



Amperage Controller Specifications

Description

A variable amperage controller offered as an optional accessory to be used with the Tactical Welder. The Amperage Controller offers variable current control, quick and easy set up, and connections and settings for multiple welding applications.

This controller is designed to provide 30-300 ampere welding control and the ability to save the desired ampere for the specific welding job. The full-wave phase control circuitry minimizes power loss, thereby reducing energy requirements. The controls provide variable ampere adjustment, allowing the end-user to select the desired current. Important features such as RFI Filter, built-in screen, knob selector and inline Anderson connectors are standard. Designed to be connected and powered in-line with the Tactical Welder.



Specifications

- + Built-in screen
- + Anderson connectors 250V
- + 18-inch-long, 6 gauge power cables
- + Cooling fan
- + Aluminum case with heat-rated plastic end covers

Part#	Input Voltage Volts DC-	Maximum Current AMPS-	Operating Temperature	Size
4803	27V DC	300 amps	-20° F to 140° F (-29° C to 60° C)	10.5"L x 4.5"W x 2.5"H

Amperage Controller - Quick Start Guide

1. Ensure the Tactical Welder battery is fully charged.
2. Connect the **outside red wire** on the amperage controller to the **red connection** on the battery, and one of the black wires on the amperage controller (it doesn't matter which one) to the black connection on the battery.
3. Connect the **middle yellow wire (with green stripe)** on the amperage controller to the **red Anderson connector** on the gun, and the other black wire on the amperage controller to the ground clamp. Connect the black 4 pin connector cable on the gun to the battery.
4. Turn the battery power switch on.
5. In order to prevent wire feed while adjusting settings, disengage the wire tension knob (Part 11 on Page 9 of the [Welder Manual](#)) by flipping it up.
6. Hold the gun trigger to turn the Amperage Controller on, continue to hold the trigger to keep power flowing to the Amperage Controller.
7. After desired settings have been selected, re-engage the wire tension knob.

If the trigger gets released the power to the amp controller will go off.

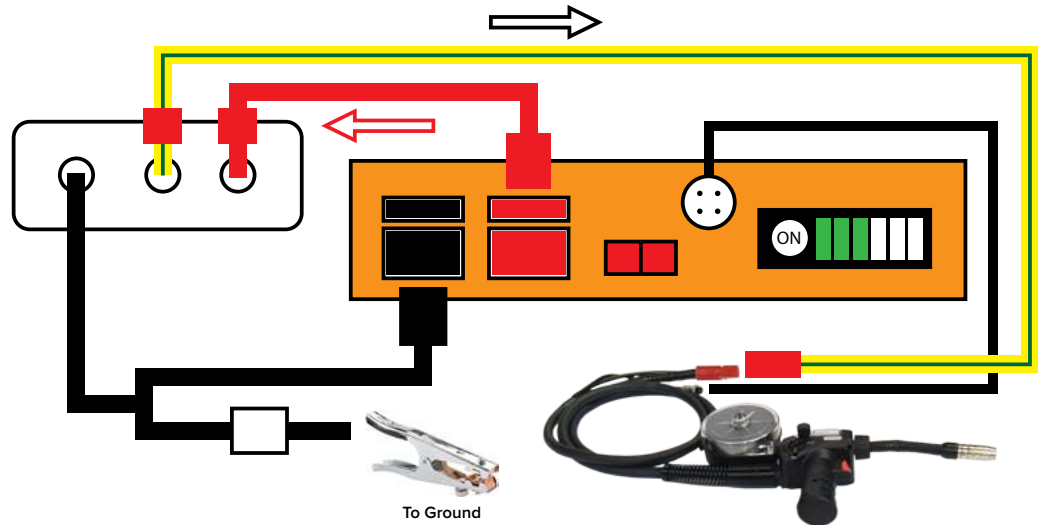
- + When the trigger is first pressed, the default current will be shown on the screen.
- + To adjust current while welding, simply turn the knob.
- + To set the default current: Turn the knob to the desired current. The amp controller will save the desired ampere after 10 seconds of constant welding.

Option #2: After all connections are secured, start welding and adjust the ampere knob to the desired current while welding, after 10 seconds the amperage controller will save the selected current.



Standard Wiring Diagram for:

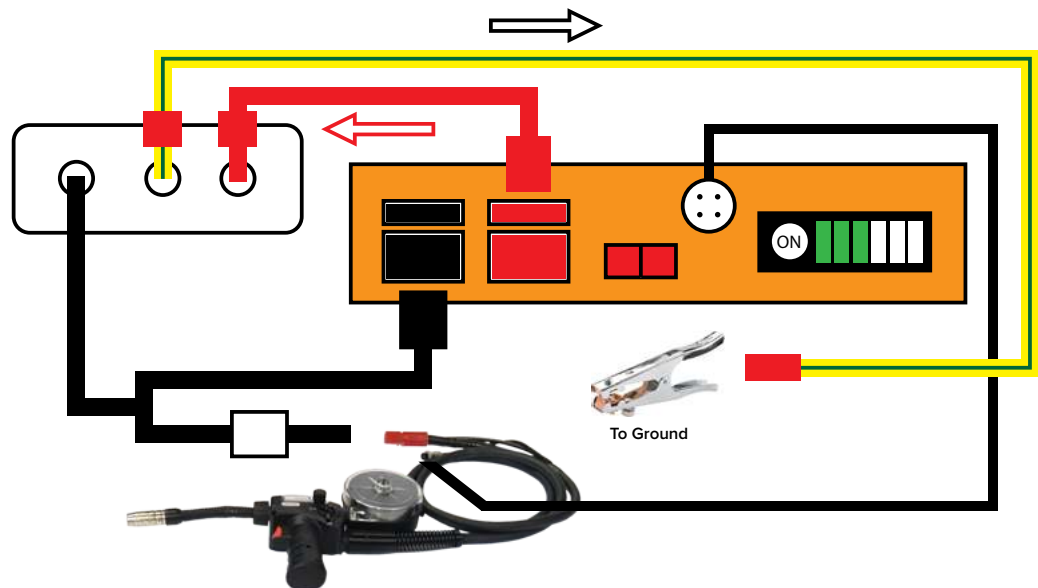
- + Flux Core Welding
- + MIG Welding
- + Aluminum Welding



WARNING: Connections should mirror the wiring diagram. Wrong connections will cause the controller to be inoperable. Double check connections before turning the unit on.

Flux Core Reverse Polarity Diagram:

Flux Core welding can be performed with either standard (straight polarity) or reverse polarity configurations. Reverse polarity will add more heat to the weld, and will yield better results and a better weld finish.



NOTE: To weld with flux core wire using the reverse polarity configuration, connect the yellow/green wire from the amperage controller to the ground clamp, and one of the black cables from the amperage controller to the red Anderson connector on the gun.