

Setup Procedure for Dynasty 350 and XMT 350 MPa for Shielded Metal Arc Welding

A handout containing the highlights of the video titled *Setup procedure of Dynasty 350 and XMT 350 MPa (SMAW)*

Setting up Dynasty 350

1. Turn power on.
2. Set the following options:
 - a. Polarity: Direct current
 - b. Process: Stick (Shielded Metal Arc Welding)
 - c. Output: Put on ON. Be cautious in handling the equipment when the blue light is on. Irresponsible handling may cause electric shock.



CAPTION 1. THE INSTRUCTOR CHOOSES THE SETTINGS FOR POLARITY, PROCESS, AND OUTPUT.

3. Connect electrode lead. Hang the electrode holder on an ungrounded bracket.



CAPTION 2. THE ELECTRODE LEAD IS CONNECTED. MAKE SURE IT IS PLUGGED INTO THE RIGHT CONNECTION BY LOOKING AT THE SYMBOL BESIDE IT. THE PHOTO INCLUDES A CLOSE-UP OF THE ELECTRODE LEAD SYMBOL.

4. Plug the workpiece connection in, and hook the other end of the workpiece connection to what you would be welding on.



CAPTION 3. THE WORKPIECE CONNECTION WITH A CLOSE-UP OF THE WORKPIECE CONNECTION SYMBOL.

Setting up XMT 350 MPa

1. Turn the power on, and open the panel door.
2. Turn selector knob on Stick. Practice caution when options in the orange zone are selected. Touching the lugs or connecting the two pieces will cause electric shock.



CAPTION 4. THE INSTRUCTOR SETTING UP THE XMT 350 MPA MACHINE.

3. Turn on Setup and adjust Dig.
4. Adjust amperage.

Tip: This machine has a negative and positive connection. This will depend on your electrode setup if it is going to be DC electrode positive or electrode negative. In the video, the instructor uses electrode positive for the demonstration.

5. Connect the electrode holder to either positive or negative, depending on what your electrode set up is.



CAPTION 5. IN THE VIDEO, THE INSTRUCTOR USED AN ELECTRODE POSITIVE. THE PHOTO INCLUDES THE CLOSE UP OF THE POSITIVE SYMBOL AND THE ESTABLISHED ELECTRODE POSITIVE CONNECTION.

6. Connect the workpiece connection.



CAPTION 6. THE WORKPIECE CONNECTION IS CONNECTED.

Looking for other learning materials?

The [Shielded Metal Arc Welding iTunes U course](#) has videos and other learning materials for you to view. You can [download iTunes for free](#) to view the course and course materials. Closed-captioned videos are available at [T4E's YouTube page](#).

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