

Karnage Welder

Operation and Safety Manual

Self-Contained Flux Core Wire Feed Welder



Thank you for your Karnage Welder Purchase!

Warranty Information

The Karnage Welder is guaranteed to be free from defects in materials or workmanship for a period of 1 year from date of purchase. This warranty covers defects of parts or workmanship caused by normal use of the equipment and does not cover damage caused by modification of the unit, improper use, accidents, abuse, neglect, or acts of God.

Karnage Welder assumes no liability or responsibility for damage resulting from the use of this product, or damage due to breach of the warranty.

Safety

Be aware of the hazards of welding prior to operating this equipment, these hazards include but are not limited to fire hazards, splatter, electric shock, radiant heat, etc.

Always wear proper PPE while welding (DRY welding gloves, welding hood, etc.) and be aware of the surrounding environment.

Welding processes cause sparks and metal splatter which can and do cause fires. Keep the work area clear of flammables and always be prepared with a fire extinguisher close by in case the need arises.

You **MUST** disconnect your vehicle's battery prior to welding to prevent damage to the vehicle's electronics. Karnage Welder assumes no responsibility for damage vehicle systems due to welding.

Description

The Karnage Welder is the only Self Contained flux core wire feed welder available on the market today. There are other trail welders of course, as well as welders that are battery operated but none are as portable, easy to use or as affordable as the Karnage Welder! The Karnage Welder is "The Ultimate Off-road Welding Solution!"

The Karnage Welder can weld as much as 60 linear inches of weld (on 3/16" material) on a full charge using .030" diameter wire!

There is no need to worry about polarity. The polarity is set internally, and the Internal Battery is self-contained and isolated from your rig's power source.

The Karnage Welder has a 100% Duty cycle since there are no parts to overheat.

Operation, Parts Description and Location

Charging Port

- The Charging Port is located on the front of the unit near the latch on the right side. The port is 12 volt “cigarette lighter socket” type. It can also be used to charge your portable wireless devices in an emergency.

Charging the Internal Battery

- Charging times vary depending on several factors, but a full charge from 80% drain will take 6-8 hours using the supplied charger.
- Move the Function Switch to the “Charge Internal Battery” position to enable charging of the batteries. Next simply plug into any 12 volt DC power supply to charge the unit. This can be a battery tender (trickle charger) when 120 volts AC is available or by using the included charging cord and plugging into the power outlet in your car or truck.

Voltage Meter

- The Voltage Meter is located inside the case on the left side. The meter will illuminate when the switch is moved the “Internal Battery Weld” position, it will not be illuminated when not in this position. A full charge will be in the range of 26.2 – 26.5 volts.

Function Switch

- The function switch is located inside the case just below the Voltage Meter. It has 3 positions to select from:
 - Up is the “Internal Battery Weld” position. When in this position the unit will operate using the internal batteries.
 - Center is the “Off/External Battery Weld” position. When in this position it is safe to connect external batteries to the “External Battery Port” for continued welding operations should the Internal Battery be depleted.
 - Down is the “Charge Internal Battery” position. When in this position the batteries are in the charging configuration and no welding can take place.
 - **IMPORTANT NOTE: ***NEVER CONNECT EXTERNAL BATTERIES WHEN THE FUNCTION SWITCH IS THE “CHARGE INTERNAL BATTERY” POSITION. SERIOUS DAMAGE TO THE UNIT AND POSSIBLE BODILY HARM MAY OCCUR*****

Speed Control Adjustment Knob

- The Speed Control Adjustment Knob is located inside the case just below the Function Switch. It is used to regulate the speed of the wire feed while welding.
- When not in use, turn the speed control knob to the lowest setting to prevent unintentional wire feeding while the unit is charging.

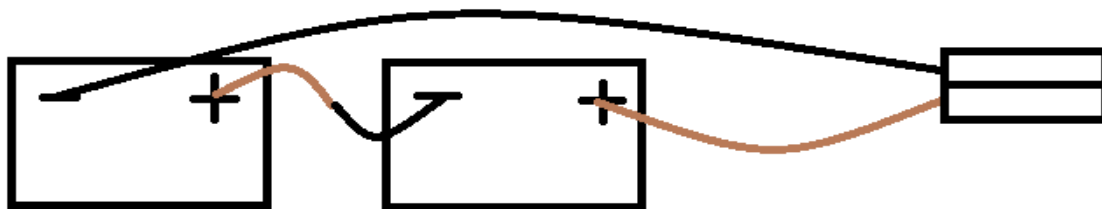
External Battery Port

- The External Battery Port is located inside the case on the bottom left side. It is used to connect external 12 volt DC batteries using the supplied cables so that welding may continue in the even the Internal Battery is depleted.
 - **IMPORTANT NOTE: ***NEVER CONNECT EXTERNAL BATTERIES WHEN THE FUNCTION SWITCH IS THE “CHARGE INTERNAL BATTERY” POSITION. SERIOUS DAMAGE TO THE UNIT AND POSSIBLE BODILY HARM MAY OCCUR*****

Connecting External Batteries

Important Note: *When connecting external batteries you MUST disconnect the battery from the vehicle as it has a negative ground and the Karnage Welder operates with a positive ground.*****

- Using (2) automotive 12 volt batteries you can extend the welding time as needed to complete the job. Using the supplied cables, connect the 2 batteries in SERIES configuration (See below). This will provide a 24 volt power supply, the same as the Internal Battery.



Wire Spool

- The Wire Spool is located inside the case and can hold a 1 or 2 pound spool of flux core wire. On the top of the Wire Spool stud there is a tension adjustment knob.

Wire Feed Assembly

- The Wire Feed Assembly is located inside the case and is connected to the welding torch lead. It has a roller that has 2 grooves, one for .030 wire diameter and one for .035 wire diameter. There is also a tension knob on the assembly used to adjust the tension between the rollers and the wire.

Welding Torch

- The Welding Torch trigger activates the Wire Feed Motor has standard threaded tip available on our website or at any retailer which supplies welding equipment.
 - **NOTE: ***The Welding Torch wire is “HOT” whenever the Function Switch is the “Internal Battery Weld” position or when External Batteries are connected.*****