

- **No welding arc:** Faulty torch or its cable or button; ⇒ *replace* it. Loose connection at welding cables; ⇒ *fasten* it. Faulty control unit; ⇒ contact service.
- **Bad gas flow:** Empty gas bottle, faulty pressure regulator or flow meter, leakage at gas hose or gas valve; ⇒ repair or replace. The bottle or regulator is frozen, ⇒ *heat up* it by hot water or gas heater.
- **Irregular wire feed:** Worn or deformed input guide, roll or its groove, loose wire reel; ⇒ *locate fault* and repair it. Bad pressure on the roll; ⇒ set *correct* pressure. Faulty control unit; ⇒ contact service.
- **Bad quality of weld:** Bad gas flow, incorrect wire speed, contaminated surface, improper quality of wire or gas, bad welding parameters, worn parts of machine ⇒ use *good quality* products for welding, *maintain* the machine regularly.

It is very important that the welding parameters would be set *properly* for the welding task:

- **Welding current:** can be regulated by the wire feed speed, through the melting output.
- **Arc voltage:** weld with a *short* arc if it is possible; width, depth and surface of the seam depend also on this.
- **Sticking out:** it is recommended to be *short*; it influences the melting output, gas shielding, spatter loss.
- **Polarity:** the reverse polarity can be used *only* for piling welding.
- **Nozzle-to-work distance:** be *short* because of gas shielding, but the gas nozzle must be protected from *heat*.
- **Leading of the torch:** usually *pulling*; the *pushing* welding can be used for *root welding* because of the wide and flat seam.

8. Parts list

| N° | Part | qty | Code | N° | Part | qty | Code | | |
|---------------------------------|--------------------------------------|-------|------|------------|---|--------------------------------|------------|-------------|------------|
| On the front plate | | | | 1. | Plastic handle | 2 | 2142240230 | | |
| 2. | Electronic unit MHT 3.0 | AI | 1 | 2142241056 | 3. | 11-pin PCB connector (AI) | 1 | 2342240179 | |
| 4. | Turning knob FF-25 | (P4) | 1 | 2342240017 | 5. | Turning knob FF-16 (K,P7,P8) | 3 | 2342240015 | |
| 6. | Switch GN 25-6720 (0-3) | Q1 | 1 | 2142330065 | 7. | Switch GN 25-8407 (1-10) | Q2 | 1 | 2142330160 |
| 8. | Standard central adaptor | | 1 | 2142240095 | 9. | Welding cable socket CX-31 | 3 | 2142240068 | |
| 10. | Polarity cable's fixing clamp | | 1 | 2342240567 | 11. | Polarity cable's plug CX-21 | 1 | 2142240154 | |
| On the rear plate | | | | 12. | Mains cable 4×2.5 mm ² , 5 m | 1 | 2343630024 | | |
| 13. | Mains cable's fixing clamp | | 1 | 2342240567 | 14. | 3/8" gas connector to cylinder | 1 | 900-000-117 | |
| 15. | Gas hose Ø9/5, 1.5 m | | 1 | 2357320008 | 16. | Gas solenoid valve 42V~ | Y1 | 1 | 2142241101 |
| 17. | Safety grid for fan Ø250 | | 1 | 2142240232 | 18. | Fan blade Ø250 | | 1 | 2142240175 |
| 19. | Fan holder Ø250 | | 1 | 28422410 | 20. | Fan motor VNT16, 230V~ | MI | 1 | 2142240583 |
| Inside | | | | | | | | | |
| 21. | Main transformer | TI | 1 | 29080293 | 22. | Rectifier bridge PTS-293 | VI | 1 | 2142240261 |
| 23. | Choke | LI | 1 | 29090235 | 24. | Auxiliary transformer | T2 | 1 | 29081139 |
| 25. | Contacto LC1-D32, 42V~ | KI | 1 | 2142320096 | 26. | Filter unit EMC-3 | | 1 | 28040623 |
| In the wire reel's space | | | | 27. | Fuse holder G-30 (500V) | 2 | 2343730050 | | |
| 28. | Fuse 1A/500V | F1,F2 | 4 | 2343730052 | 29. | Fuse holder PTF-35 (250V) | 1 | 2343730015 | |
| 30. | Fuse 3.15A/250V | F3 | 2 | 2343730049 | 31. | Feeding mechan. 2445L-402D | 1 | 2142241559 | |
| 32. | Feed. motor D76L, 24V 45W | M2 | 1 | 2142241559 | 33. | Feeding roll Ø40/22, Ø0.8-1.0V | 1 | 2342240646 | |
| 34. | Feeding roll Ø40/22, Ø0.9-1.2V | | 1 | 2342240737 | 35. | Wire reel (spool) holder | 1 | 2142240076 | |
| Others | | | | 36. | Earth cable's plug CX-21 | 1 | 2142240154 | | |
| 37. | Earth cable 35 mm ² , 5 m | | 1 | 2343630015 | 38. | Earth clamp 350A | 1 | 2142240072 | |
| 39. | Shunt 600A/60 mV (option) | SI | 1 | 2142241101 | 40. | V-A-meter (option) | | 2147540008 | |