

# SET-UP-GUIDE

## MTS-205

### Note:

This set-up information is intended to act as a guide only. Please refer to operating manual for further information.



### Changing Polarity



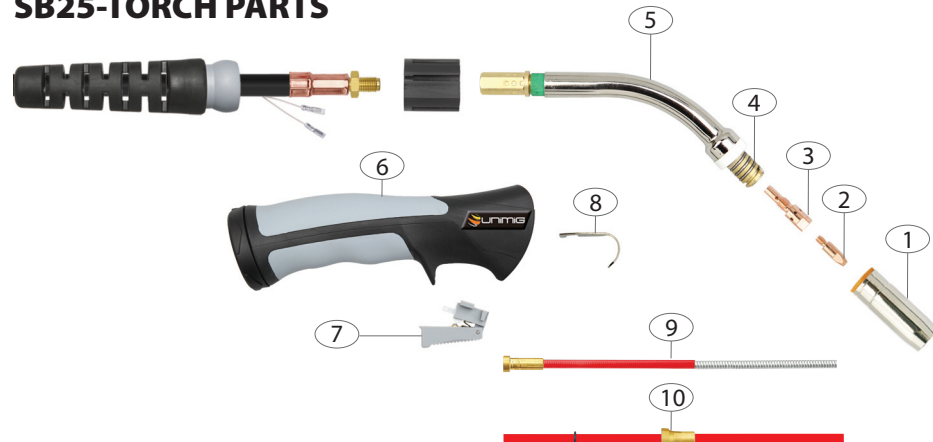
V = Volts

WFS = Wire feed Speed

MATERIAL	WIRE TYPE	DRIVE ROLLER	POLARITY	SHIELDING GAS	GAS FLOW RATE	WIRE DIAMETER	1MM	2MM	4MM	6MM	8MM
STEEL	SOLID ER70S-6	V GROOVE	DCEP	ARGON/CO2/O2 MIX	8 - 12 L/PM	0.8MM	14 / 4	14 / 5	16 / 7	20 / 12	23 / 15
	SOLID ER70S-6	V GROOVE	DCEP	ARGON/CO2/O2 MIX	8 - 12 L/PM	0.9MM	-	15 / 5	17 / 8	20 / 13	24 / 15
	FLUX CORED	F GROOVE	DCEN	N/A	N/A	0.8MM	14 / 4	14 / 5	16 / 7	18 / 9	21 / 11
	FLUX CORED	F GROOVE	DCEN	N/A	N/A	0.9MM	-	15 / 6	17 / 8	19 / 10	22 / 12
STAINLESS	STAINLESS	V GROOVE	DCEP	ARGON/CO2 MIX	8 - 12 L/PM	0.8MM	14 / 4	14 / 5	16 / 7	18 / 9	20 / 11
	STAINLESS	V GROOVE	DCEP	ARGON/CO2 MIX	8 - 12 L/PM	0.9MM	-	15 / 5	17 / 8	19 / 10	21 / 12
ALUMINIUM	ALUMINIUM	U GROOVE	DCEP	ARGON	8 - 12 L/PM	1.0MM	-	14 / 8	15 / 9	17 / 12	19 / 15

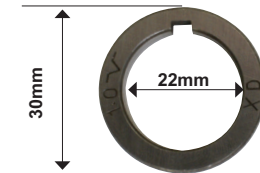
Note: The above informations is intended for a down hand butt weld with a gas flow of 8-12 L/PM. Please refer to the operation manual for further information.

### SB25-TORCH PARTS



- 1 PGN25CYL Cylindrical Nozzle
- PGN25CON Conical Nozzle
- PGN25TAP Tapered Nozzle
- 2 PCT0009-06 Contact Tip Steel (0.6mm)
- PCT0009-08 Contact Tip Steel (0.8mm)
- PCT0009-09 Contact Tip Steel (0.9mm)
- PCTAL0009-09 Contact Tip Aluminium (0.9mm)
- PCTAL0009-10 Contact Tip Aluminium (1.0mm)
- PCTAL0009-12 Contact Tip Aluminium (1.2mm)
- 3 PCTH25 Contact Tip Holder
- 4 PGNS25 Shroud Spring
- 5 SNK25 Swan Neck Assembly
- 6 UG2514 Ergo Handle Kit C/W Lock Nut
- 7 UG2516 Medium / Large Ergo Trigger
- 8 UB2517 Hanger Hook
- 9 SLR4M Red Steel Liner 4 Metre
- 10 TLR4M Red Aluminium Liner 4 Metre

### DRIVE ROLLER SELECTION



Part Number	Description
0.6-0.8V30/22	Drive Roll V Groove 0.6-0.8mm
0.8-1.0V30/22	Drive Roll V Groove 0.8-1.0mm
0.9-1.2V30/22	Drive Roll V Groove 0.9-1.2mm
1.0-1.2V30/22	Drive Roll V Groove 1.0-1.2mm
1.0-1.2U30/22	Drive Roll U Groove 1.0-1.2mm
0.8-0.9F30/22	Drive Roll Knurled 0.8-0.9mm