1. ALL RELAYS AND CONTACTORS SHOWN IN DE-ENERGIZED POSITION.
2. ITR SECONDARY CONNECTIONS 25-26 PROVIDE 15V., 25-27 PROVIDE 27V.
3. ALL GROUND CONNECTIONS MUST BE MADE ON BRIGHT METAL FREE OF PAINT, OIL OR RUST.

**SYMBOLS**
- Transformer winding, relay, contactor or motor field
- Terminal or stud
- Fuse
- Toggle or knife switch or current relay contacts normally open
- Push button switch, spring return
- Plug & receptacle (pins indicate male contacts)
- Ground
- Rheostat
- Condenser
- Meter

**NOMENCLATURE**
- C1: Condenser, IMFD. 1000V, D.C.
- CR: Current relay
- CS: Contactor switch
- F1 & F2: 110V A.C. supply fuses 5 AMP
- F3: Welding voltage supply, fuse 15 AMP
- FRS: Feed & retract switch
- IB: Inching button
- ITR: Inching transformer
- MCR: Main contactor relay
- Ω: Voltmeter
- WVC: Welding voltage control
- Y: Plug & receptacle contacts - 6 pole
- Z: Plug & receptacle contacts - 8 pole

CIRCUIT AND WIRING DIAGRAMS FOR SERIES VOLT PORTABLE FLEXIBLE WELD
Voltage Control circuits for early models of the Portable Flexible Welder are shown in Form 9180 (Series 3 "US" Voltage Control Circuit and Wiring Diagram).