauge to 5/16 inch thickness.

Maintenance

Regular maintenance ensures optimal performance and longevity of your welder.

- **Cleaning:** Periodically clean the welder's exterior and internal components (with compressed air) to remove dust and debris. Ensure power is disconnected before cleaning.
- **Contact Tip Replacement:** Replace worn or spattered contact tips as needed to ensure good electrical contact and consistent wire feeding.
- **Drive Roll Maintenance:** Keep the drive rolls clean and free of debris. Ensure proper tension for consistent wire feeding.
- **Gun Liner:** Inspect the gun liner for kinks or blockages that could impede wire feeding. Replace if necessary.

Troubleshooting

Problem	Possible Cause	Solution
No Arc	No power, poor work clamp connection, faulty gun trigger.	Check power supply, ensure work clamp is secure, inspect gun trigger and cable.
Inconsistent Wire Feed	Incorrect drive roll tension, clogged liner, wrong contact tip size.	Adjust drive roll tension, clean/replace liner, use correct contact tip.

Problem	Possible Cause	Solution
Poor Weld Quality	Incorrect voltage/wire speed settings, dirty workpiece, improper technique.	Adjust settings, clean workpiece, refine welding technique.

Specifications

Feature	Specification
Model	K2696-1
Series	Easy-Core 125
Input Voltage	120V AC
Phase	Single-Phase
Input Frequency	60 Hz
Welding Processes	Flux-Cored Welding (FCAW)
Polarity	DC
Rated Output	90A 19V DC
Duty Cycle	20%
Output Range	30 to 125A DC
Maximum Wire Diameter (Flux-Cored)	0.035 in
Maximum Wire Feed Speed	500 in/min
Minimum Wire Feed Speed	50 in/min
Material Thickness (Mild Steel)	20 ga to 5/16 in
Weight	49 lb
Overall Dimensions (W x D x H)	10.15 in x 17.9 in x 13.7 in

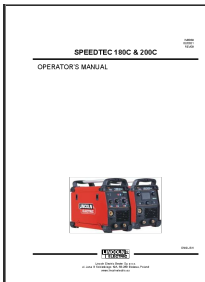
Warranty and Support

Warranty information for your Easy Core 125 Series Flux Core Welder is typically provided with the product packaging or can be obtained directly from the manufacturer or authorized dealer. Please retain your proof of purchase for warranty claims.

For technical support, parts, or service, please contact the manufacturer's customer service department or your local authorized service center. Refer to the contact information provided in your product documentation.

Related Documents - K2696-1

	Lincoln Electric Handy MIG / Handy Core Operator's Manual Comprehensive operator's manual for Lincoln Electric Handy MIG and Handy Core welding machines (IM3000), covering technical specifications, safety guidelines, installation, operation, maintenance, and suggested accessories.
	Lincoln Electric WELD-PAK® 180i MP® DV Welder: Features, Specs, and Accessories Comprehensive overview of the Lincoln Electric WELD-PAK® 180i MP® DV, a compact and versatile MIG, Stick, and DC TIG welder. Details key features, performance, included accessories, and specifications for home, hobby, and professional use.
	R-Tech PRO-MIG250 Portable Inverter MIG/MAG/MMA Welder - Operating Instructions Operating instructions manual for the R-Tech PRO-MIG250 Portable Inverter MIG/MAG/MMA Welder. Covers technical specifications, safety precautions, electrical installation, connections, controls, operation modes (MIG/MMA), welding parameters, maintenance, and troubleshooting.
	Lincoln Electric Power Wave C300: Portable Multi-Process Welder Specifications and Features Detailed overview of the Lincoln Electric Power Wave C300, a portable multi-process wire feeder welder. Features, key controls, processes, and technical specifications for production welding, fabrication, and training.
	Lincoln Electric Power Wave 355M Advanced Process Welder The Lincoln Electric Power Wave® 355M is a compact and efficient inverter-based welding power source designed for advanced process semiautomatic welding, including aluminum push-pull capability. It features Waveform Control Technology®, ArcLink® digital communication, Pulse-On-Pulse® welding mode, and Power Mode® for superior arc performance and control across various applications like fabrication, production, and automotive.



[Lincoln Electric SPEEDTEC 180C & 200C Operator's Manual]

Comprehensive operator's manual for Lincoln Electric SPEEDTEC 180C and 200C welding machines, detailing technical specifications, safety guidelines, installation, operation procedures, maintenance, and accessories.

Documents - K2696-1 – K2696-1

[pdf] Specifications Dimension Guide Accessories

Lincoln Electric Welding Tools Equipment Product Information welders soldering tools equipment accessories supplies CARiD k2696 1 product information images carid lincoln electric items |||

Easy-CoreTM 125 Processes Flux-Cored Product Number **K2696-1** See back for complete specs Input Power 120/1/60 Input Current at Rated Output 20A Rated Output Current/Voltage/Duty Cycle 90A/19V 20 Output Range 30 - 125 A 50-500 WFS 1.3-12.7 m/min Max. OCV: 33 Weight/Dimensions H x W x D 49 lb...

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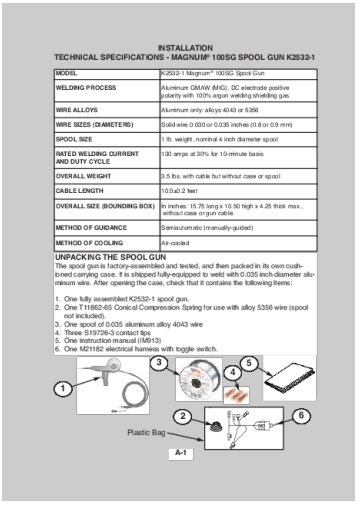

[pdf] User Manual Specifications

IMT913 MAGNUM 100SG SPOOL GUN The Lincoln Electric Company INSTALLATION SAFETY PRECAUTIONS WARNING polarity per the machine's Instruction Manual 3 Gas selection and flow rate Connect 100% welding grade argon gas supply to solenoid valve Set regulator deliver a of 20 50 SCFH thru spool gun 4 Flip wire drive selector switch behind access door Magnum® 91T7fK3HPkL images na ssl amazon I

INSTALLATION TECHNICAL SPECIFICATIONS - MAGNUM 100SG SPOOL GUN K2532-1 MODEL K2532-1 Magnum 100SG ... K2480-1 WELD PAK 125 HD K2513-1 WELD PAK 140 HD K2514-1 MIG PAK 140 K2658-1 EASY CORE 125 **K2696-1** EASY MIG 140 K2697-1 WORK PAK 125 K2699-1 CORE PACK 125 K2785-1 PRO MIG 180 K2481-1 ...

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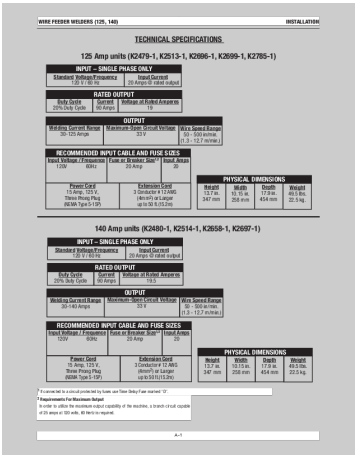

WIRE FEEDER WELDERS (125, 140) INSTALLATION

TECHNICAL SPECIFICATIONS

125 Amp units (K2479-1, K2513-1, K2696-1, K2699-1, K2785-1)

INPUT – SINGLE PHASE ONLY

Standard Voltage/Frequency	Input Current
120 V / 60 Hz	20 Amps @ rated output

RATED OUTPUT

Duty Cycle	Current	Voltage at Rated Amperes
20% Duty Cycle	90 Amps	13

OUTPUT

Welding Current Range	Maximum Open-Circuit Voltage	Wire Speed Range
30–125 Amps	33 V	50 – 500 in/min (1.3 – 12.7 m/min.)

RECOMMENDED INPUT CABLE AND FUSE SIZES

Input Voltage / Frequency	Fuse or Breaker Size*	Input Amps
120V / 60Hz	20 Amp	20

Power Cord	Extension Cord	PHYSICAL DIMENSIONS			
		Height	Width	Depth	Weight
15 Amp, 125 V, Three Prong Plug (NEMA Type 5-15P)	3 Conductor # 12 AWG (4mm²) or Larger up to 50 ft (15.2m)	13.7 in. 347 mm	10.15 in. 258 mm	17.9 in. 454 mm	49.5 lbs. 22.5 kg

140 Amp units (K2480-1, K2514-1, K2658-1, K2697-1)

INPUT – SINGLE PHASE ONLY

Standard Voltage/Frequency	Input Current
120 V / 60 Hz	25 Amps @ rated output

RATED OUTPUT

Duty Cycle	Current	Voltage at Rated Amperes
20% Duty Cycle	90 Amps	19.5

OUTPUT

Welding Current Range	Maximum Open-Circuit Voltage	Wire Speed Range
30-140 Amps	33 V	50 - 500 in/min (1.3 - 12.7 m/min.)

RECOMMENDED INPUT CABLE AND FUSE SIZES

Input Voltage / Frequency	Fuse or Breaker Size*	Input Amps
120V	20 Amp	25

Power Cord	Extension Cord	PHYSICAL DIMENSIONS			
		Height	Width	Depth	Weight
15 Amp, 125 V, Three Prong Plug (NEMA Type 5-15P)	3 Conductor# 12 AWG (4mm²) or Larger up to 50 ft (15.2m)	13.7 in. 347 mm	10.15 in. 258 mm	17.9 in. 454 mm	49.5 lbs. 22.5 kg

[pdf] Installation Guide Specifications Dimension Guide Guide Catalog

IMT10049 WIRE FEEDER WELDERS 125 140 MODELS The Lincoln Electric Company Amp Weld Pak HD MIG Wire Feed Welder with Magnum 100L Gun Sample spools of and Flux 115V Installation Guide K2514 1 015082664958 0015082664958 463474 28dd5d34 0c9d 4cf7 a12a 1af9816225f4 images thdstatic catalog Images 28 |||

WIRE FEEDER WELDERS 125, 140 INSTALLATION TECHNICAL SPECIFICATIONS 125 Amp units K2479-1, K2513-1, **K2696-1**, K2699-1, K2785-1 INPUT SINGLE PHASE ONLY Standard Voltage/Frequency Input Current 120 V / 60 Hz 20 Amps rated output RATED OUTPUT Duty Cycle Current Voltage at Rated Amperes ...

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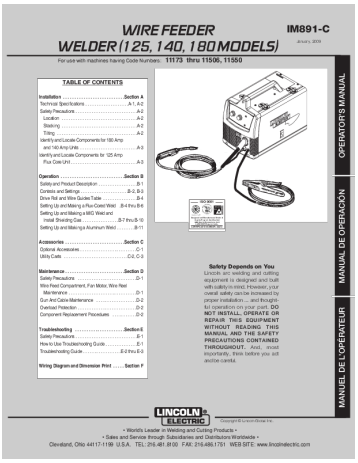

WIRE FEEDER WELDER (125, 140, 180 MODELS)

IM891-C

For use with machines having Code Numbers: 11173 thru 11506, 11550

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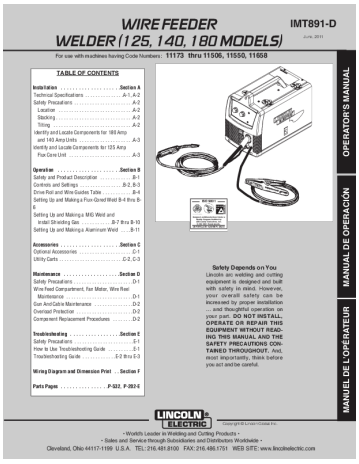

WIRE FEEDER WELDER (125, 140, 180 MODELS)

IMT891-D

For use with machines having Code Numbers: 11173 thru 11506, 11550, 11668

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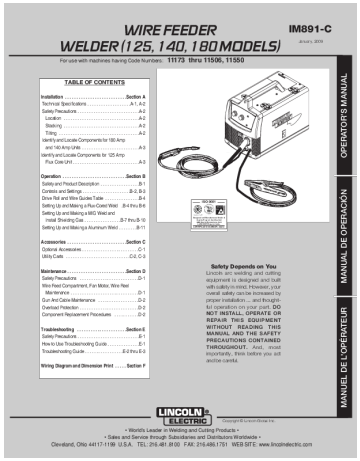

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IM891 Tom Norton Product Manual Lincoln Electric Easy MIG 140 Flux Cored Welder Transformer 115V 30140 Amp Output Model K2697 1 167740 m northerntool images manuals |||

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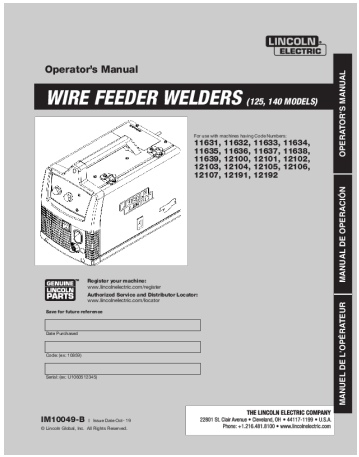

[pdf] User Manual Datasheet Safety Datasheet Label

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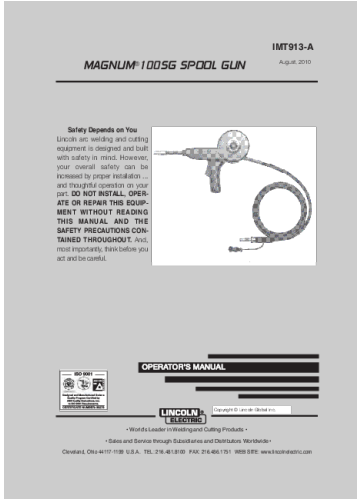

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IMT913 P 554 The Lincoln Electric Company MAGNUM 100SG SPOOL GUN August 2010 Northern Tool K2532 1 Magnum® Spool Gun 3 44732 northerntool images manuals

MAGNUM100SG SPOOL GUN IMT913-A August, 2010 Safety Depends on You Lincoln arc welding and cutting ... K2480-1 WELD PAK 125 HD K2513-1 WELD PAK 140 HD K2514-1 MIG PAK 140 K2658-1 EASY CORE 125 **K2696-1** EASY MIG 140 K2697-1 WORK PAK 125 K2699-1 CORE PACK 125 K2785-1 PRO MIG 180 K2481-1 ...

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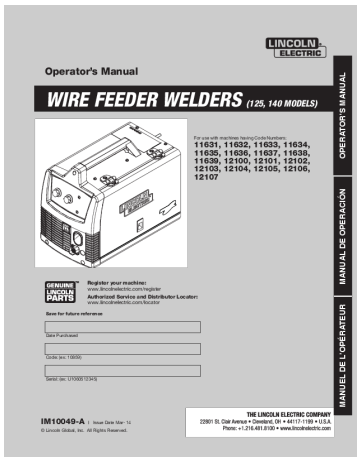

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IMT10049 11631 11632 11633 11634 11635 11636 11637 11638 11639 12100 12101 12102 12103 12104 12105 12106 12107 The Lincoln Electric Company 140 Amp Weld Pak HD MIG Wire Feed Welder with Magnum 100L Gun Sample spools of and Flux 115V Use Care Manual K2514 1 015082664958 0015082664958 463474 daaf621c 4e8e 4e57 a4c0 be287bfd78db images thdstatic catalog Images da |||

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