

2 YEAR
PRODUCT
WARRANTY



Unimig® VIPER 182 Mk II

U14001K | Operating Manual





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Welding and cutting equipment can be dangerous to both the operator and people in or near the surrounding working area if the equipment is not correctly operated. Equipment must only be used under the strict and comprehensive observance of all relevant safety regulations.

Read and understand this instruction manual carefully before the installation and operation of this equipment.

Machine Operating Safety

- Do not switch the function modes while the machine is operating. Switching of the function modes during welding can damage the machine. Damage caused in this manner will not be covered under warranty.
- Disconnect the electrode-holder cable from the machine before switching on the machine, to avoid arcing should the electrode be in contact with the workpiece.
- Operators should be trained and or qualified.



Electric shock: It can kill. Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on. The input power circuit and internal machine circuits are also live when power is on. In MIG/MAG welding, the wire, drive rollers, wire feed housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is dangerous.

- Connect the primary input cable, according to Australian and New Zealand standards and regulations.
- Avoid all contact with live electrical parts of the welding/cutting circuit, electrodes and wires with bare hands.
- The operator must wear dry welding gloves while he/she performs the welding/cutting task.
- The operator should keep the workpiece insulated from himself/herself.
- Keep cords dry, free of oil and grease, and protected from hot metal and sparks.
- Frequently inspect input power cable for wear and tear, replace the cable immediately if damaged, bare wiring is dangerous and can kill.
- Do not use damaged, undersized, or badly joined cables.
- Do not drape cables over your body.
- We recommend (RCD) safety switch is used with this equipment to detect any leakage of current to earth.



Fumes and gases are dangerous. Smoke and gas generated while welding or cutting can be harmful to people's health. Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

- Do not breathe the smoke and gas generated while welding or cutting, keep your head out of the fumes.
- Keep the working area well ventilated, use fume extraction or ventilation to remove welding/cutting fumes and gases.
- In confined or heavy fume environments always wear an approved air-supplied respirator.
- Welding/cutting fumes and gases can displace air and lower the oxygen level, causing injury or death. Be sure the breathing air is safe.
- Do not weld/cut in locations near degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapours to form highly toxic and irritating gases.
- Materials such as galvanised, lead, or cadmium plated steel, containing elements that can give off toxic fumes when welded/cut. Do not weld/cut these materials unless the area is very well ventilated, and or wearing an air-supplied respirator.



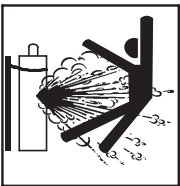
Arc rays: harmful to people's eyes and skin. Arc rays from the welding/cutting process produce intense visible and invisible ultraviolet and infrared rays that can burn eyes and skin.

- Always wear a welding helmet with the correct shade of filter lens and suitable protective clothing, including welding gloves while the welding/cutting operation is performed.
- Measures should be taken to protect people in or near the surrounding working area. Use protective screens or barriers to protect others from flash, glare and sparks; warn others not to watch the arc.



Fire hazard. Welding/cutting on closed containers, such as tanks, drums, or pipes, can cause them to explode. Flying sparks from the welding/cutting arc, hot workpiece, and hot equipment can cause fires and burns. Accidental contact of the electrode to metal objects can cause sparks, explosion, overheating, or fire. Check and be sure the area is safe before doing any welding/cutting.

- The welding/cutting sparks & spatter may cause fire, therefore remove any flammable materials well away from the working area. Cover flammable materials and containers with approved covers if unable to be moved from the welding/cutting area.
- Do not weld/cut on closed containers such as tanks, drums, or pipes, unless they are correctly prepared according to the required Safety Standards to ensure that flammable or toxic vapours and substances are totally removed, these can cause an explosion even though the vessel has been “cleaned”. Vent hollow castings or containers before heating, cutting or welding. They may explode.
- Do not weld/cut where the atmosphere may contain flammable dust, gas, or liquid vapours (such as petrol)
- Have a fire extinguisher nearby and know how to use it. Be alert that welding/cutting sparks and hot materials from welding/cutting can easily go through small cracks and openings to adjacent areas. Be aware that welding/cutting on a ceiling, floor, bulkhead, or partition can cause a fire on the hidden side.



Gas Cylinders. Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Because gas cylinders usually are part of the welding/cutting process, be sure to treat them carefully. CYLINDERS can explode if damaged.

- Protect gas cylinders from excessive heat, mechanical shocks, physical damage, slag, open flames, sparks, and arcs.
- Ensure cylinders are held secure and upright to prevent tipping or falling over.
- Never allow the welding/cutting electrode or earth clamp to touch the gas cylinder, do not drape welding cables over the cylinder.
- Never weld/cut on a pressurised gas cylinder, it will explode and kill you.
- Open the cylinder valve slowly and turn your face away from the cylinder outlet valve and gas regulator.



Gas build-up. The build-up of gas can cause a toxic environment, deplete the oxygen content in the air resulting in death or injury. Many gases used in welding/cutting are invisible and odourless.

- Shut off shielding gas supply when not in use.
- Always ventilate confined spaces or use approved air-supplied respirator.



Electronic magnetic fields. MAGNETIC FIELDS can affect Implanted Medical Devices.

- Wearers of Pacemakers and other Implanted Medical Devices should keep away.
- Implanted Medical Device wearers should consult their doctor and the device manufacturer before going near any electric welding, cutting or heating operation.



Noise can damage hearing. Noise from some processes or equipment can damage hearing.

- Wear approved ear protection if noise level is high.



Hot parts. Items being welded/cut generate and hold high heat and can cause severe burns.

- Do not touch hot parts with bare hands. Allow a cooling period before working on the welding/cutting gun. Use insulated welding gloves and clothing to handle hot parts and prevent burns.

CAUTION

1. Working Environment.

- i. The environment in which this welding/cutting equipment is installed must be free of grinding dust, corrosive chemicals, flammable gas or materials etc., and at no more than a maximum of 80% humidity.
- ii. When using the machine outdoors, protect the machine from direct sunlight, rainwater and snow, etc.; the temperature of the working environment should be maintained within -10°C to +40°C.
- iii. Keep this equipment 30cm distant from the wall.
- iv. Ensure the working environment is well ventilated.

2. Safety Tips.

- i. **Ventilation:** This equipment is small-sized, compact in structure, and of excellent performance in amperage output. The fan is used to dissipate heat generated by this equipment during the welding/cutting operation. Important: Maintain good ventilation of the louvres of this equipment. The minimum distance between this equipment and any other objects in or near the working area should be 30 cm. Good ventilation is of critical importance for the normal performance and service life of this equipment.
- ii. **Thermal Overload Protection:** Should the machine be used to an excessive level, or in a high-temperature environment, poorly ventilated area or if the fan malfunctions the Thermal Overload Switch will be activated, and the machine will cease to operate. Under this circumstance, leave the machine switched on to keep the built-in fan working to bring down the temperature inside the equipment. The machine will be ready for use again when the internal temperature reaches a safe level.
- iii. **Over-Voltage Supply:** Regarding the power supply voltage range of the machine, please refer to the “Main parameter” table. This equipment is of automatic voltage compensation, which enables the maintaining of the voltage range within the given range. In case that the voltage of input power supply amperage exceeds the stipulated value, it is possible to cause damage to the components of this equipment. Please ensure your primary power supply is correct.
- iv. Do not come into contact with the output terminals while the machine is in operation. An electric shock may occur.

MAINTENANCE

Exposure to extremely dusty, damp, or corrosive air is damaging to the welding/cutting machine. To prevent any possible failure or fault of this welding/cutting equipment, clean the dust at regular intervals with clean and dry compressed air of required pressure.

Please note that: lack of maintenance can result in the cancellation of the guarantee; the guarantee of this welding/cutting equipment will be void if the machine has been modified, attempt to take apart the machine or open the factory-made sealing of the machine without the consent of an authorized representative of the manufacturer.

TROUBLESHOOTING

Caution: Only qualified technicians are authorized to undertake the repair of this welding/cutting equipment. For your safety and to avoid Electrical Shock, please observe all safety notes and precautions detailed in this manual.

ATTENTION! - CHECK FOR GAS LEAKAGE

At initial set up and at regular intervals we recommend to check for gas leakage

Recommended procedure is as follows:

- 1.** Connect the regulator and gas hose assembly and tighten all connectors and clamps.
- 2.** Slowly open the cylinder valve.
- 3.** Set the flow rate on the regulator to approximately 8-10 L/min.
- 4.** Close the cylinder valve and pay attention to the needle indicator of the contents pressure gauge on the regulator, if the needle drops away towards zero there is a gas leak. Sometimes a gas leak can be slow and to identify it will require leaving the gas pressure in the regulator and line for an extended time period. In this situation it is recommended to open the cylinder valve, set the flow rate to 8-10 L/min, close the cylinder valve and check after a minimum of 15 minutes.
- 5.** If there is a gas loss then check all connectors and clamps for leakage by brushing or spraying with soapy water, bubbles will appear at the leakage point.
- 6.** Tighten clamps or fittings to eliminate gas leakage.

IMPORTANT! - We strongly recommend that you check for gas leakage prior to operation of your machine. We recommend that you close the cylinder valve when the machine is not in use.

Welding Guns Of Australia PTY LTD, authorised representatives or agents of Welding Guns Of Australia PTY LTD will not be liable or responsible for the loss of any gas.

VIPER™ 182 Mk II MIG/STICK Welder

Key Features:

- Spool Gun Ready
- Geared Wire Drive
- 10 AMP Plug

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TECHNICAL DATA

SKU	U11002K
PRIMARY INPUT VOLTAGE	240V Single Phase
SUPPLY PLUG	10 AMP
RATED INPUT POWER (kVA)	7.1
I _{eff} (A)	9.8
RATED OUTPUT	30A/15.5V - 180A/23.0V
NO LOAD VOLTAGE (V)	62
PROTECTION CLASS	IP21S
INSULATION CLASS	F
POWER FACTOR	0.7
MINIMUM GENERATOR (kVA)	10
DINSE CONNECTOR	35/50
STANDARD	AS/NZ60974-1
WELDS	Mild Steel, Stainless Steel, Cast Iron, Silicon Bronze, Aluminium, Copper
WARRANTY (Years)	2

MIG SPECIFICATIONS

MIG WELDING CURRENT RANGE	30-180A
MIG DUTY CYCLE @ 40°C	10% @ 180A
MIG WIRE SIZE RANGE	0.6-0.9mm
MIG WIRE SPOOL SIZE	1kg / 5kg
MIG WELDING THICKNESS RANGE	1-10mm
DRIVE ROLLER SIZE	30/22

STICK SPECIFICATIONS

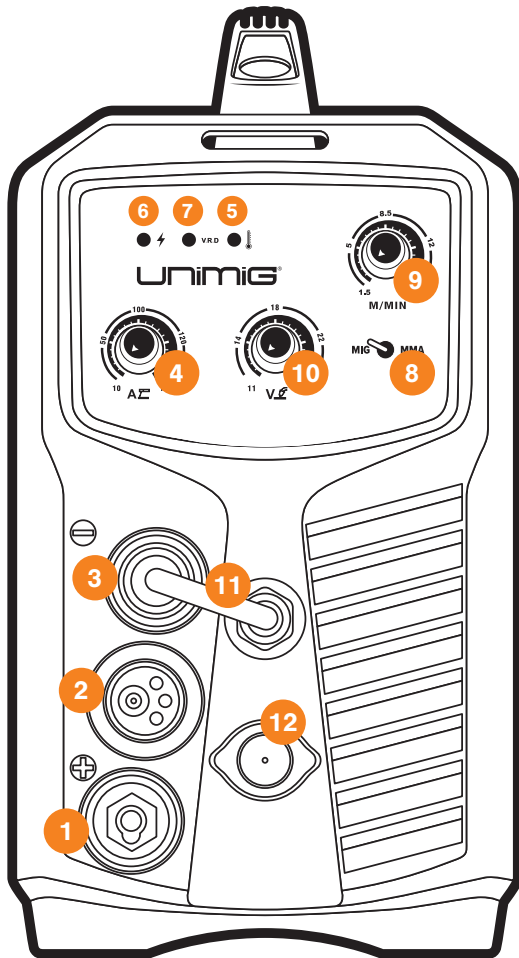
STICK WELDING CURRENT RANGE	10-160A
STICK DUTY CYCLE @ 40°C	10% @ 160A
STICK ELECTRODE RANGE	2.5-4.0mm
STICK WELDING THICKNESS RANGE	2-10mm

SIZE & WEIGHT

DIMENSIONS (mm)	553x214x388mm
WEIGHT (kg)	12.0kg

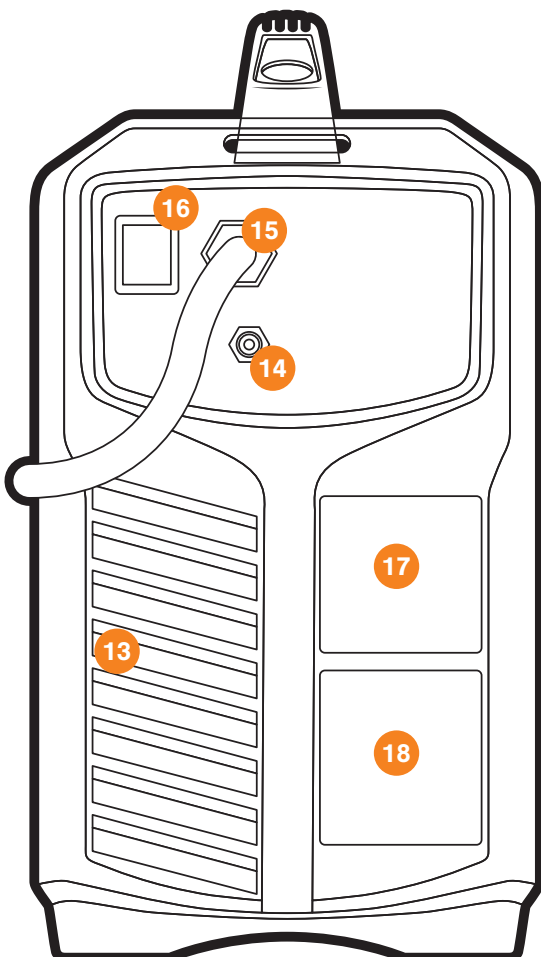
MACHINE FEATURES

WIRE DRIVE	Geared
VRD	Yes
SPOOL GUN CONNECTION	Yes
BURNBACK ADJUSTMENT	Yes
WIRE INCH	Yes
THERMAL OVERLOAD PROTECTION	Over Temperature Warning



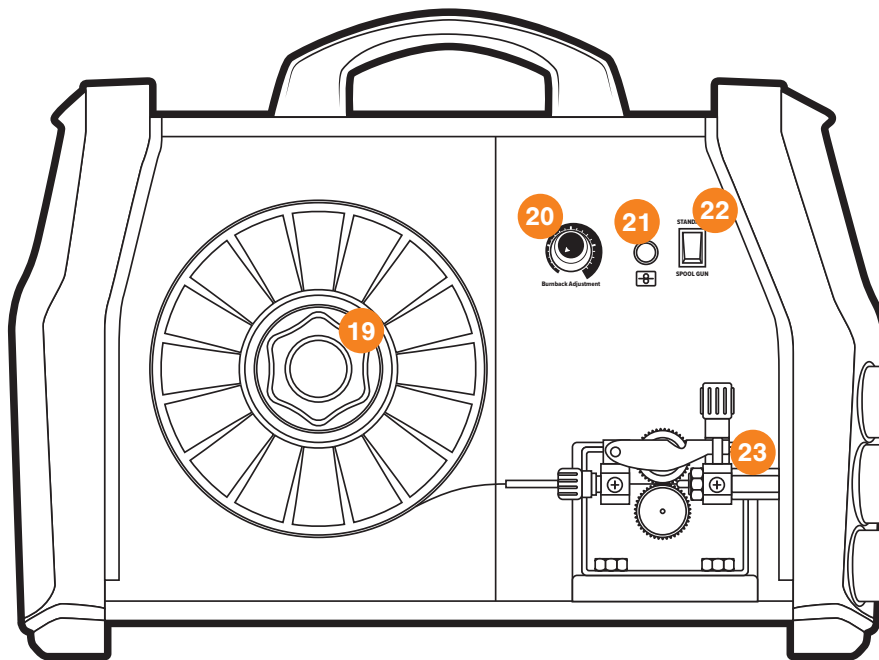
Front Panel Layout

1. "+" Output terminal
2. Euro connection
3. "-" Output terminal
4. Amperage control knob in MMA
5. Thermal Overload LED
6. Power LED
7. VRD LED
8. MIG/MMA switch
9. Wire feed speed control in MIG
10. Voltage control knob in MIG
11. Polarity cable
12. Socket for Spool Gun



Rear Panel Layout

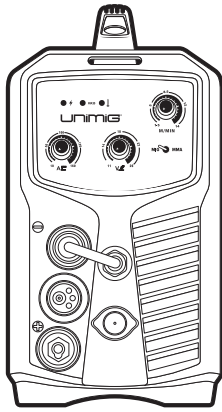
13. Fan
14. Gas inlet
15. Input power cord
16. On/off Switch
17. Warning mark
18. Data plate



Interior Layout

- 19.** Wire feeding spool holder
- 20.** Burn-back control knob
- 21.** Manual wire feeding button
- 22.** Spool Gun selecting switch
- 23.** Wire feeder

WHAT'S IN THE BOX



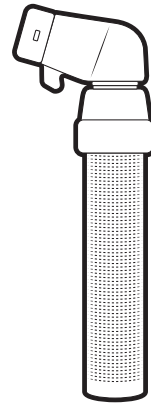
VIPER 182 Mk II MIG/STICK Welder



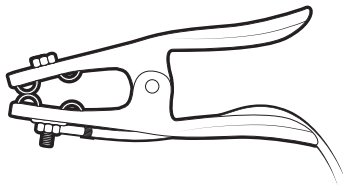
Includes:

- 1 x 0.8mm Contact Tip
- 1 x Tip Holder
- 1 x Gas Nozzle

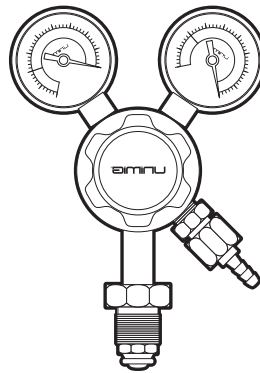
3m SB15 MIG Torch



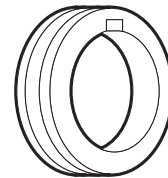
3m Electrode Holder



3m 300 AMP Earth Clamp



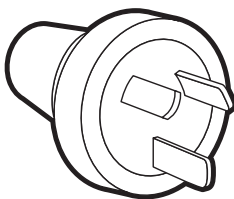
Twin Gauge Argon Regulator



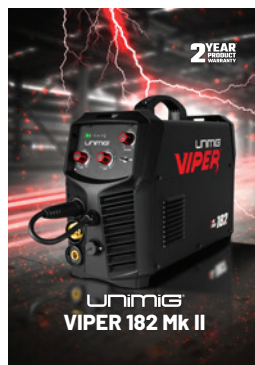
Includes:

- 1 x 0.8-0.9mm "V GROOVE" 30/22
- 1 x 0.8-0.9mm "F GROOVE" 30/22
- 1 x 0.9-1.0mm "U GROOVE" 30/22

Drive Rollers



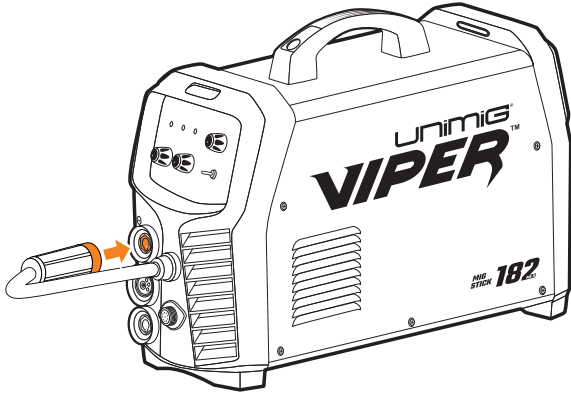
10 AMP Plug (Fitted)



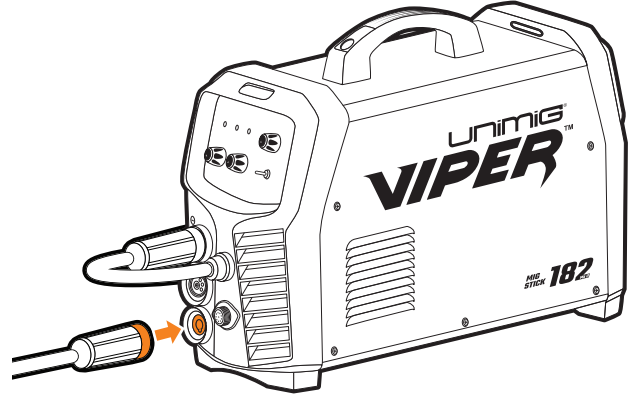
Operating Manual

SETUP FOR MIG (GASLESS)

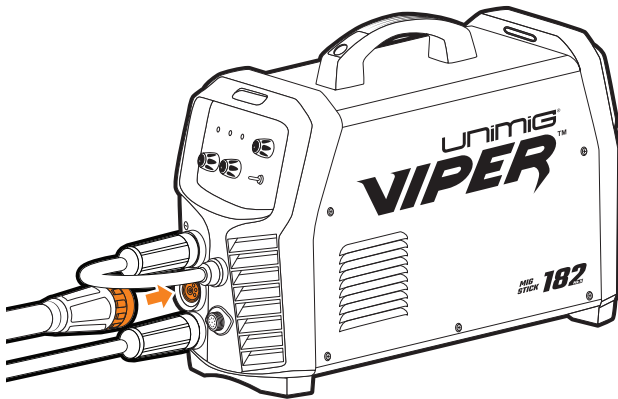
- 1 Connect the polarity cable to the **negative (-)** dinse connection, twist to lock in place.



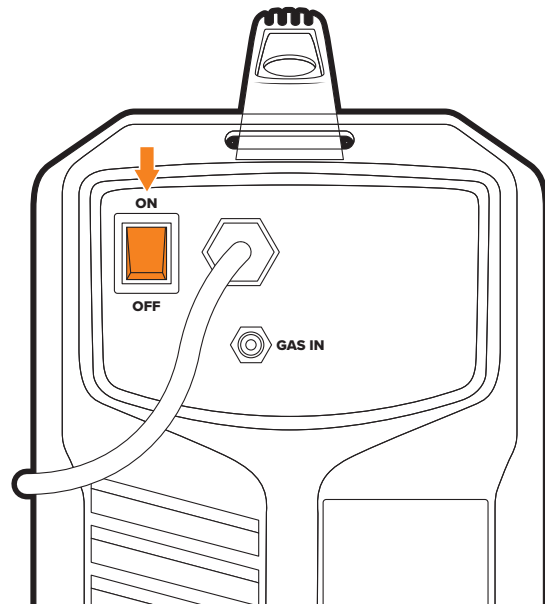
- 2 Connect the earth clamp to the **positive (+)** dinse connection, twist to lock in place.



- 3 Connect the MIG torch to the Euro connection, and twist end to secure in place.

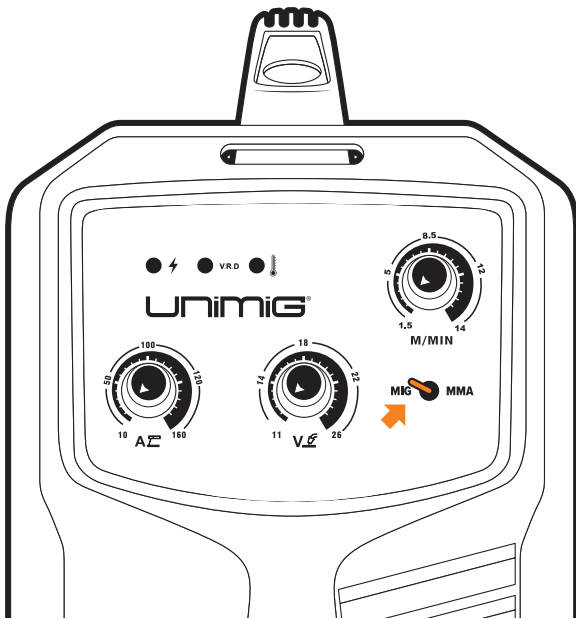


- 4 Connect the plug into a 10 AMP socket, then switch the machine ON.

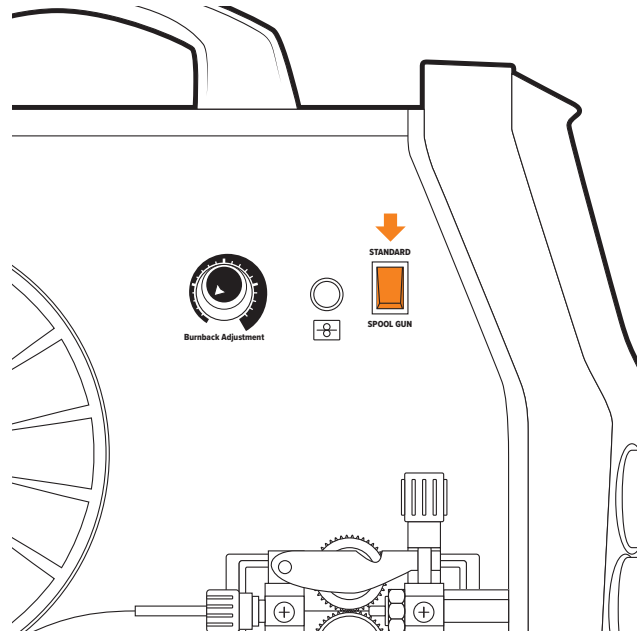


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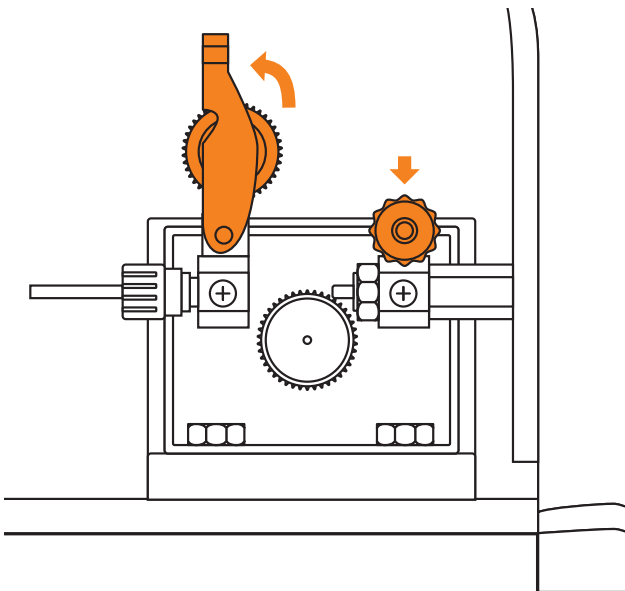
- 5 Select **MIG** on the MIG/MMA selector.



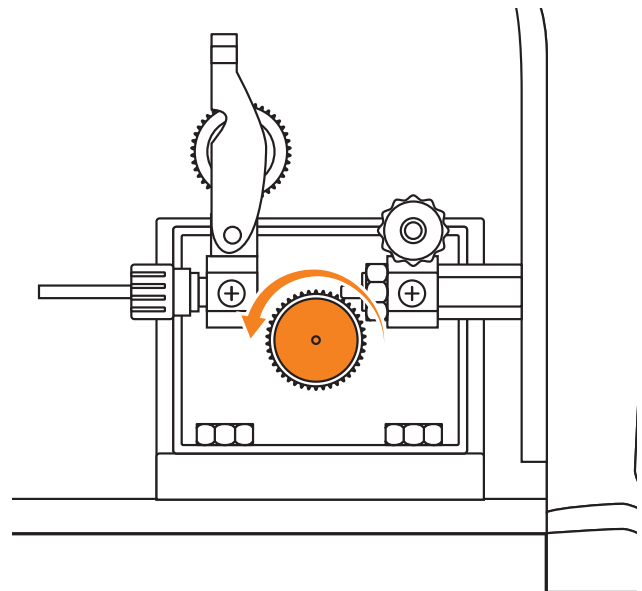
- 6 Select **Standard** on the Standard/Spool Gun selector.



- 7 Pull down the roller tension knob to release the wire drive.

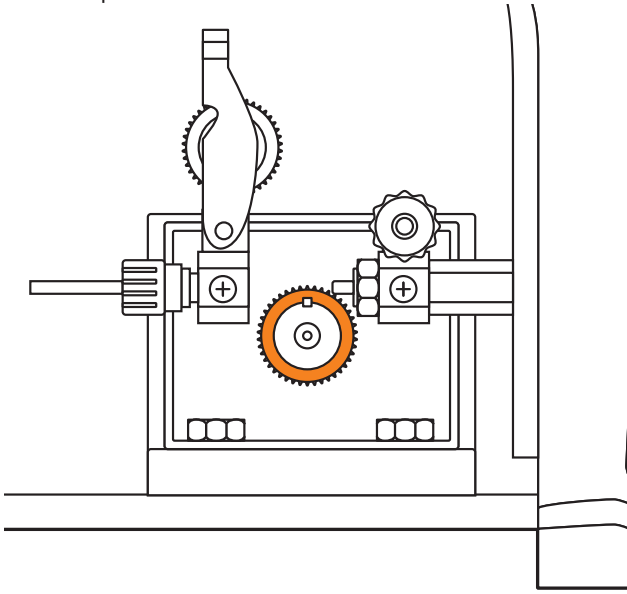


- 8 Unscrew the roller cap.

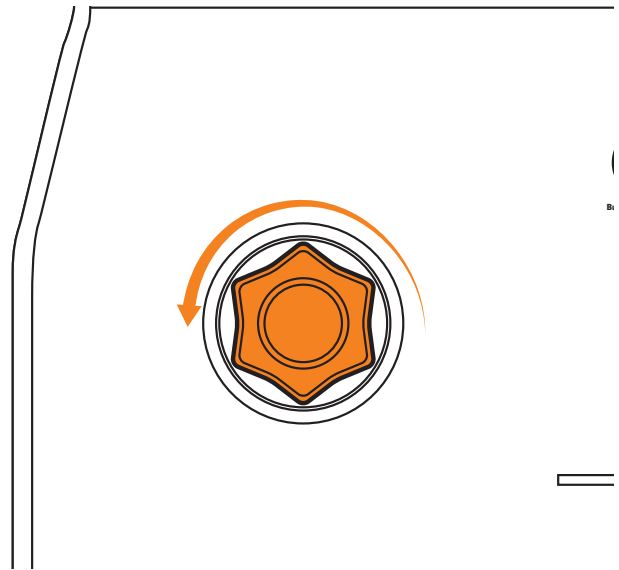


SETUP FOR MIG (GASLESS)

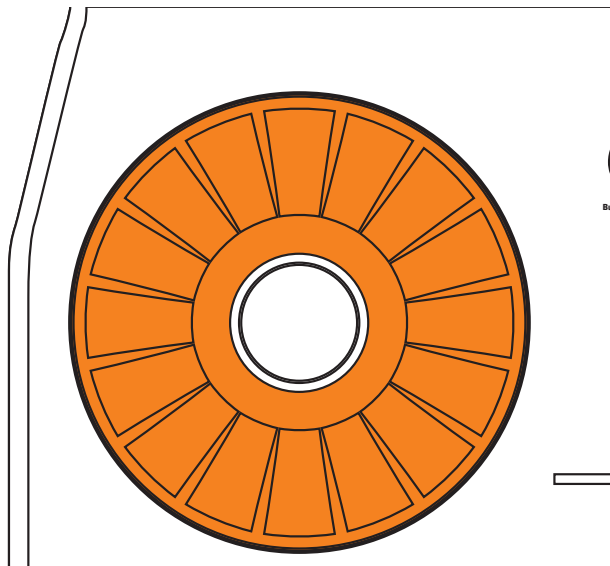
- 9** Ensure you have an Knurled (F Groove) drive roller installed. If not, fit correct roller and replace the roller cover.



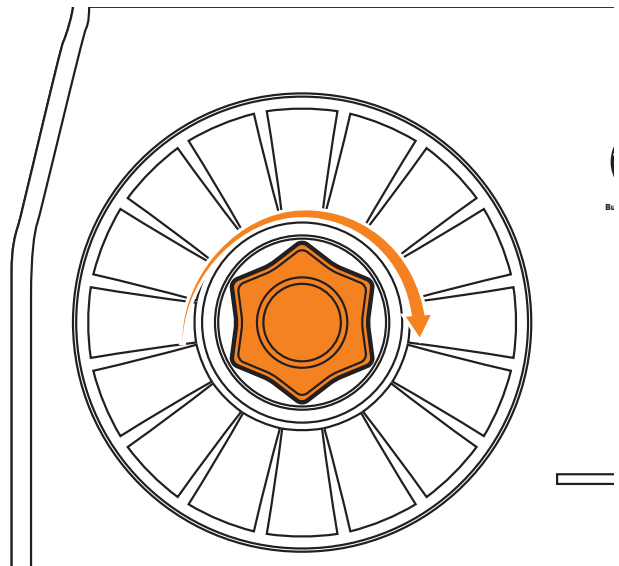
- 10** Unscrew spool retaining nut.



- 11** Place 5kg wire spool onto the spool holder. For 1kg spool, see step 18.

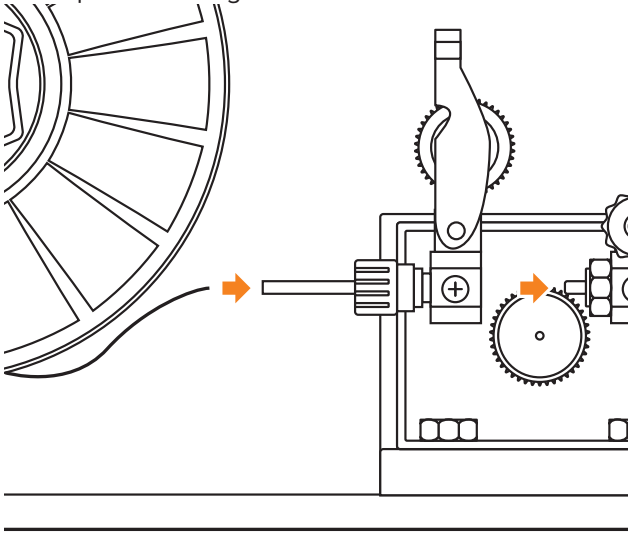


- 12** Tighten spool retaining nut.

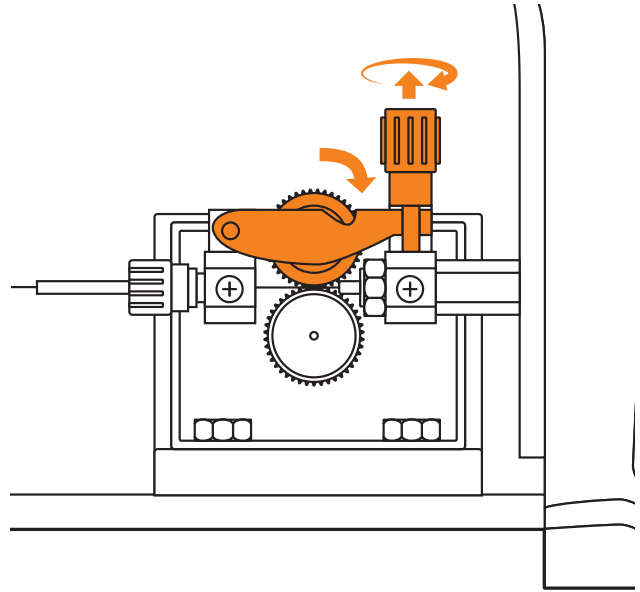


SETUP FOR MIG (GASLESS)

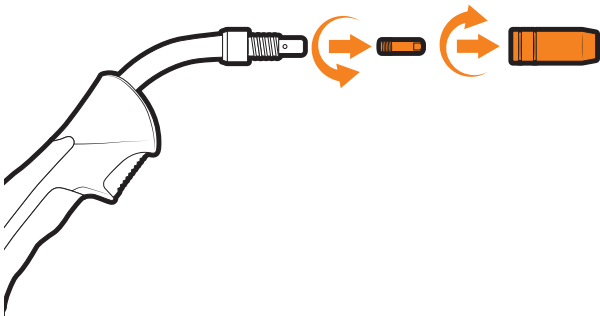
- 13** Feed wire through the inlet guide tube through to the outlet guide tube. Ensure that the wire passes through the roller.



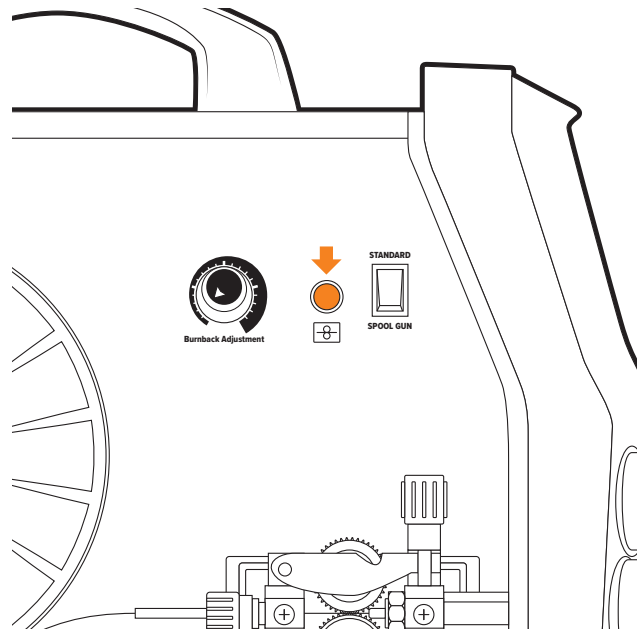
- 14** Lift roller tension knob to lock wire in place. Twist to tighten.



- 15** Remove front end consumables from the MIG torch.

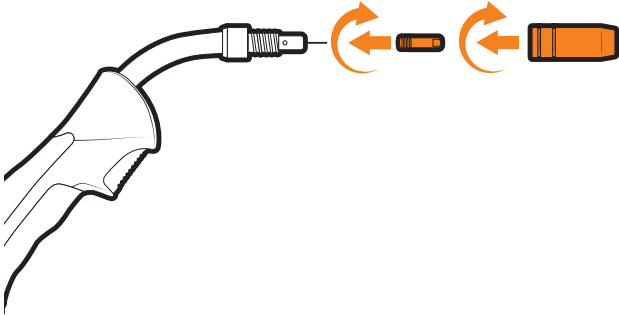


- 16** Hold the Wire Inch button to feed wire through to the torch. If the wire slips or stops you will need to adjust the roller tension knob.

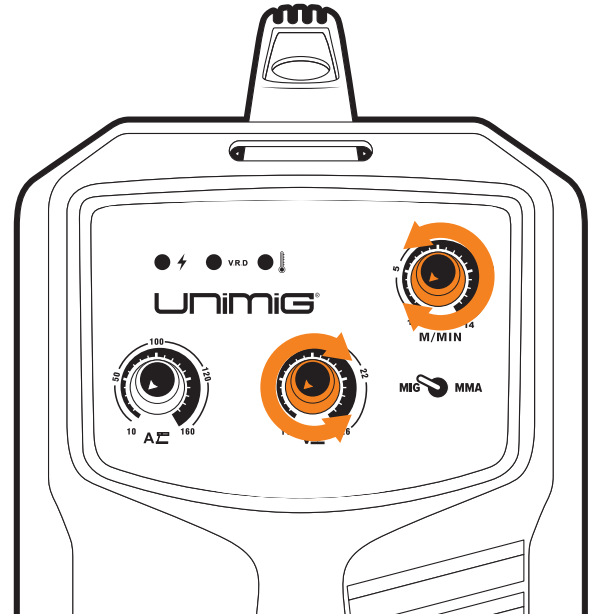


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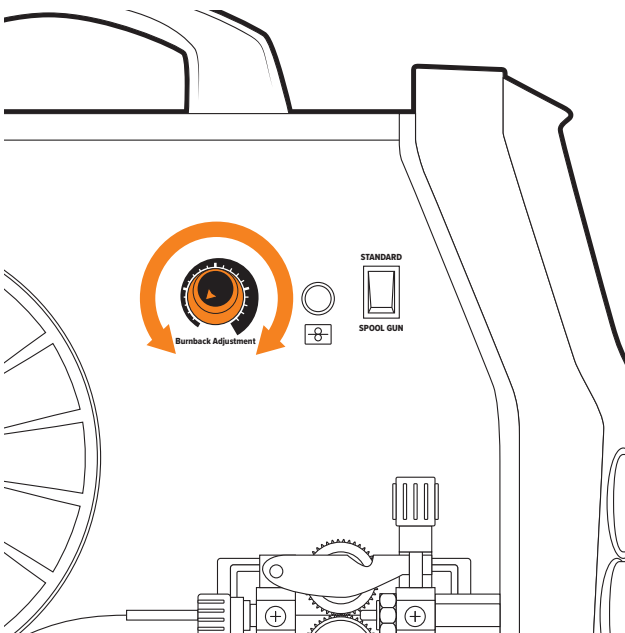
- 17** Replace front end consumables on the MIG torch.



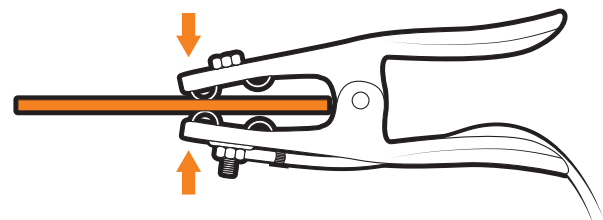
- 18** Adjust voltage and wire speed according to your material and thickness.



- 19** Adjust the burn back control to prevent the wire sticking in the weld pool. Burn back control is located above the wire feed motor.

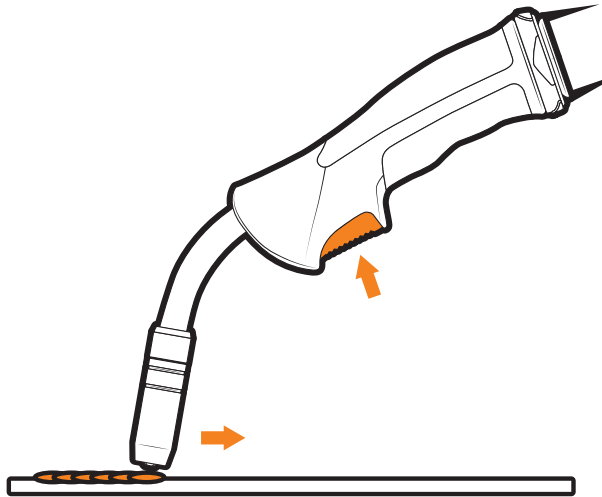


- 20** Connect earth clamp to your workpiece.

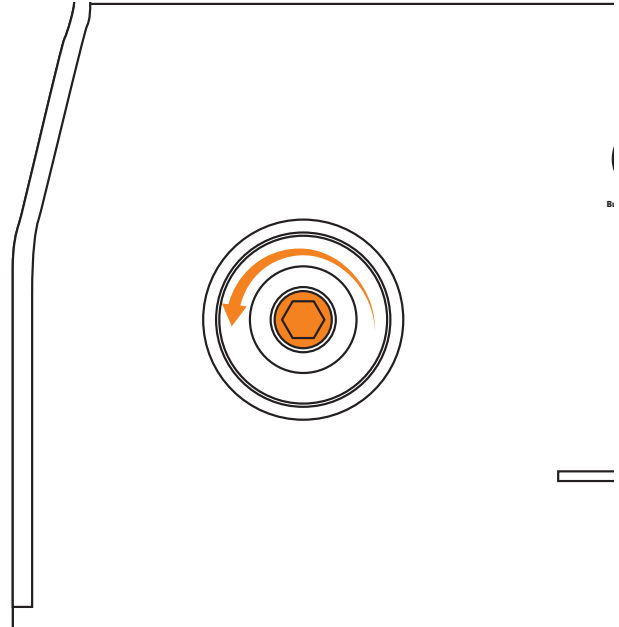


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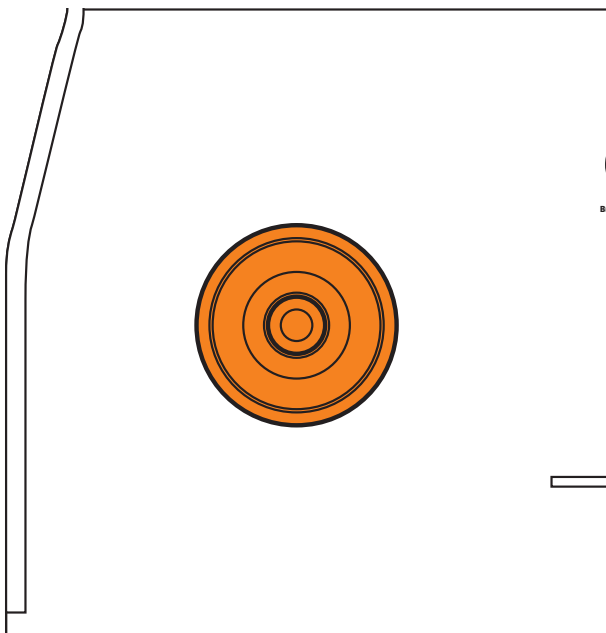
- 17** Line up the torch with your workpiece, then simply pull the trigger to initiate the weld. For gasless MIG, the drag method is recommended for optimum weld quality. Release trigger to end the weld.



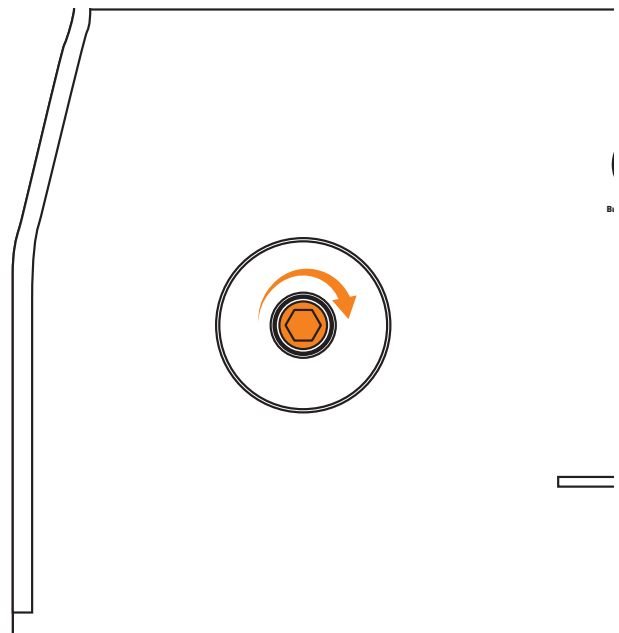
- 18** **For 1kg spool:** After removing spool holder nut, unscrew the 1kg spool bolt located inside the spool holder housing.



- 19** **For 1kg spool:** Remove spool holder housing and spring. Place 1kg spool housing inside the square hole where the spool housing is removed from. The 1kg housing is found on the inside of the main spool holder housing.

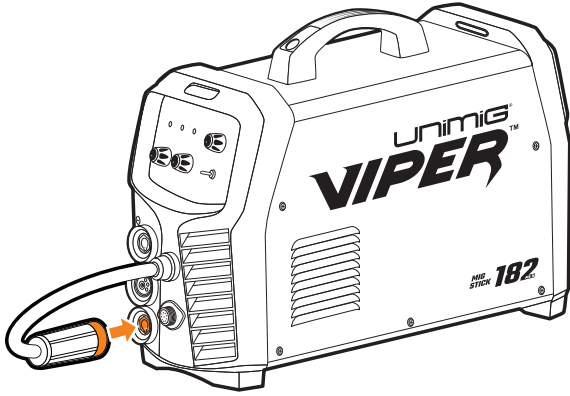


- 20** **For 1kg spool:** Place 1kg spool over 1kg spool housing, then tighten and secure with 1kg spool bolt and nut.

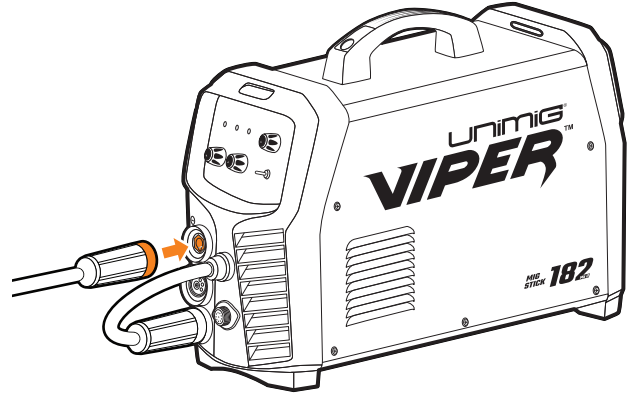


SETUP FOR MIG (GAS-SHIELDED)

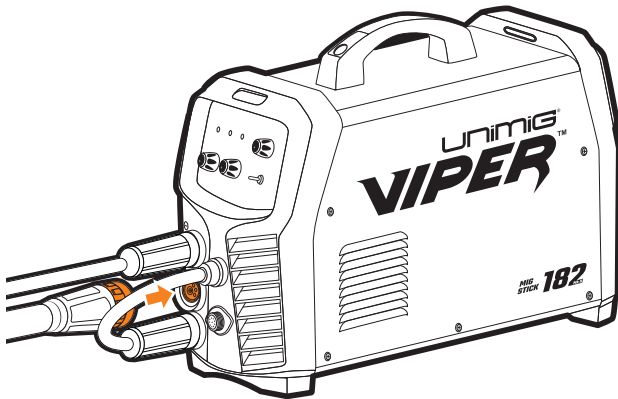
- 1 Connect the polarity cable to the **positive (+)** dinse connection, twist to lock in place.



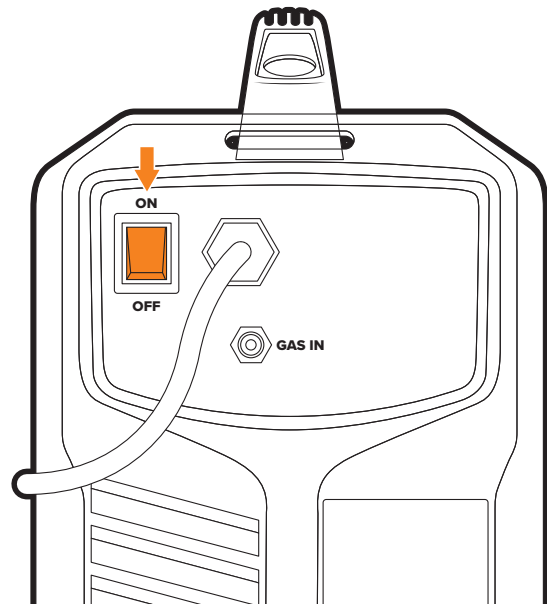
- 2 Connect the earth clamp to the **negative (-)** dinse connection, twist to lock in place.



- 3 Connect the MIG torch to the Euro connection, and twist end to secure in place.

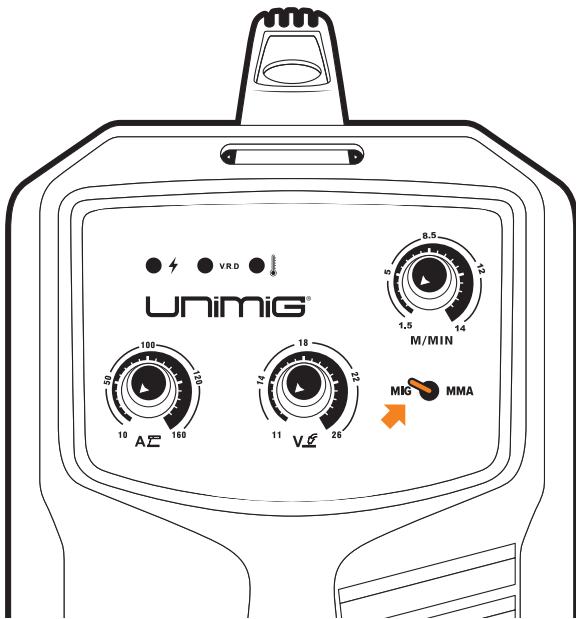


- 4 Connect the plug into a 10 AMP socket, then switch the machine ON.

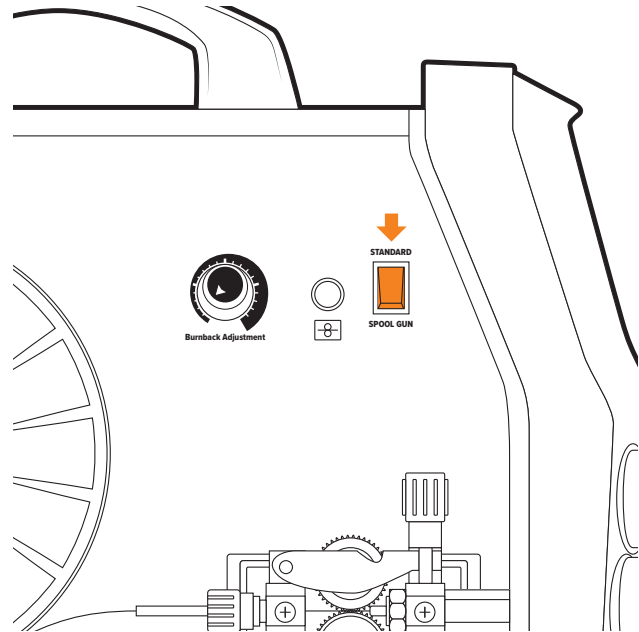


SETUP FOR MIG (GAS-SHIELDED)

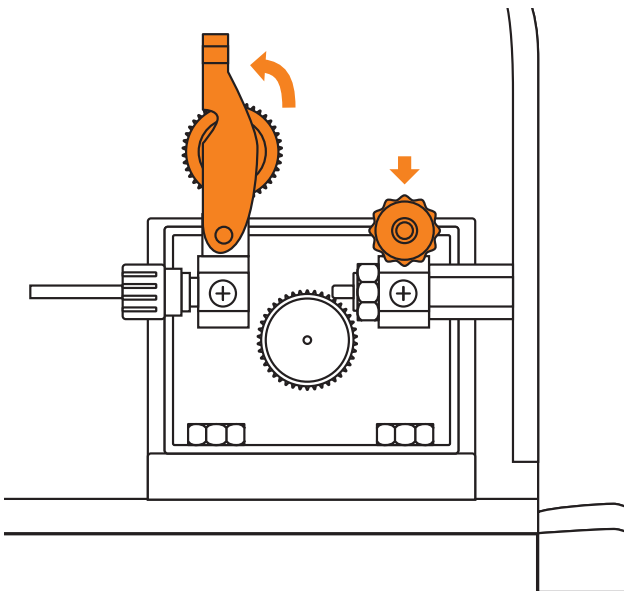
- 5 Select **MIG** on the MIG/MMA selector.



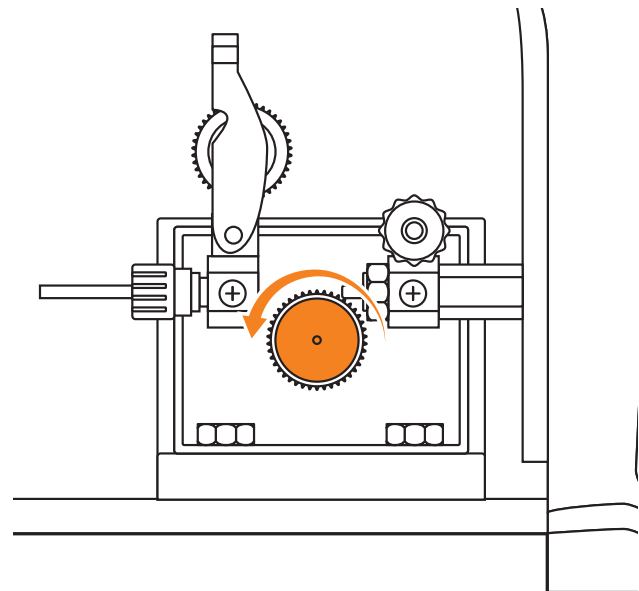
- 6 Select **Standard** on the Standard/Spool Gun selector.



- 7 Pull down the roller tension knob to release the wire drive.

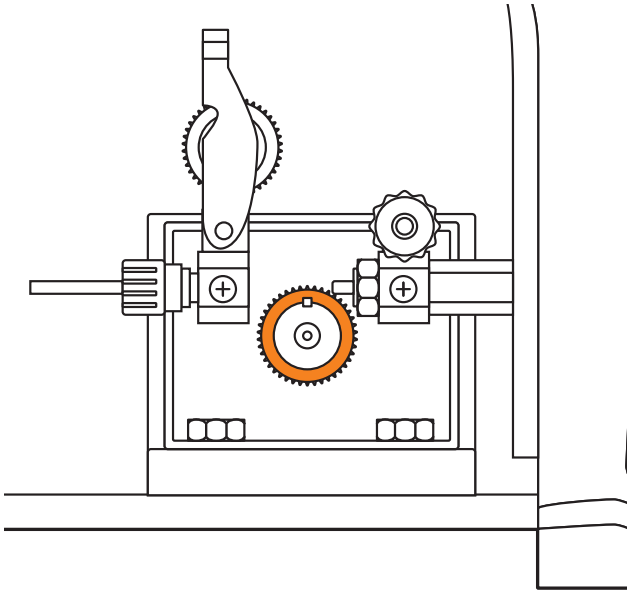


- 8 Unscrew the roller cap.

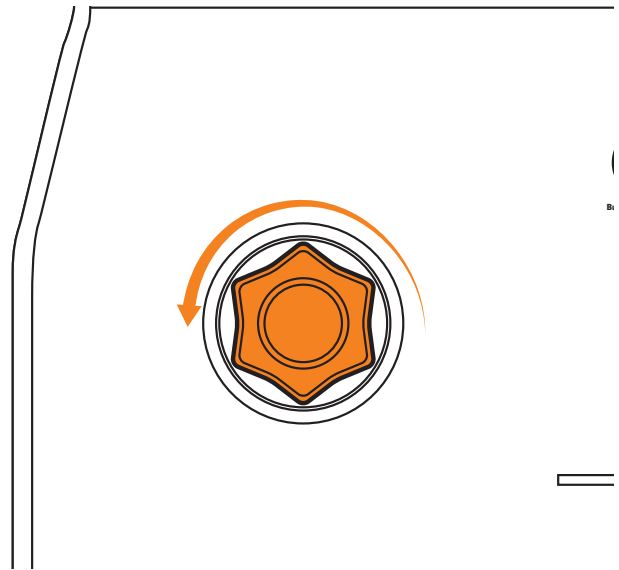


SETUP FOR MIG (GAS-SHIELDED)

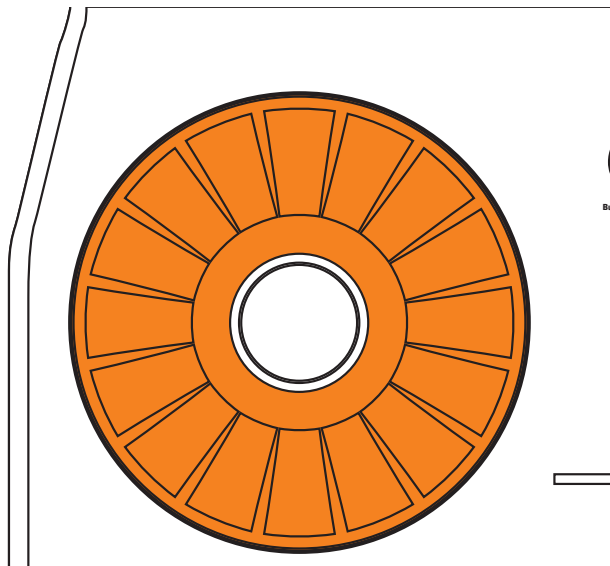
- 9** Ensure you have an V Groove drive roller installed. If not, fit correct roller and replace the roller cover.



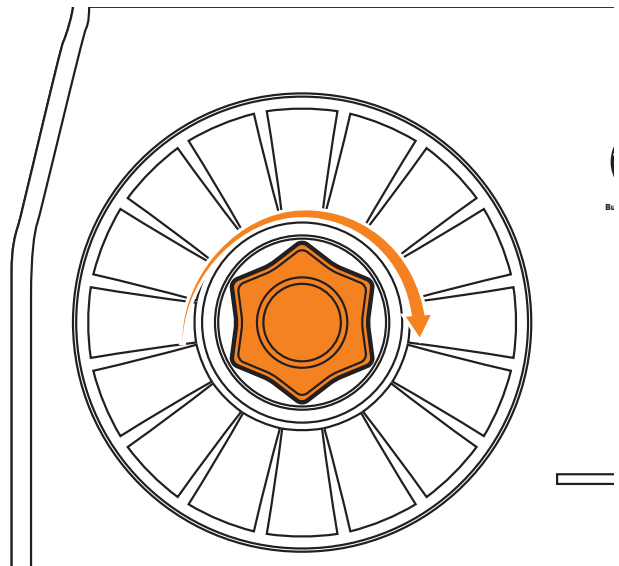
- 10** Unscrew spool retaining nut.



- 11** Place 5kg wire spool onto the spool holder. For 1kg spool, see step 27.

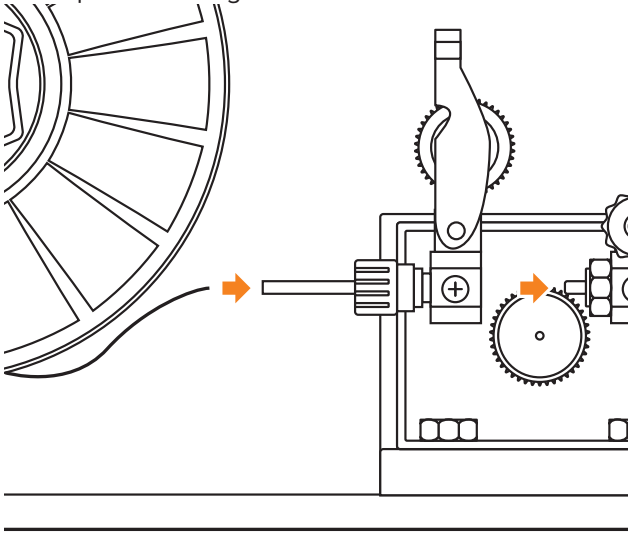


- 12** Tighten spool retaining nut.

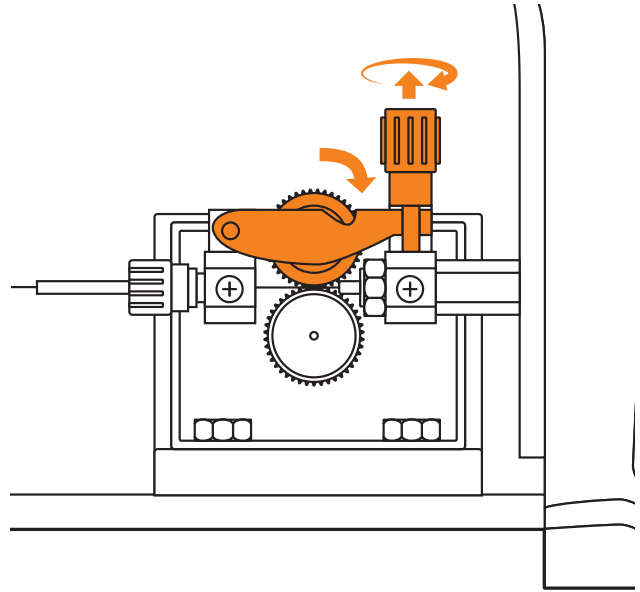


SETUP FOR MIG (GAS-SHIELDED)

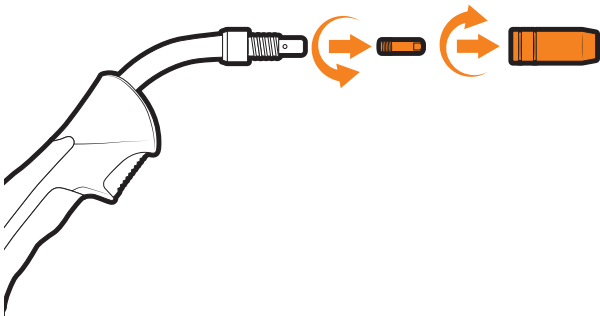
- 13** Feed wire through the inlet guide tube through to the outlet guide tube. Ensure that the wire passes through the roller.



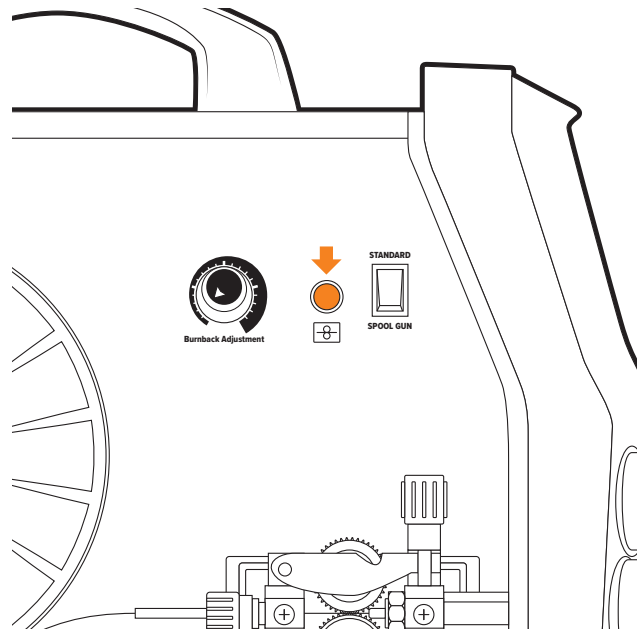
- 14** Lift roller tension knob to lock wire in place. Twist to tighten.



- 15** Remove front end consumables from the MIG torch.

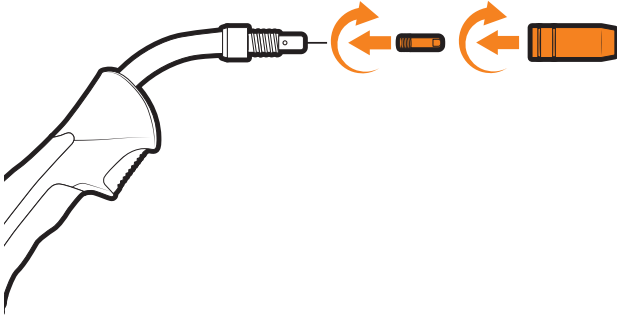


- 16** Hold the Wire Inch button to feed wire through to the torch. If the wire slips or stops you will need to adjust the roller tension knob.

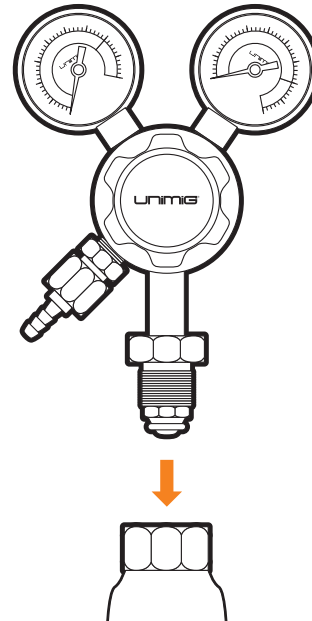


SETUP FOR MIG (GAS-SHIELDED)

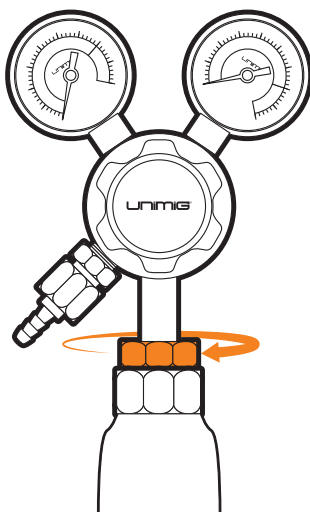
- 17** Replace front end consumables on the MIG torch.



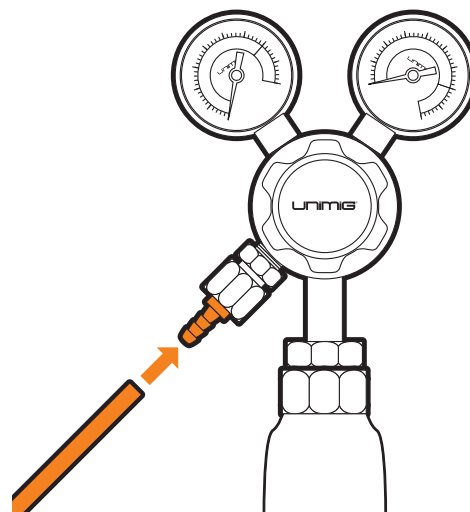
- 18** Place twin gauge argon regulator into your gas outlet.



- 19** Tighten securely with wrench.

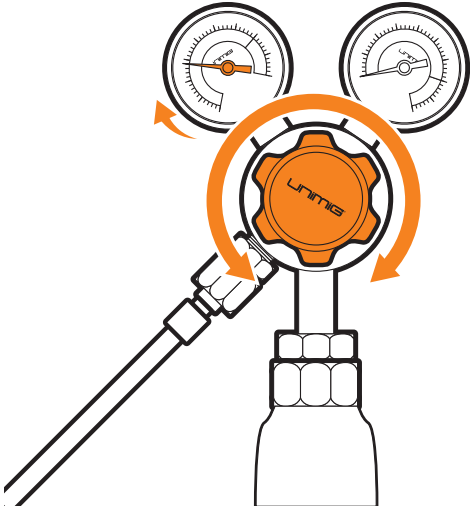


- 20** Connect gas hose to the regulator outlet, and crimp in place.

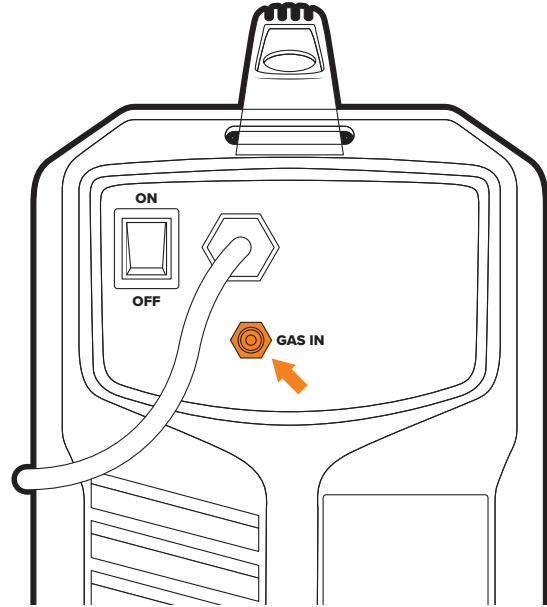


SETUP FOR MIG (GAS-SHIELDED)

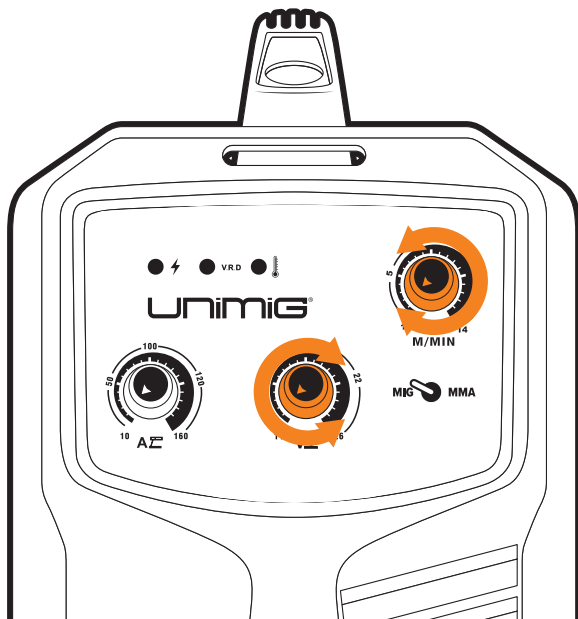
21 Adjust gas flow to 8-10L/min.



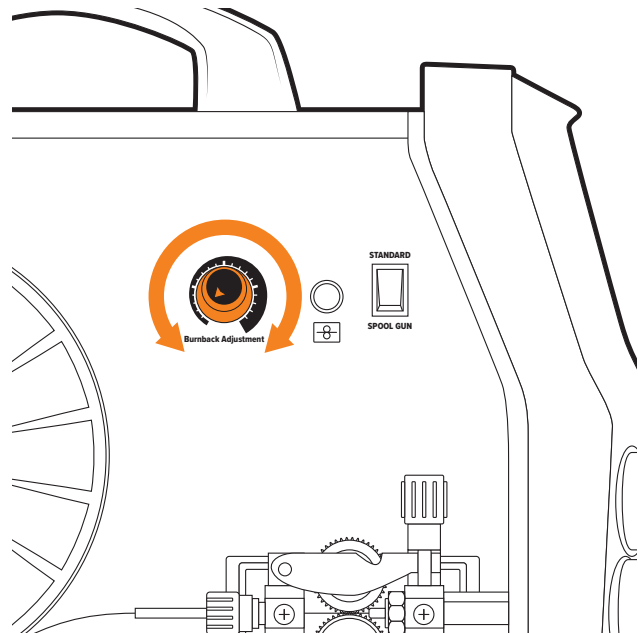
22 Connect gas hose to the gas inlet on the rear of the machine.



23 Adjust voltage and wire speed according to your material and thickness.

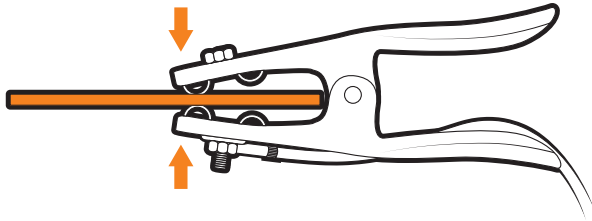


24 Adjust the burn back control to prevent the wire sticking in the weld pool. Burn back control is located above the wire feed motor.

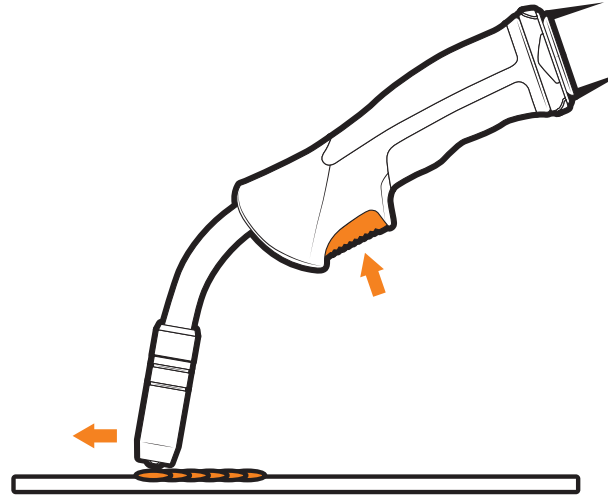


SETUP FOR MIG (GAS-SHIELDED)

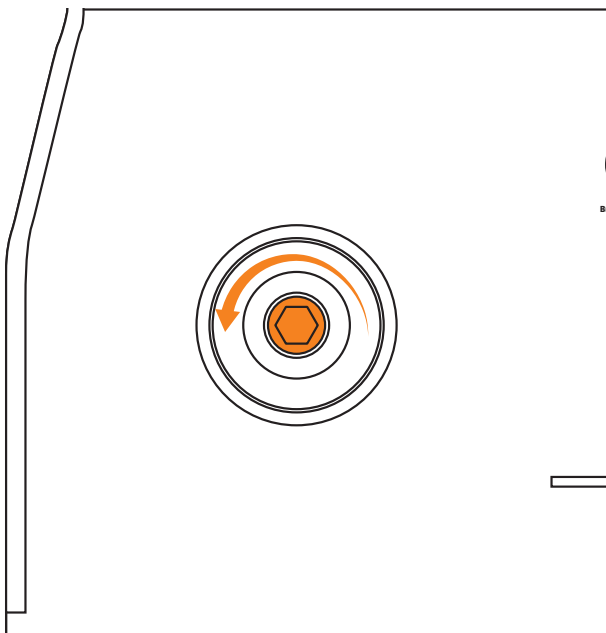
25 Connect earth clamp to your workpiece.



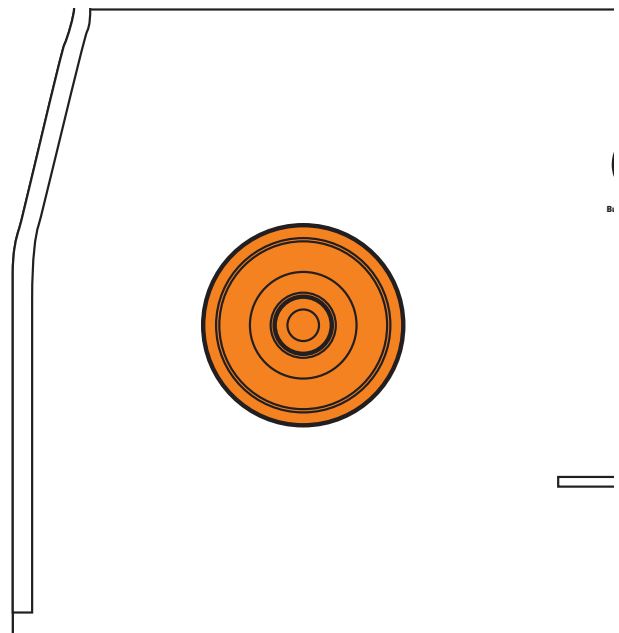
26 Line up the torch with your workpiece, then simply pull the trigger to initiate the weld. For gas-shielded MIG, the push method is recommended for optimum weld quality. Release trigger to end the weld.



27 **For 1kg spool:** After removing spool holder nut, unscrew the 1kg spool bolt located inside the spool holder housing.

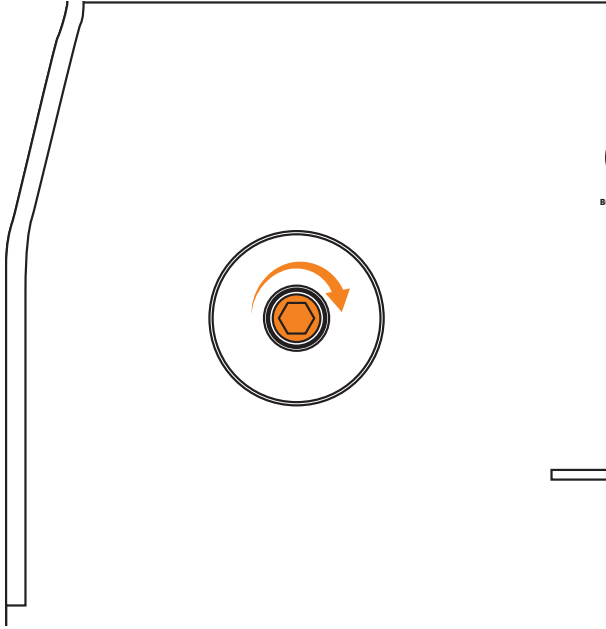


28 **For 1kg spool:** Remove spool holder housing and spring. Place 1kg spool housing inside the square hole where the spool housing is removed from. The 1kg housing is found on the inside of the main spool holder housing.



SETUP FOR MIG (GAS-SHIELDED)

- 29** **For 1kg spool:** Place 1kg spool over 1kg spool housing, then tighten and secure with 1kg spool bolt and nut.



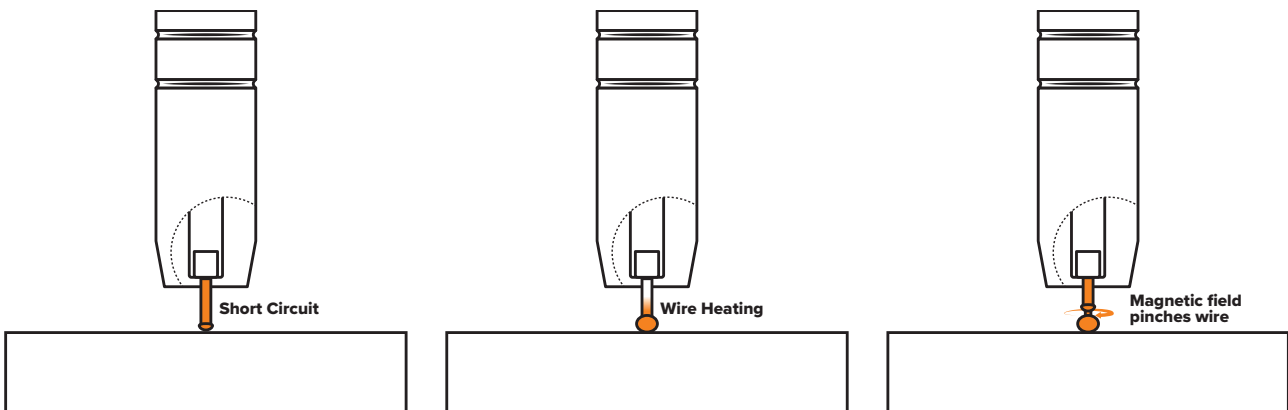
MIG (Metal Inert Gas) Welding

MIG (metal inert gas) welding also known as GMAW (gas metal arc welding) or MAG (metal active gas welding), is a semi-automatic or automatic arc welding process in which a continuous and consumable wire electrode and a shielding gas are fed through a welding gun. A constant voltage, direct current power source is most commonly used with MIG welding.

There are four primary methods of metal transfer in MIG welding, called short circuit (also known as dip transfer) globular transfer, spray transfer and pulsed-spray, each of which has distinct properties and corresponding advantages and limitations. To perform MIG welding, the necessary equipment is a welding gun, a wire feed unit, a welding power supply, an electrode wire, and a shielding gas supply. Short circuit transfer is the most commonly used method whereby the wire electrode is fed continuously down the welding torch through to and exiting the contact tip. The wire touches the workpiece and causes a short circuit the wire heats up and begins to form a molten bead, the bead separates from the end of the wire and forms a droplet that is transferred into the weld pool. This process is repeated about 100 times per second, making the arc appear constant to the human eye.

Short Circuit Transfer

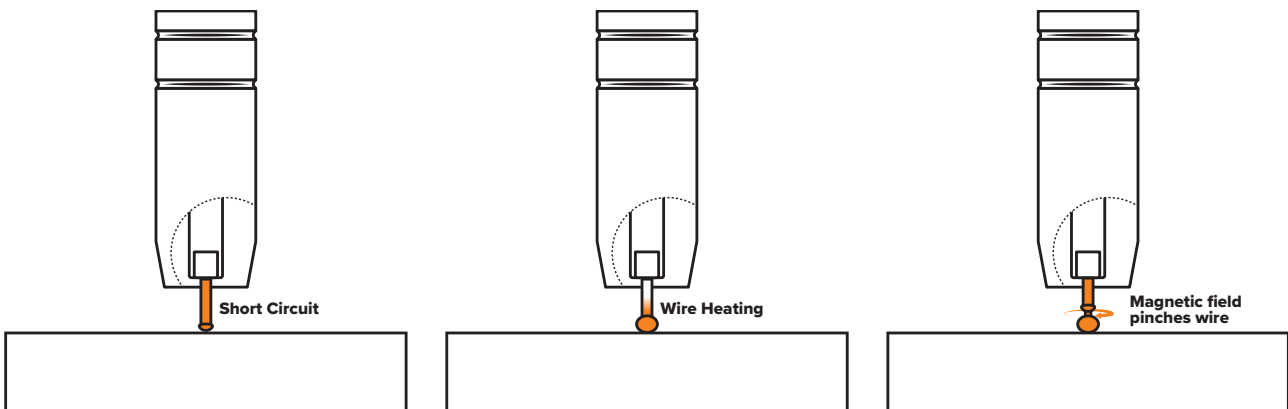
Short circuit transfer is the most commonly used method whereby the wire electrode is fed continuously down the welding torch through to and exiting the contact tip. The wire touches the workpiece and causes a short circuit the wire heats up and begins to form a molten bead, the bead separates from the end of the wire and forms a droplet that is transferred into the weld pool. This process is repeated about 100 times per second, making the arc appear constant to the human eye.



The wire approaches the work piece and touches the work creating a short circuit between the wire and the base metal, because there is no space between the wire and the base metal there is no arc and current flows through the wire.

The wire cannot support all the current flow, resistance builds up and the wire becomes hot and weak and begins to melt.

The current flow creates a magnetic field that begins to pinch the melting wire forming it into droplet.



The pinch causes the forming droplet to separate and fall towards the now creating weld pool.

An arc is created at the separation of the droplet and the heat and force of the arc flattens out the droplet into the weld pool. The heat of the arc melts the end of the wire slightly as it feeds towards the base metal.

The wire feed speed overcomes the heat of the arc and the wire again approaches the work to short circuit and repeat the cycle.

Basic MIG Welding

Good weld quality and weld profile depend on gun angle, the direction of travel, electrode extension (stick out), travel speed, the thickness of base metal, wire feed speed (amperage) and arc voltage. To follow are some basic guides to assist with your setup.

Gun Position - Travel Direction, Work Angle

Gun position or technique usually refers to how the wire is directed at the base metal, the angle and travel direction chosen. Travel speed and work angle will determine the characteristic of the weld bead profile and degree of weld penetration.

Push Technique

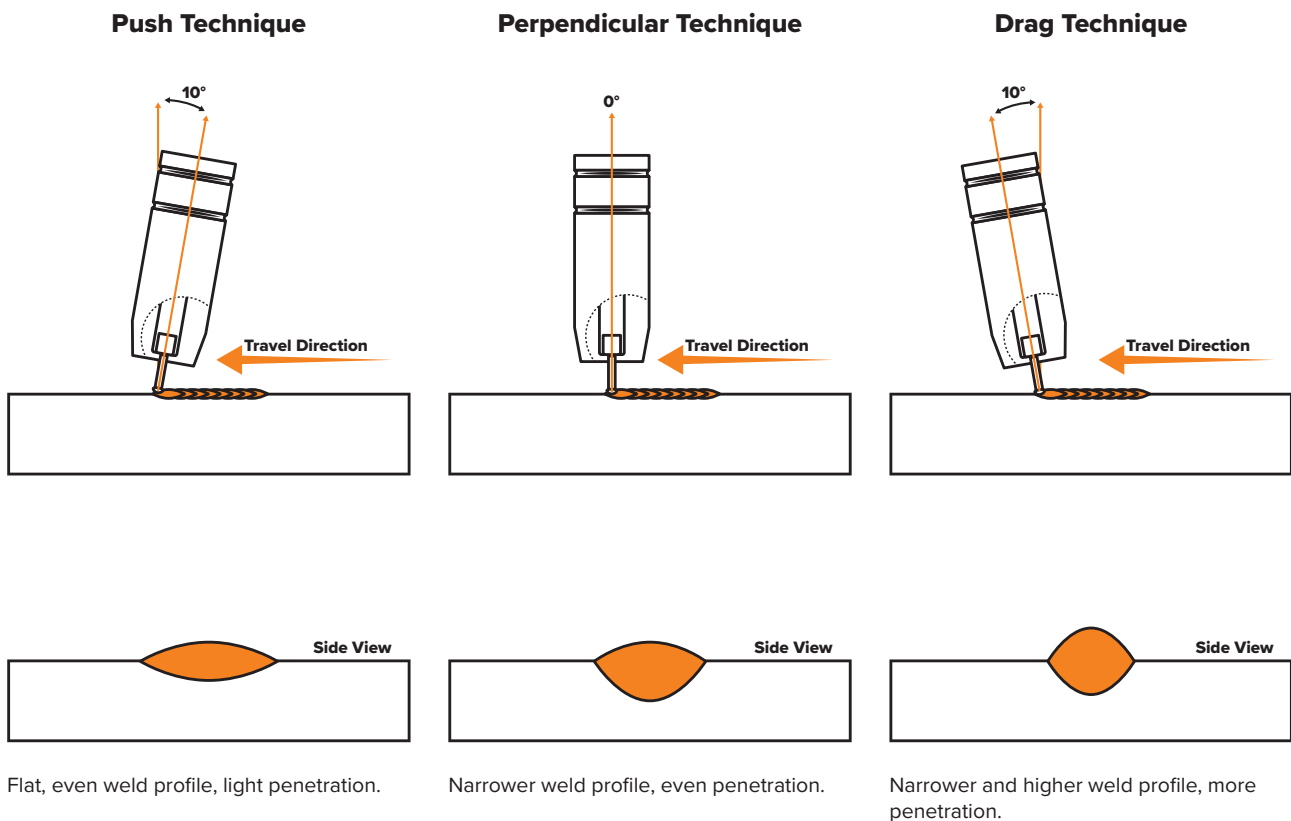
The wire is located at the leading edge of the weld pool and pushed towards the un-melted work surface. This technique offers a better view of the weld joint and direction of the wire into the weld joint. Push technique directs the heat away from the weld puddle, allowing faster travel speeds providing a flatter weld profile with light penetration - useful for welding thin materials. The welds are wider and flatter, allowing for minimal clean up / grinding time.

Perpendicular Technique

The wire is fed directly into the weld. This technique is used primarily for automated situations or when conditions make it necessary. The weld profile is generally higher, and deeper penetration is achieved.

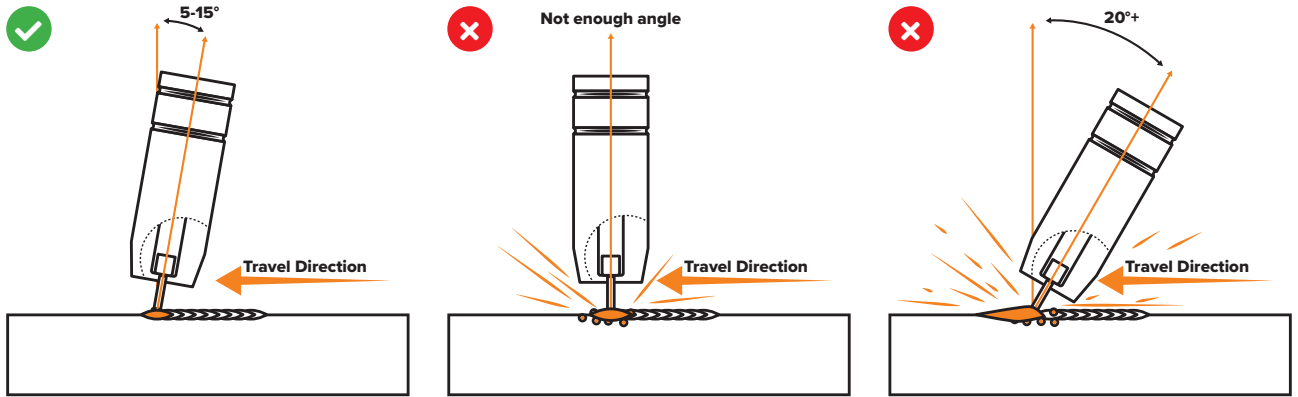
Drag Technique

The gun and wire are dragged away from the weld bead. The arc and heat are concentrated on the weld pool. The base metal receives more heat, deeper melting, more penetration and the weld profile is higher with more build-up.



Travel Angle

Travel angle is the right to left, relative to the direction of welding. A travel angle of 5°- 15° is ideal and produces the right level of control over the weld pool. A travel angle higher than 20° will give an unstable arc condition with poor weld metal transfer, less penetration, high levels of spatter, weak gas shield and poor quality finished weld.



Good level of control over the weld pool, even flat weld.

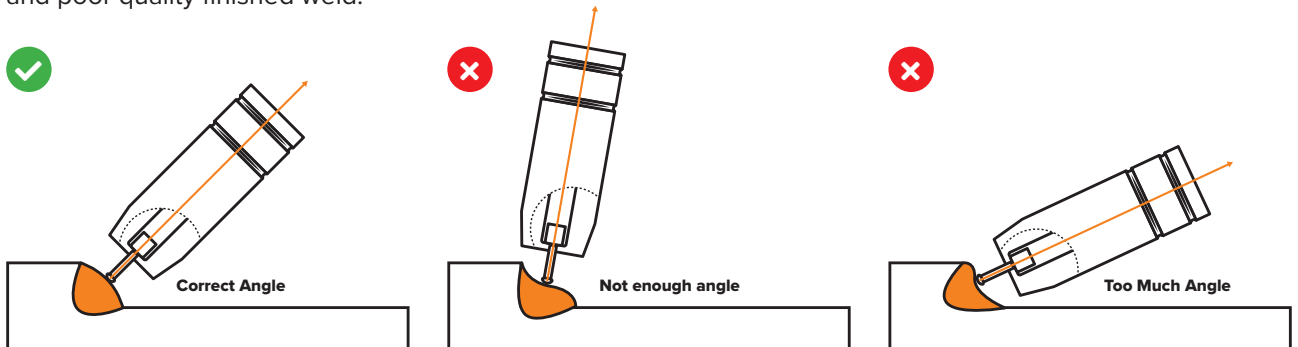
Less control over the weld pool, more spatter.

Poor control, unstable arc, less penetration, lots of spatter.

Angle to Work

The work angle is the forward back angle of the gun relative to the workpiece.

The correct work angle provides good bead shape, prevents undercut, uneven penetration, weak gas shield and poor quality finished weld.



Good level of control over the weld pool, even flat weld.

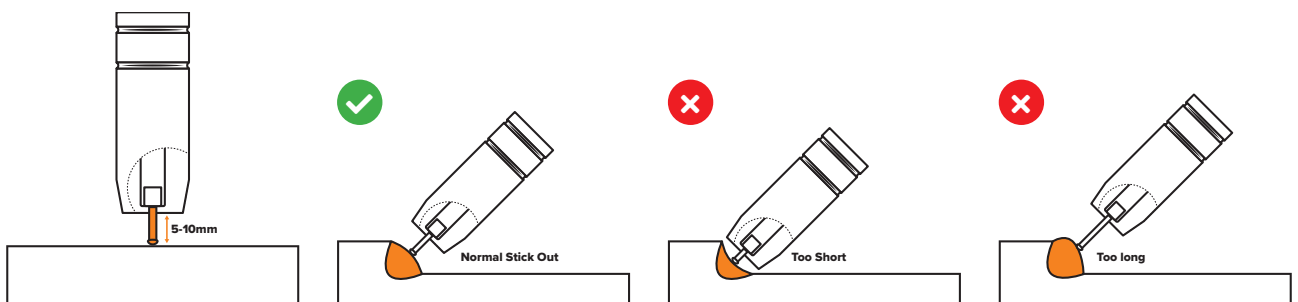
Less control over the weld pool, more spatter.

Poor control, unstable arc, less penetration, lots of spatter.

Stick Out

Stick out is the length of the unmelted wire protruding from the end of the contact tip.

A constant even stick out of 5-10mm will produce a stable arc, and an even current flow providing good penetration and even fusion. Too short stick out will cause an unstable weld pool, produce spatter and overheat the contact tip. Too long stick out will cause an unstable arc, lack of penetration, lack of fusion, and increase spatter.



Even arc, good penetration even fusion, good finish.

Unstable arc, spatter, over heat contact tip.

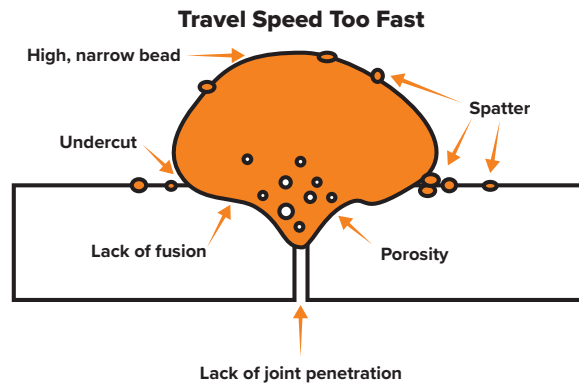
Unstable arc, spatter, poor penetration and fusion.

Travel Speed

Travel speed is the rate that the gun is moved along the weld joint and is usually measured in mm per minute. Travel speeds can vary depending on conditions and the welder's skill and is limited to the welder's ability to control the weld pool. Push technique allows faster travel speeds than Drag technique. The gas flow must also correspond with the travel speed, increasing with faster travel speed and decreasing at a slower speed. Travel speed needs to match the amperage and will decrease as the material thickness and amperage increase.

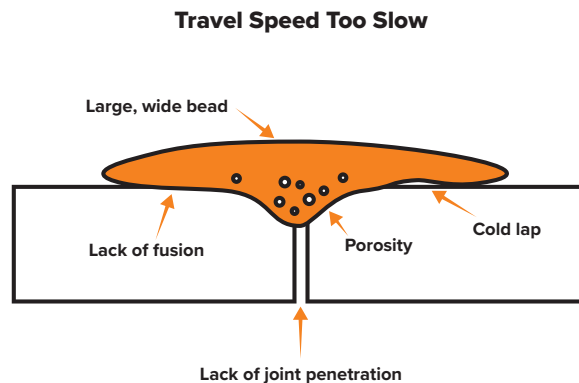
Travel Speed Too Fast

A too fast travel speed produces too little heat per mm of travel resulting in less penetration and reduced weld fusion, the weld bead solidifies very quickly trapping gases inside the weld metal causing porosity. Undercutting of the base metal can also occur, and an unfilled groove in the base metal is created when the travel speed is too fast to allow molten metal to flow into the weld crater created by the arc heat.



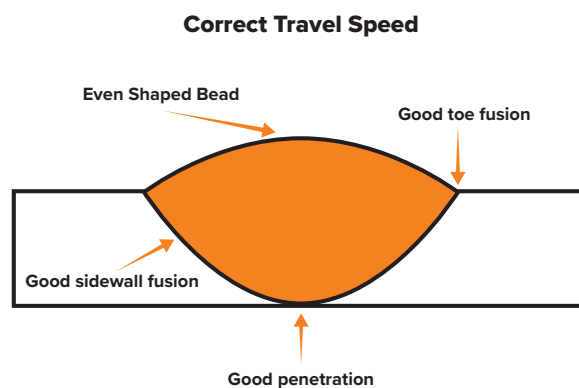
Travel Speed Too Slow

A too slow travel speed produces a large weld with a lack of penetration and fusion. The energy from the arc dwells on top of the weld pool rather than penetrating the base metal. This produces a wider weld bead with more deposited weld metal per mm than is required resulting in a weld deposit of poor quality.



Correct Travel Speed

The correct travel speed keeps the arc at the leading edge of the weld pool allowing the base metal to melt sufficiently to create good penetration, fusion and wetting out of the weld pool producing a weld deposit of good quality.



MIG WELDING GUIDE

Wire types and sizes

Use the correct wire type for the base metal being welded. Use stainless steel wire for stainless steel, aluminium wires for aluminium and steel wires for steel.

Use a smaller diameter wire for thin base metals. For thicker materials use a larger wire diameter and larger machine, check the recommended welding capability of your machine.

As a guide, refer to the “Welding Wire Thickness Chart” below.

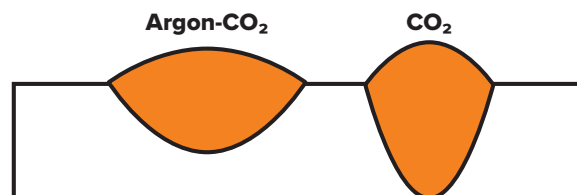
Material Type	Wire Type	Wire Size	Drive Roller	Polarity	Shielding Gas	Gas Flow Rate	Material Thickness	1mm	2mm	3mm	4mm	6mm	8mm	
Steel	ER70S-6	0.8mm	V Groove	DCEP+	ArCO ²	8-12L/min	Voltage (V)	15	18	20	21	23	23	
							Wire Speed (m/min)	5	7.5	8.5	9	12	13	
	ER70S-6	0.9mm	V Groove	DCEP+	ArCO ²	8-12L/min	Voltage (V)	/	18	18.5	19	22	23	
							Wire Speed (m/min)	/	6	7	7.5	11	13	
	E71T-11	0.8mm	F Groove (Knurled)	DCEN-	/	/	/	Voltage (V)	14	17	21	22	23	/
								Wire Speed (m/min)	3.5	5.5	8.5	9	11	/
E71T-11	0.9mm	F Groove (Knurled)	DCEN-	/	/	/	Voltage (V)	15	18	19	20	22	23	
							Wire Speed (m/min)	4	5	5.5	6	8	9	
Stainless Steel	316LSi	0.8mm	V Groove	DCEP+	ArCO ²	8-12L/min	Voltage (V)	12	13	14.5	16	17	19	
							Wire Speed (m/min)	7	8	9	10	11	15	
	316LSi	0.9mm	V Groove	DCEP+	ArCO ²	8-12L/min	Voltage (V)	/	13	14.5	16	18	20	
							Wire Speed (m/min)	/	7	8	9	10	14	
Aluminium	5356	1.0mm	U Groove	DCEP+	Ar	8-12L/min	Voltage (V)	/	11	12	13	17	18	
							Wire Speed (m/min)	/	9	10	11	14	16	

Gas selection

The purpose of the gas in the MIG process is to protect/shield the wire, the arc and the molten weld metal from the atmosphere. Most metals when heated to a molten state will react with the air in the atmosphere, without the protection of the shielding gas the weld produced would contain defects like porosity, lack of fusion and slag inclusions. Additionally, some of the gas becomes ionised (electrically charged) and helps the current flow smoothly.

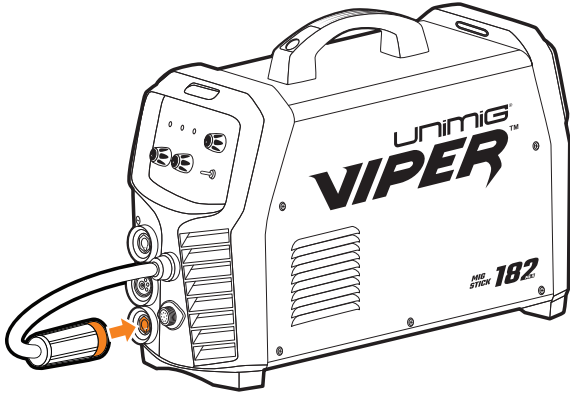
- The correct gas flow is also critical in protecting the welding zone from the atmosphere.
- Too low flow will give inadequate coverage and result in weld defects and unstable arc conditions.
- Too high flow can cause air to be drawn into the gas column and contaminate the weld zone.

Use the correct shielding gas. Co₂ is suitable for steel and offers good penetration characteristics; the weld profile is narrower and slightly more raised than the weld profile obtained from Argon Co₂ mixed gas. Argon Co₂ mix gas offers better weldability for thin metals and has a wider range of setting tolerance on the machine. Argon 80% Co₂ 20% is a good all-round mix suitable for most applications.

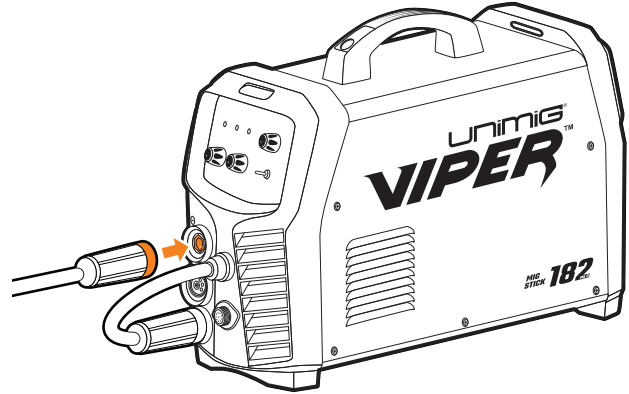


SETUP FOR SPOOL GUN

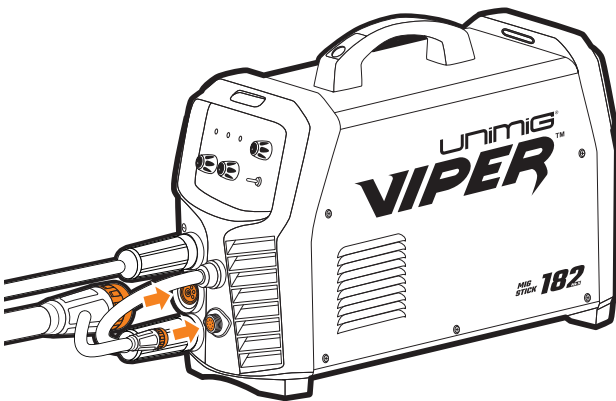
- 1 Connect the polarity cable to the **positive (+)** dinse connection, twist to lock in place.



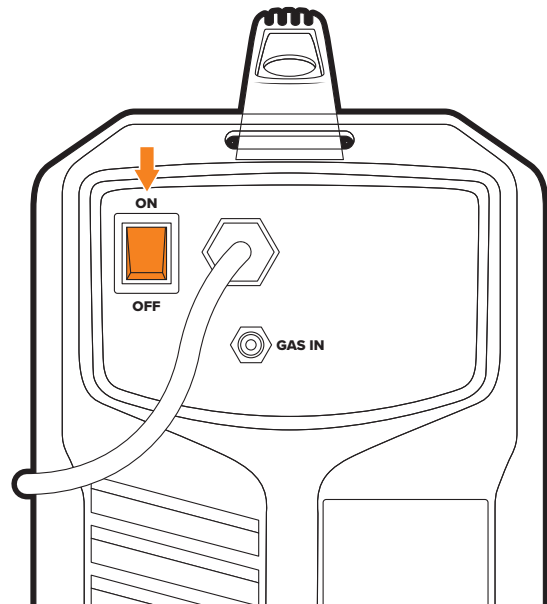
- 2 Connect the earth clamp to the **negative (-)** dinse connection, twist to lock in place.



- 3 Connect the Spool Gun to the Euro connection, and twist end to secure in place. Inset the spool gun control cable into the 9 pin socket.

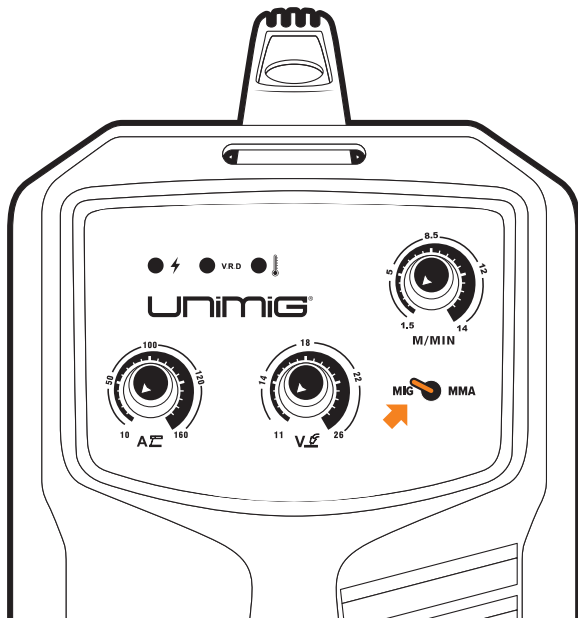


- 4 Connect the plug into a 10 AMP socket, then switch the machine ON.

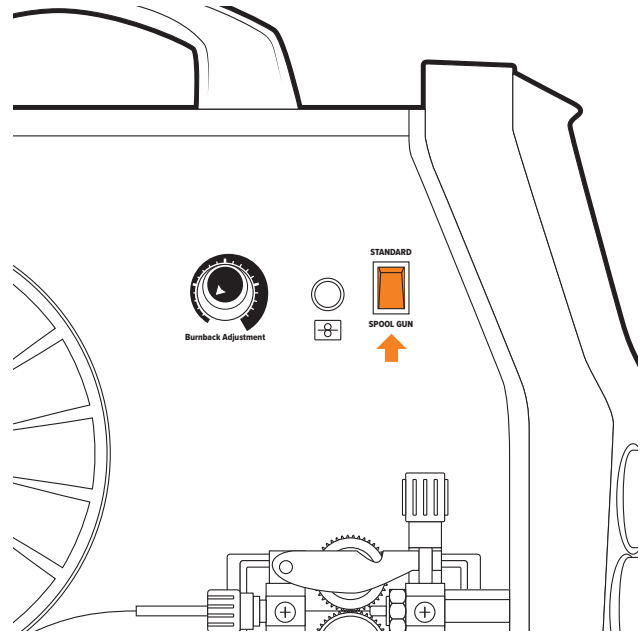


SETUP FOR SPOOL GUN

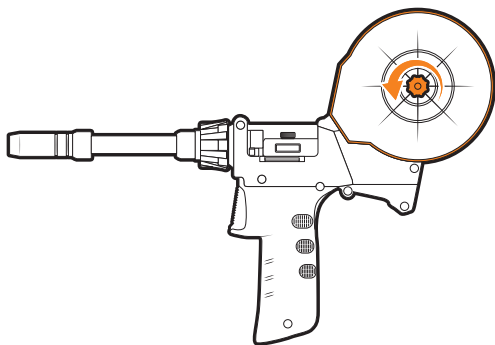
- 5 Select **MIG** on the MIG/MMA selector.



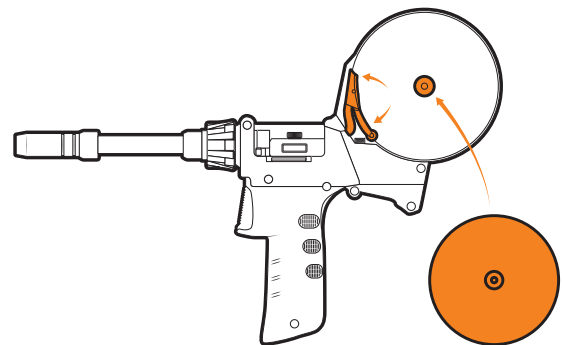
- 6 Select **Spool Gun** on the Standard/Spool Gun selector.



- 7 Unscrew spool holder.

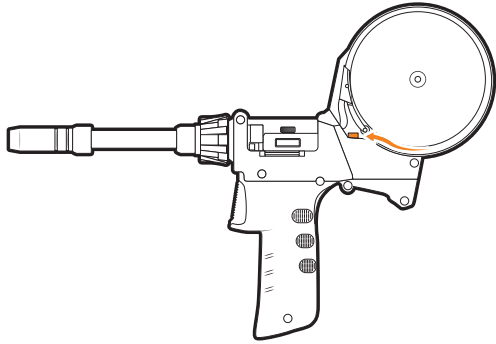


- 8 Push back the spool guides, and place wire spool onto the spool nut.

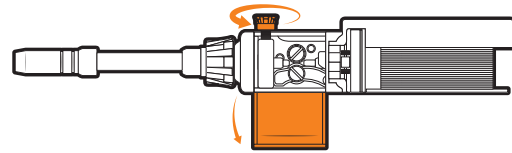


SETUP FOR SPOOL GUN

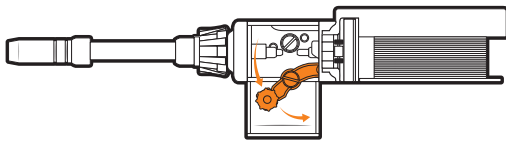
9 Feed wire through the inlet guide tube.



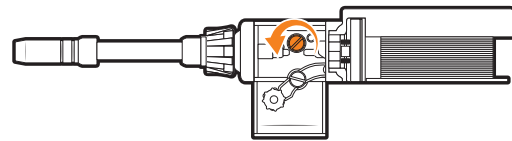
10 Open cover, and loosen roller lock.



11 Open the wire drive.

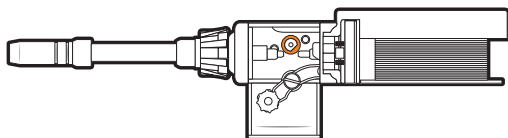


12 Unscrew roller nut.

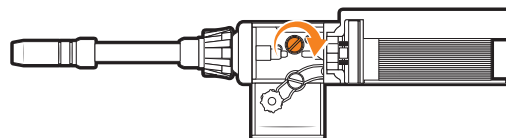


SETUP FOR SPOOL GUN

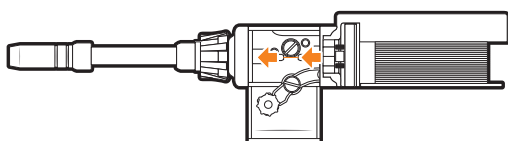
- 13** Ensure you have the correct roller for the wire size you are using. If not, replace with correct size.



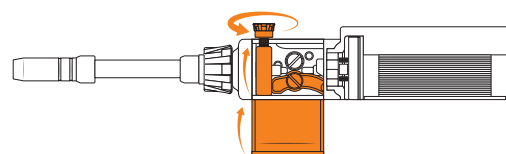
- 14** Replace roller nut and tighten.



- 15** Feed wire through roller, and through the outlet guide tube.

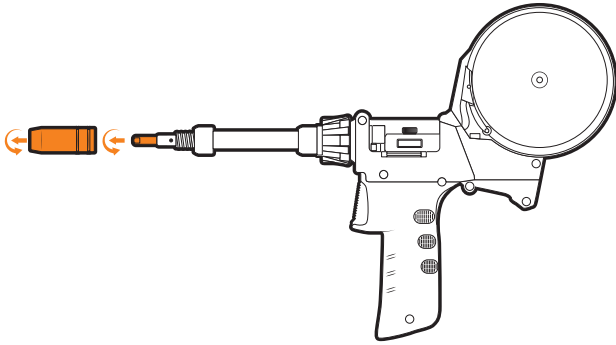


- 16** Close wire drive and tighten roller tension knob.

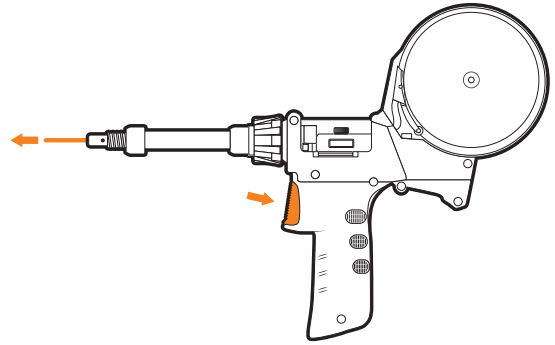


SETUP FOR SPOOL GUN

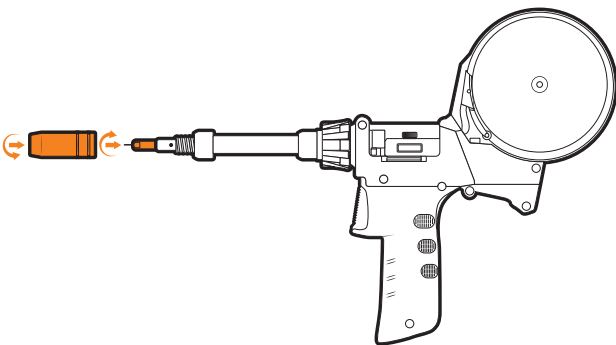
17 Remove front end consumables.



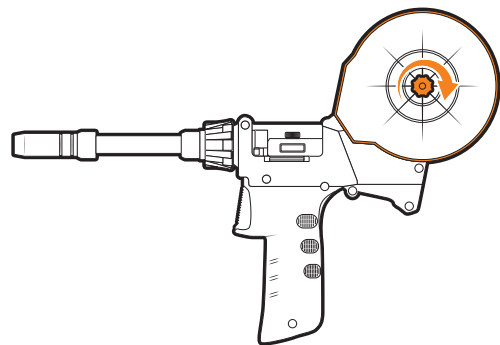
18 Push trigger to feed wire out the torch nozzle.



19 Replace front end consumables.

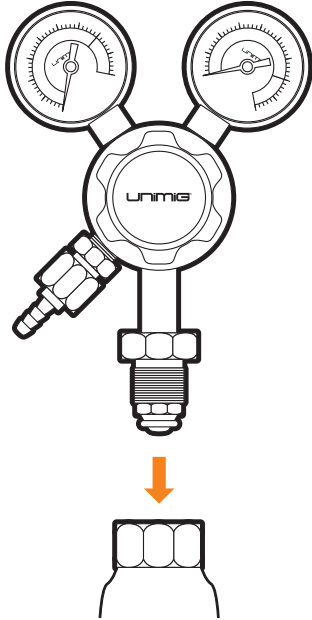


20 Replace spool cover and tighten.

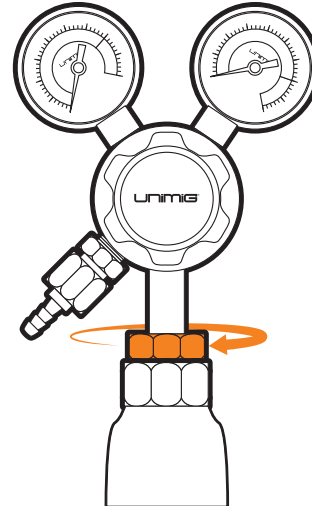


SETUP FOR SPOOL GUN

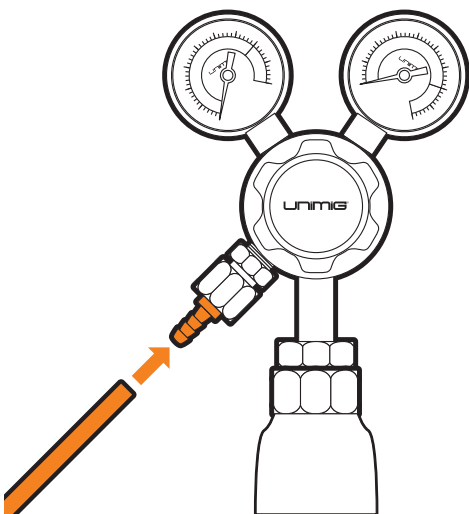
21 Place twin gauge argon regulator into your gas outlet.



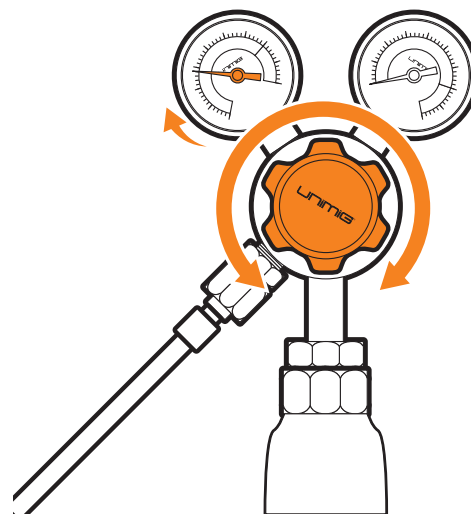
22 Tighten securely with wrench.



23 Connect gas hose to the regulator outlet, and crimp in place.

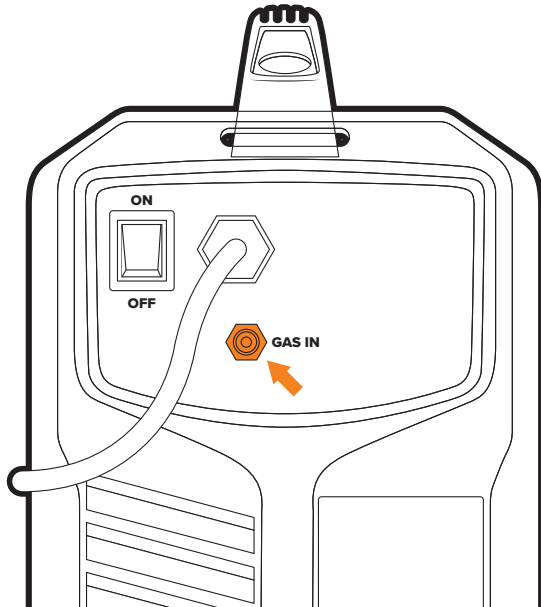


24 Adjust gas flow to 8-10L/min.

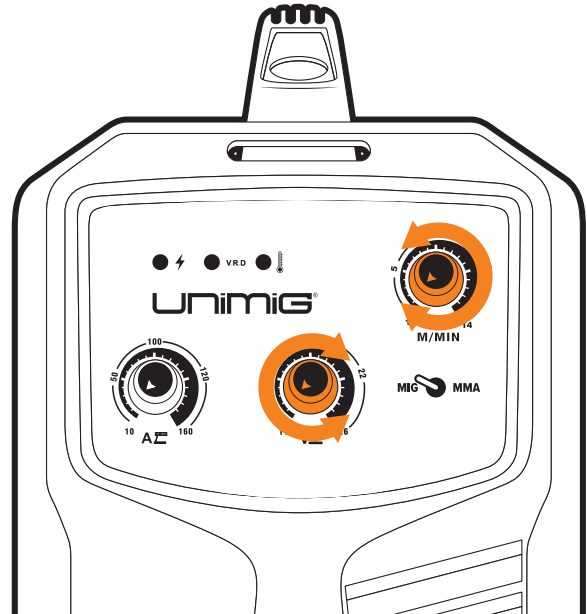


SETUP FOR SPOOL GUN

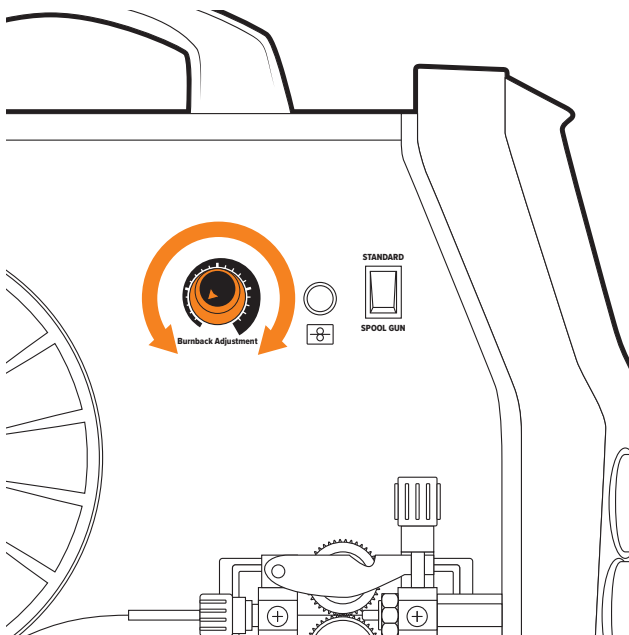
- 25** Connect gas hose to the gas inlet on the rear of the machine.



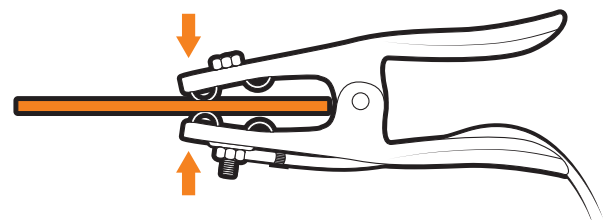
- 26** Adjust voltage and wire speed according to your material and thickness.



- 27** Adjust the burn back control to prevent the wire sticking in the weld pool. Burn back control is located above the wire feed motor.

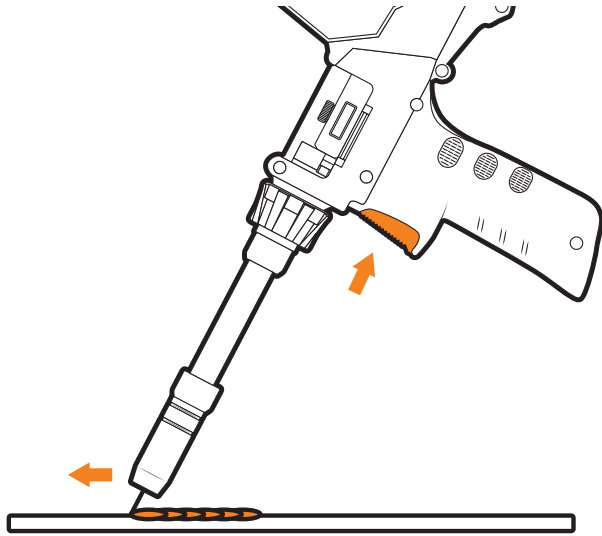


- 28** Connect earth clamp to your workpiece.



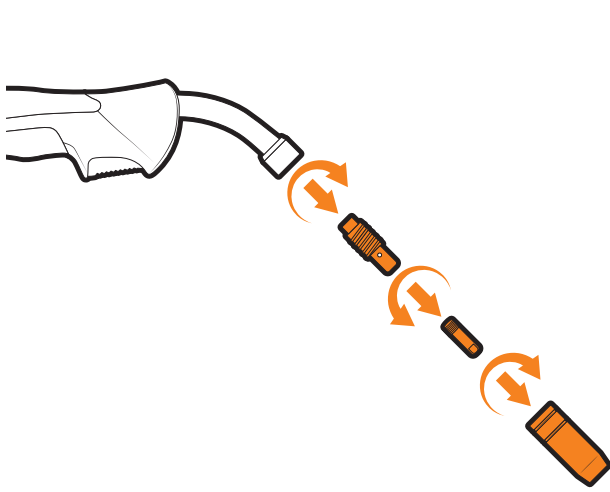
SETUP FOR SPOOL GUN

- 29** Line up the torch with your workpiece, then simply pull the trigger to initiate the weld. Release trigger to end the weld.

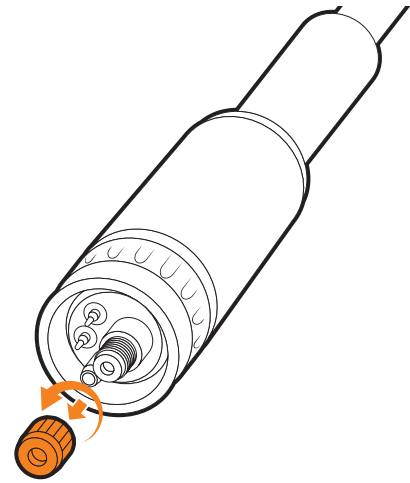


CHANGING THE MIG TORCH LINER

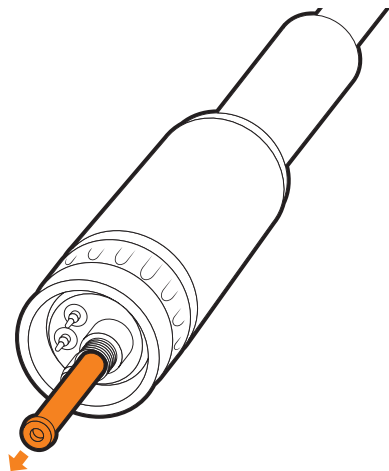
1 Remove MIG torch front end parts.



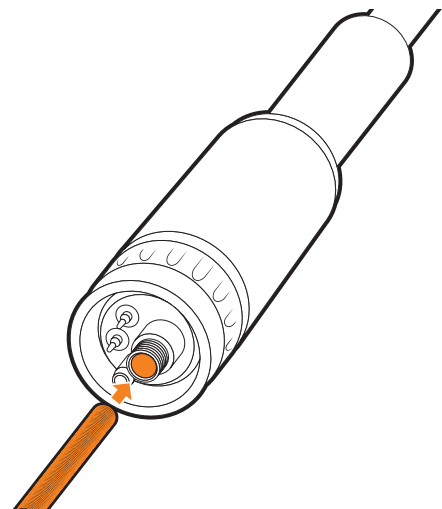
2 Remove the liner retaining nut.



3 Carefully pull out and completely remove the existing liner. Ensure MIG torch is completely unravelled until setup is complete.

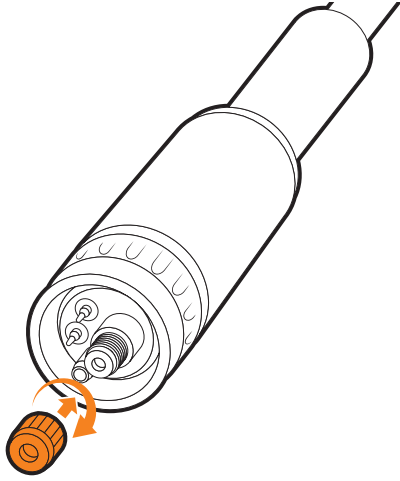


4 Carefully feed in the new liner down the torch lead all the way to exit the torch neck.

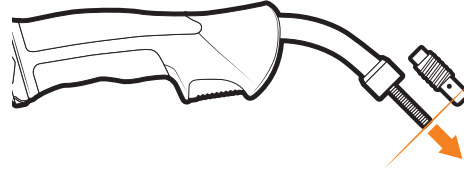


CHANGING THE MIG TORCH LINER

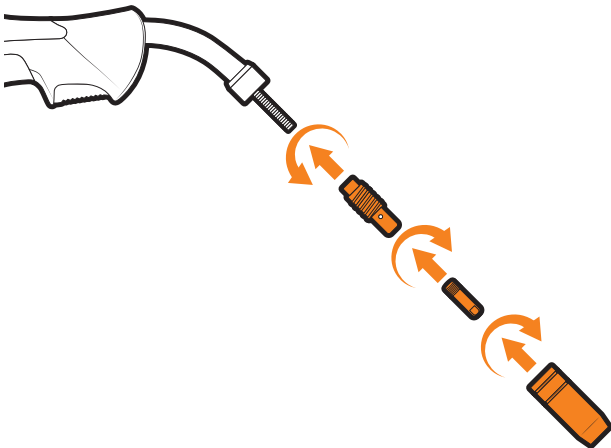
- 5 Fit the liner retaining nut and screw only 1/2 way down.



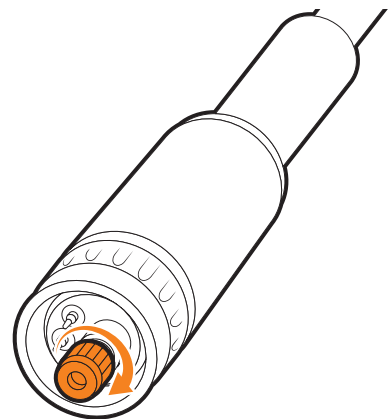
- 6 Snip the excess liner off, about the length of the where tip holder sits past the end of the torch neck.



- 7 Replace the front end parts

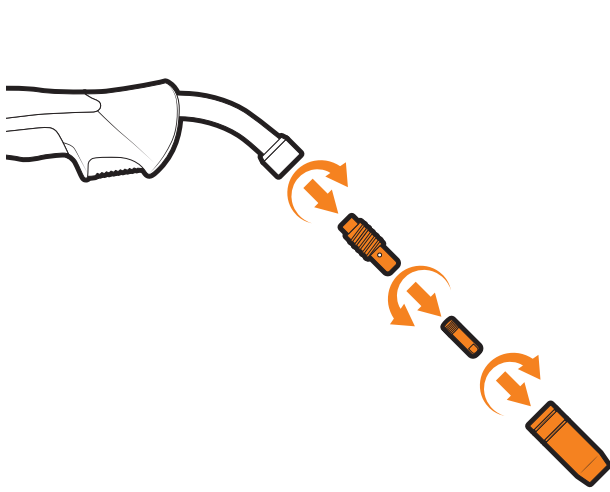


- 8 (9) Fully screw down the liner retaining nut and nip it up tight. This compresses the liner inside the torch cable assembly preventing it moving during use and ensures good wire feed.

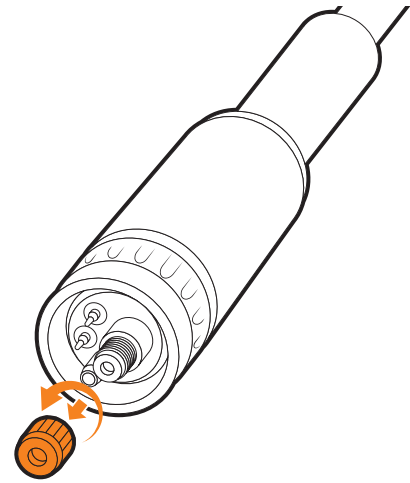


CHANGING THE MIG TORCH LINER (ALUMINIUM)

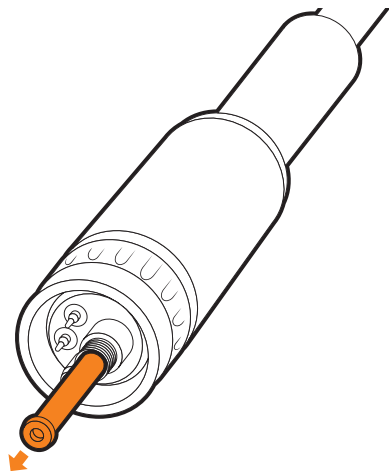
1 Remove MIG torch front end parts.



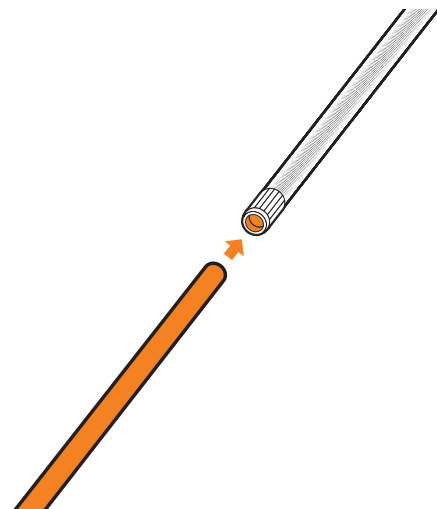
2 Remove the liner retaining nut.



3 Carefully pull out and completely remove the existing liner. Ensure MIG torch is completely unravelled until setup is complete.

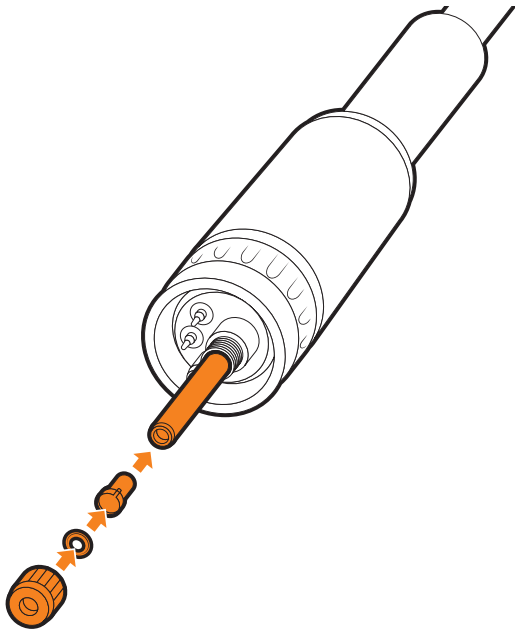


4 Fit the neck spring to the front end of the aluminium liner.



CHANGING THE MIG TORCH LINER (ALUMINIUM)

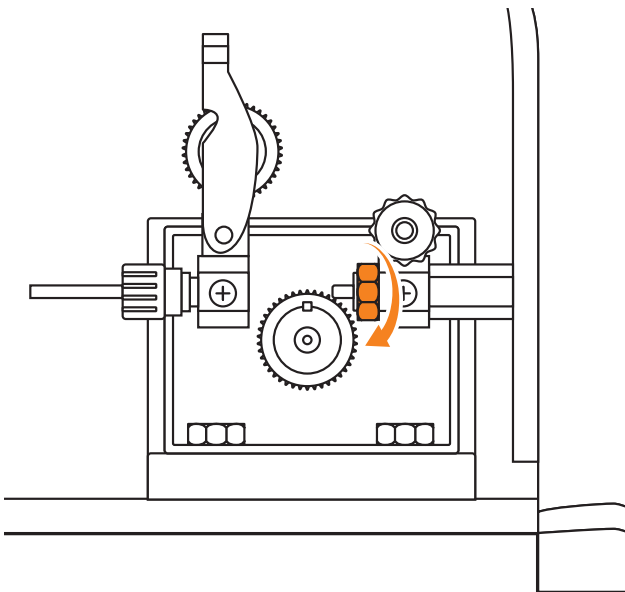
- 5 Feed liner and neck spring through the torch, then fit liner collet, liner O-ring and liner retaining nut.



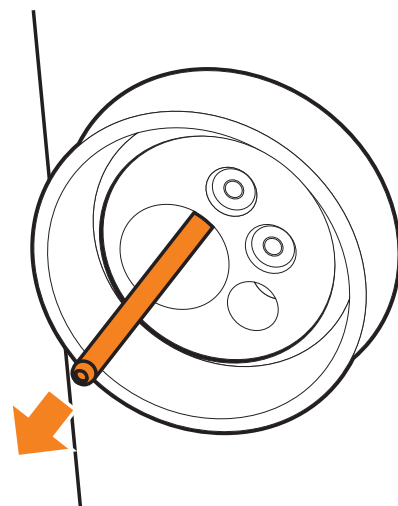
- 6 Push the liner firmly into the torch lead and tighten the liner retaining nut.



- 7 Loosen the inlet guide tube retaining screw.

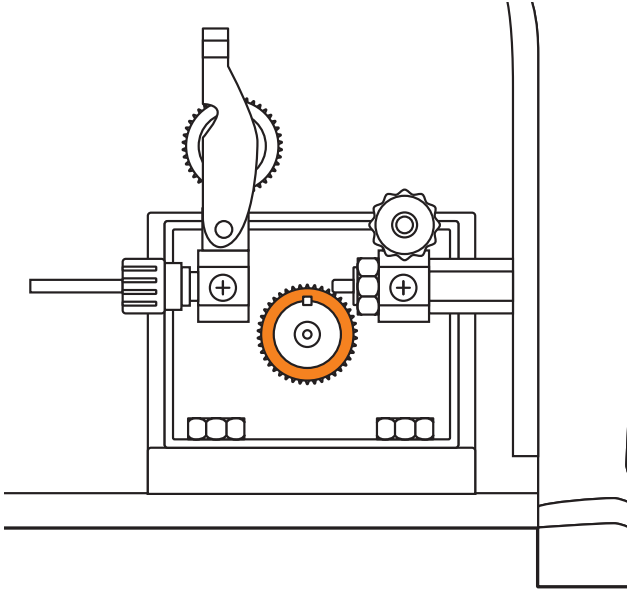


- 8 Remove the inlet guide tube using long nose pliers.

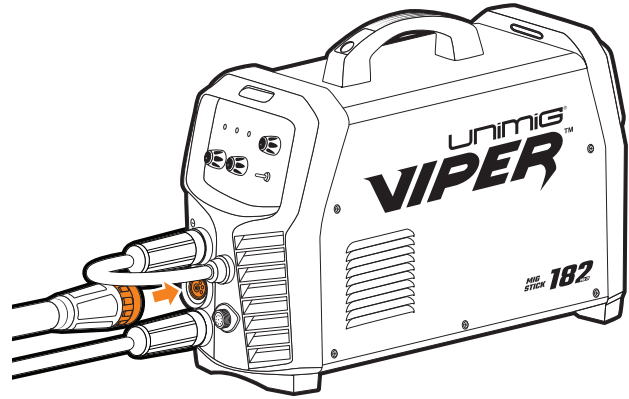


CHANGING THE MIG TORCH LINER (ALUMINIUM)

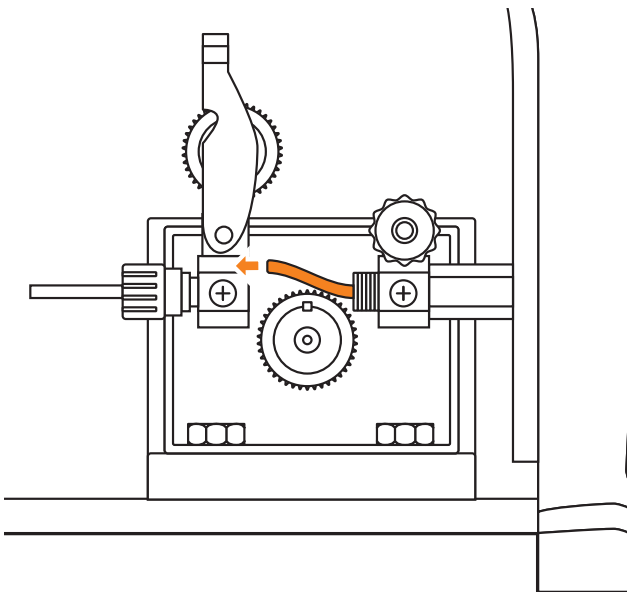
- 9** Install a U groove drive roller of the correct size for the diameter wire being used.



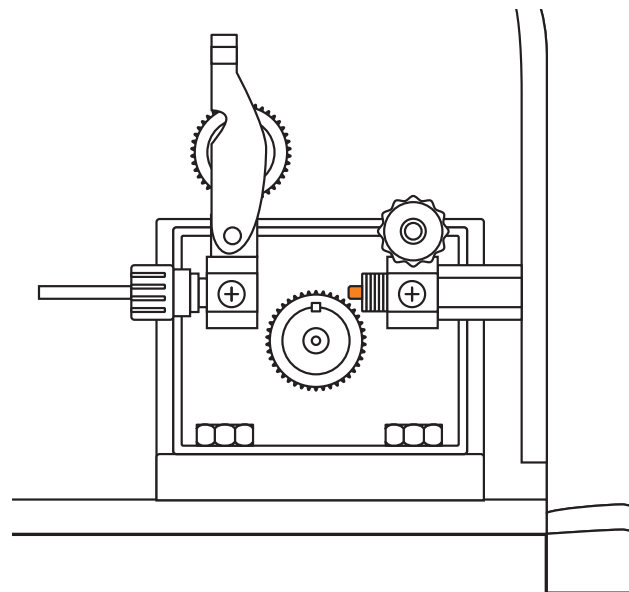
- 10** Feed liner through euro connection, and connect and tighten the torch.



- 11** Take the extended polyimide liner all the way up and over the drive roller.

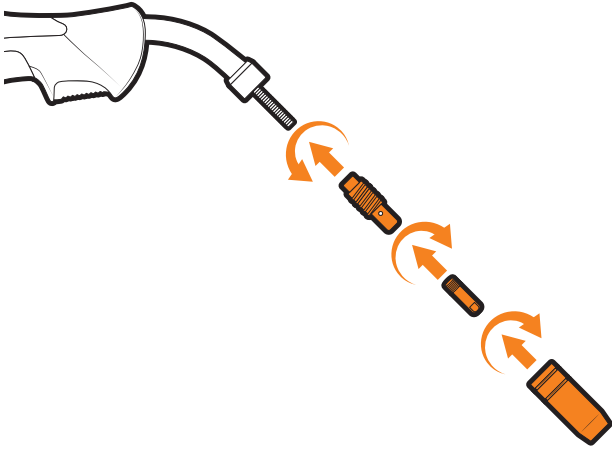


- 12** Cut the extended Polyimide liner with a sharp knife just in front of the drive roller.



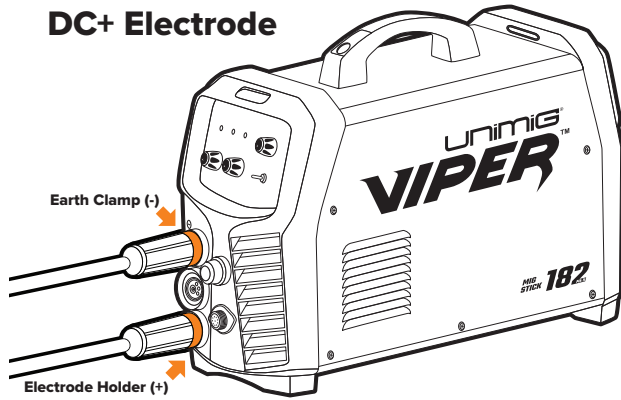
CHANGING THE MIG TORCH LINER (ALUMINIUM)

- 13 Replace the front end parts.

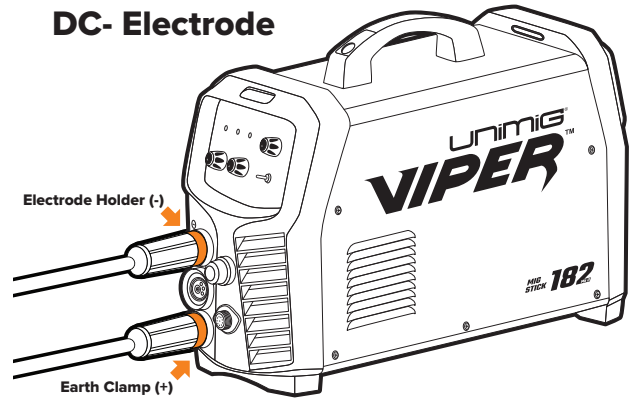


SETUP FOR STICK (MMA) WELDING

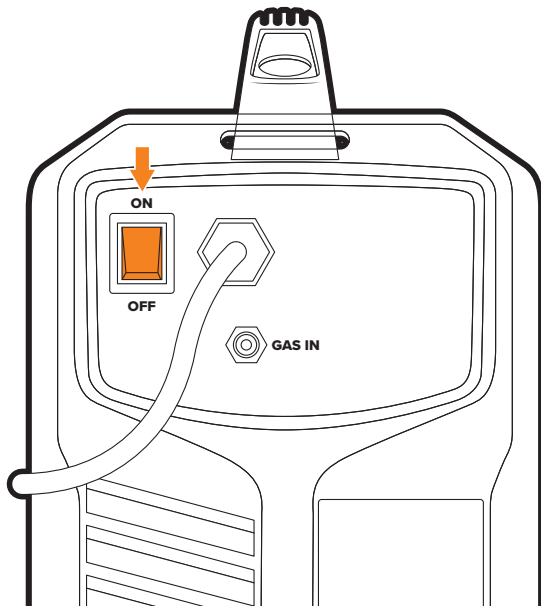
- 1 For DC+ electrodes, connect earth clamp to the **negative (-)** dinse connection, and electrode holder to the **positive (+)** dinse connection.



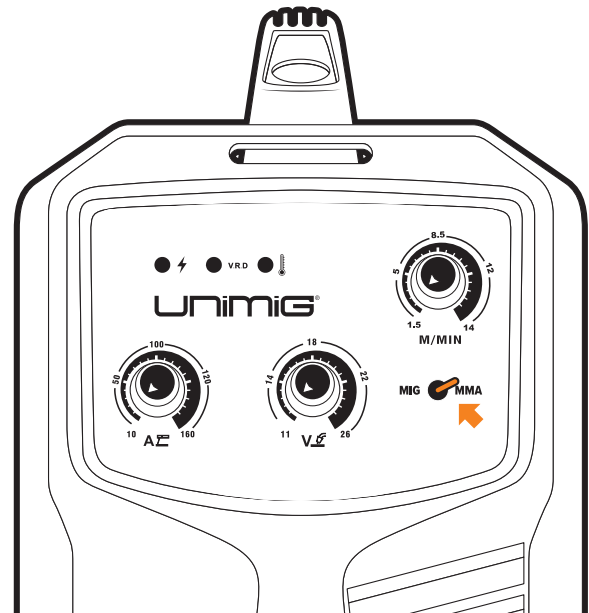
- 2 For DC- electrodes, connect earth clamp to the **positive (+)** dinse connection, and electrode holder to the **negative (-)** dinse connection.



- 3 Connect the plug into a 10 AMP socket, then switch the machine ON.

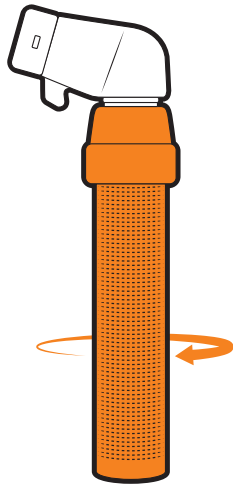


- 4 Select **MMA** from the MIG/MMA selector.

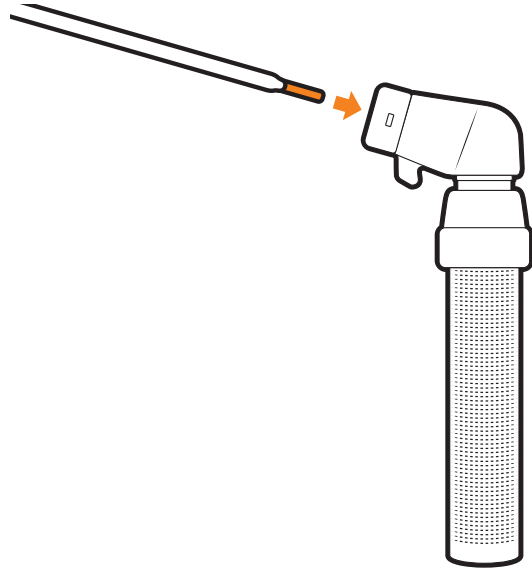


SETUP FOR STICK (MMA) WELDING

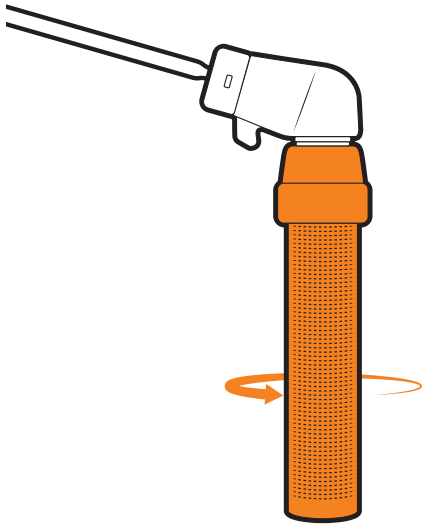
5 Twist electrode holder to loosen grip.



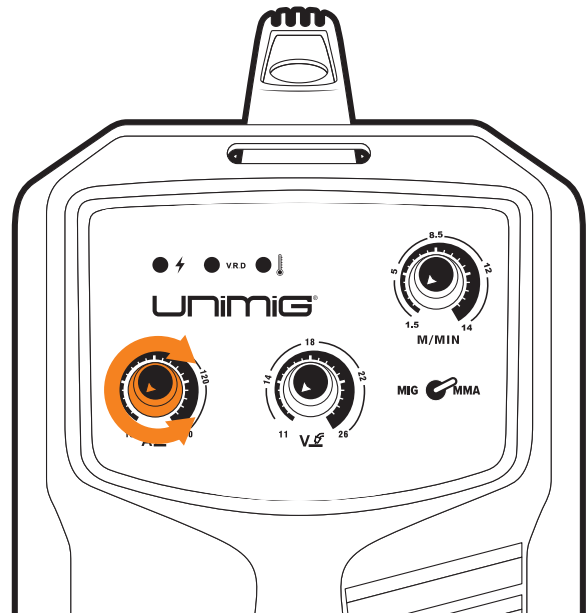
6 Place electrode into electrode holder.



7 Twist electrode holder to tighten and securely grip electrode.

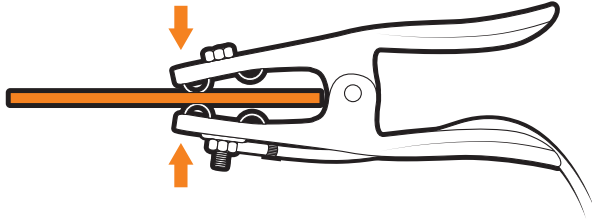


8 Adjust amperage to desired setting.

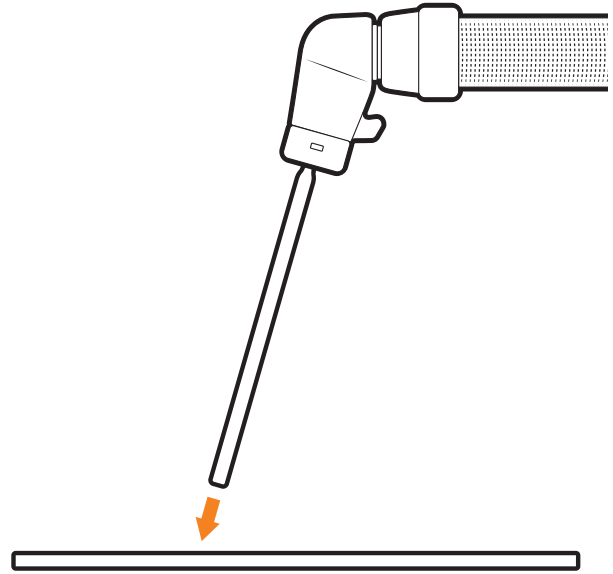


SETUP FOR STICK (MMA) WELDING

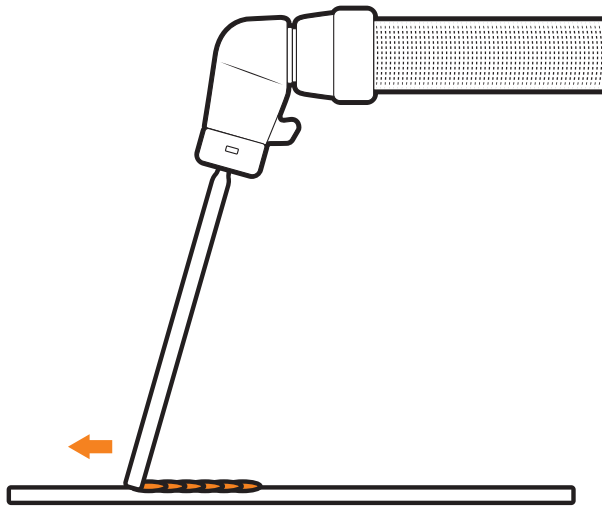
- 9 Connect earth clamp to your workpiece.



- 10 Strike electrode against workpiece to initiate arc.



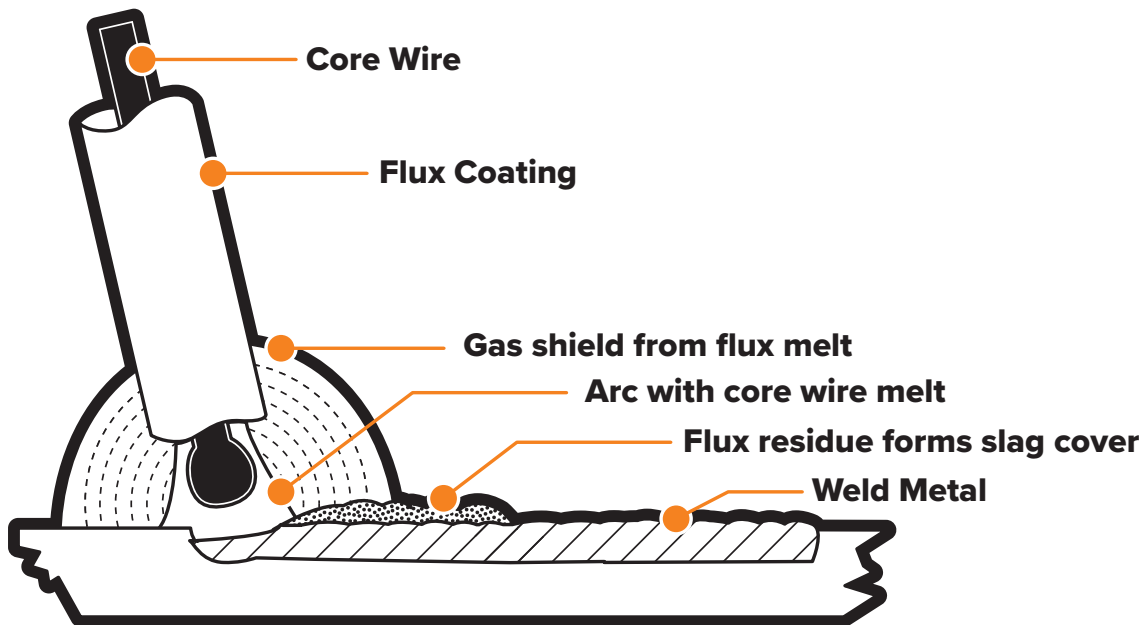
- 11 Drag along workpiece to weld. Pull the electrode away from the workpiece to finish weld.



MMA (STICK) WELDING GUIDE

STICK (MMA / Manual Metal Arc) Welding

One of the most common types of arc welding is manual metal arc welding (MMA) or MMA welding. An electric current is used to strike an arc between the base material and a consumable electrode rod or 'stick'. The electrode rod is made of a material that is compatible with the base material being welded and is covered with a flux that gives off gaseous vapours that serve as a shielding gas and providing a layer of slag, both of which protect the weld area from atmospheric contamination. The electrode core itself acts as filler material the residue from the flux that forms a slag covering over the weld metal must be chipped away after welding.



- The arc is initiated by momentarily touching the electrode to the base metal.
- The heat of the arc melts the surface of the base metal to form a molten pool at the end of the electrode.
- The melted electrode metal is transferred across the arc into the molten pool and becomes the deposited weld metal.
- The deposit is covered and protected by a slag which comes from the electrode coating.
- The arc and the immediate area are enveloped by an atmosphere of protective gas.

Manual metal arc (stick) electrodes have a solid metal wire core and a flux coating. These electrodes are identified by the wire diameter and by a series of letters and numbers. The letters and numbers identify the metal alloy and the intended use of the electrode.

The Metal Wire Core works as a conductor of the current that maintains the arc. The core wire melts and is deposited into the welding pool.

The covering on a shielded metal arc welding electrode is called Flux. The flux on the electrode performs many different functions.

These include:

- Producing a protective gas around the weld area
- Providing fluxing elements and de-oxidisers
- Creating a protective slag coating over the weld as it cools
- Establishing arc characteristics
- Adding alloying elements.

Covered electrodes serve many purposes in addition to adding filler metal to the molten pool. These additional functions are provided mainly by the covering on the electrode.

Electrode Selection

As a general rule, the selection of an electrode is straight forward, in that it is only a matter of selecting an electrode of similar composition to the parent metal. However, for some metals, there is a choice of several electrodes, each of which has particular properties to suit specific classes of work. It is recommended to consult your welding supplier for the correct selection of electrode.

The size of the electrode generally depends on the thickness of the section being welded, and the thicker the section, the larger the electrode required. The table gives the maximum size of electrodes that may be used for various thicknesses of section based on using a general-purpose type 6013 electrode.

Average Thickness of Material	Maximum Recommended Electrode Diameter
1.0 - 2.0mm	2.5mm
2.0 - 5.0mm	3.2mm
5.0 - 8.0mm	4.0mm
8.0 - > mm	5.0mm

Correct current selection for a particular job is an important factor in arc welding. With the current set too low, difficulty is experienced in striking and maintaining a stable arc. The electrode tends to MMA to work, penetration is reduced, and beads with a distinct rounded profile will be deposited. Too high current is accompanied by overheating of the electrode resulting undercut and burning through of the base metal and producing excessive spatter. Normal current for a particular job may be considered as the maximum, which can be used without burning through the work, over-heating the electrode or producing a rough spattered surface. The table shows current ranges generally recommended for a general-purpose type 6013 electrode.

Electrode Size (ø mm)	Current Range (Amps)
2.5mm	60 - 100
3.2mm	100 - 130
4.0mm	130 - 165
5.0mm	165 - 260

Arc Length

To strike the arc, the electrode should be gently scraped on the work until the arc is established. There is a simple rule for the proper arc length; it should be the shortest arc that gives a good surface to the weld. An arc too long reduces penetration, produces spatter and gives a rough surface finish to the weld. An excessively short arc will cause sticking of the electrode and result in poor quality welds. The general rule of thumb for down hand welding is to have an arc length no greater than the diameter of the core wire.

Electrode Angle

The angle that the electrode makes with the work is important to ensure a smooth, even transfer of metal. When welding in down hand, fillet, horizontal or overhead, the angle of the electrode is generally between 5 and 15 degrees towards the direction of travel. When vertical up welding, the angle of the electrode should be between 80 and 90 degrees to the workpiece.

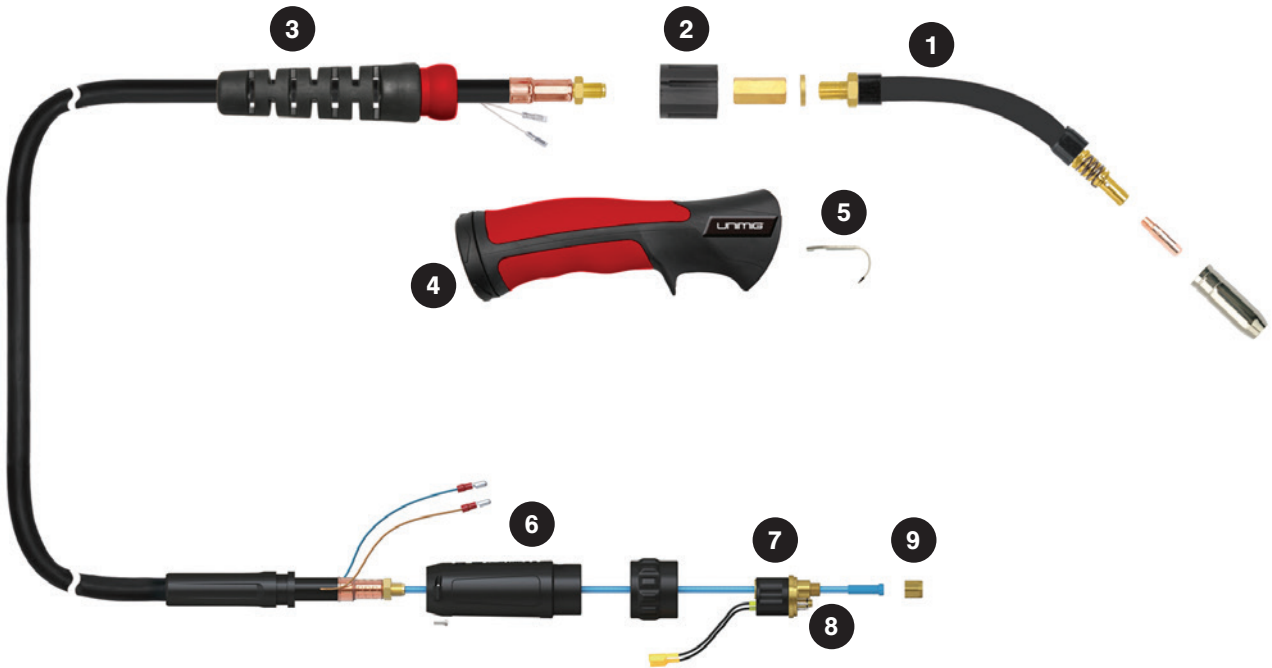
Travel Speed

The electrode should be moved along in the direction of the joint being welded at a speed that will give the size of run required. At the same time, the electrode is fed downwards to keep the correct arc length at all times. Excessive travel speeds lead to poor fusion, lack of penetration, etc., while too slow a rate of travel will frequently lead to arc instability, slag inclusions and poor mechanical properties.

Material and Joint Preparation

The material to be welded should be clean and free of any moisture, paint, oil, grease, mill scale, rust or any other material that will hinder the arc and contaminate the weld material. Joint preparation will depend on the method used include sawing, punching, shearing, machining, flame cutting and others. In all cases, edges should be clean and free of any contaminants. The chosen application will determine the type of joint.

SB15 BINZEL Style MIG Torch



Length	3m	4m	5m
SKU	SB15-3M	SB15-4M	SB15-5M

TORCH SPARES		
1	SNK15	Swan Neck Assembly
	SNKF15	Flexible Swan Neck
2	UG1515	Ergo Handle Location Body
3	UG8015	Handle Cable Support C/W Ball Joint
4	UG2514	Ergo Handle Kit C/W Lock Nut
5	UB2517	Hanger Hook
6	UB1518	Gun Plug Housing C/W Nut
7	UC1528	Hybrid Gun Plug Body C/W Spring Pins
8	UB1524	Gun Plug 'O' Ring
9	UB1525	Liner Nut

TECHNICAL DATA	
COOLING METHOD	Air Cooled
DUTY CYCLE - CO2	60% @ 180A
DUTY CYCLE - MIXED GAS	60% @ 150A
WIRE SIZE	0.6-1.0mm
LENGTHS (m)	3/4/5
STANDARD	EN60974-7

SB15 MIG Torch Consumables



SKU	Description	QTY
PCTH15	TIP HOLDER	2



SKU	Description	QTY
PGNS15	NOZZLE SPRING	2



SKU	Description	QTY
PCT0008-06	CONTACT TIPS - Steel 0.6mm	10
PCT0008-08	CONTACT TIPS - Steel 0.8mm	10
PCT0008-09	CONTACT TIPS - Steel 0.9mm	10
PCT0008-10	CONTACT TIPS - Steel 1.0mm	10
PCT0008-12	CONTACT TIPS - Steel 1.2mm	10
PCTAL0008-09	CONTACT TIPS - Aluminium 0.9mm	10
PCTAL0008-10	CONTACT TIPS - Aluminium 1.0mm	10
PCTAL0008-12	CONTACT TIPS - Aluminium 1.2mm	10



SKU	Description	QTY
PGN15CON	GAS NOZZLE - Conical	2
PGN15CYL	GAS NOZZLE - Cylindrical	2
PGN15SPOT	GAS NOZZLE - Spot	2
PGN15TAP	GAS NOZZLE - Tapered	2



SKU	Description	Wire Size
SLB3M	Blue Steel Liner 3 Metre	0.6 - 0.8mm
SLB4M	Blue Steel Liner 4 Metre	0.6 - 0.8mm
SLB5M	Blue Steel Liner 5 Metre	0.6 - 0.8mm
SLR3M	Red Steel Liner 3 Metre	0.9 - 1.2mm
SLR4M	Red Steel Liner 4 Metre	0.9 - 1.2mm
SLR5M	Red Steel Liner 5 Metre	0.9 - 1.2mm
TLB3M	Blue Aluminium Liner 3 Metre	0.6 - 0.8mm
TLB4M	Blue Aluminium Liner 4 Metre	0.6 - 0.8mm
TLR3M	Red Aluminium Liner 3 Metre	0.9 - 1.2mm
TLR4M	Red Aluminium Liner 4 Metre	0.9 - 1.2mm
NKSTL	Neck Spring for Aluminium	

MIG DRIVE ROLLERS

Drive Roller Selection

The importance of smooth, consistent wire feeding during MIG welding cannot be emphasised enough. The smoother the wire feed, the better the welding will be. Feed rollers or drive rollers are used to feed the wire mechanically along the length of the welding gun.

Feed rollers are designed to be used for certain types of welding wire, and they have different types of grooves machined in them to accommodate the different types of wire. The wire is held in the groove by the top roller of the wire drive unit and is referred to as the pressure roller; pressure is applied by a tension arm that can be adjusted to increase or decrease the pressure as required. The type of wire will determine how much pressure can be applied and what type of drive roller is best suited to obtain optimum wire feed.

Solid Hard Wire (V Groove)

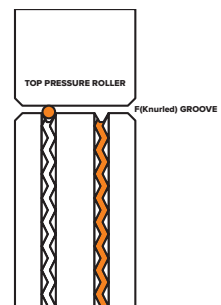
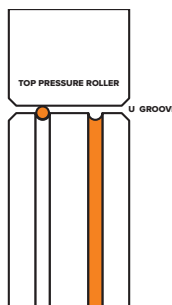
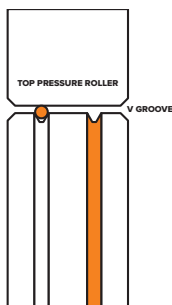
Steel or Stainless Steel require a drive roller with a **V** shape groove for optimum grip and drive capability. Solid wires can have more tension applied to the wire from the top pressure roller that holds the wire in the groove, and the V shape groove is more suited for this. Solid wires are more forgiving to feed due to their higher cross-sectional column strength; they are stiffer and don't bend so easily.

Aluminium (U Groove)

Aluminium requires a **U** shape groove. Aluminium wire has a lot less column strength, can bend easily and is, therefore, more difficult to feed. Soft wires can easily buckle at the wire feeder where the wire is fed into inlet guide tube of the torch. The U-shaped roller offers more surface area grip and traction to help feed the softer wire. Softer wires also require less tension from the top pressure roller to avoid deforming the shape of the wire, too much tension will push the wire out of shape and cause it to catch in the contact tip.

Flux Core / Gasless Wire (Knurled/F Groove)

These wires are made up of a thin metal sheath that has fluxing, and metal compounds layered onto it and then rolled into a cylinder to form the finished wire. The wire cannot take too much pressure from the top roller as it can be crushed and deformed if too much pressure is applied. A **Knurled/F Groove** drive roller has been developed, and it has small serrations in the groove, the serrations grip the wire and assist in driving it without too much pressure from the top roller. The downside to the knurled wire feed roller on flux-cored wire is it will slowly over time bit by bit eat away at the surface of the welding wire, and these small pieces will eventually go down into the liner. This will cause clogging in the liner and added friction that will lead to welding wire feed problems. A U groove wire can also be used for flux core wire without the wire particles coming off the wire surface. However, it is considered that the knurled roller will give a more positive feed of flux core wire without any deformation of the wire shape.



Roller Diameter: 30/22

V Groove Roller (Steel Wire)

SKU	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

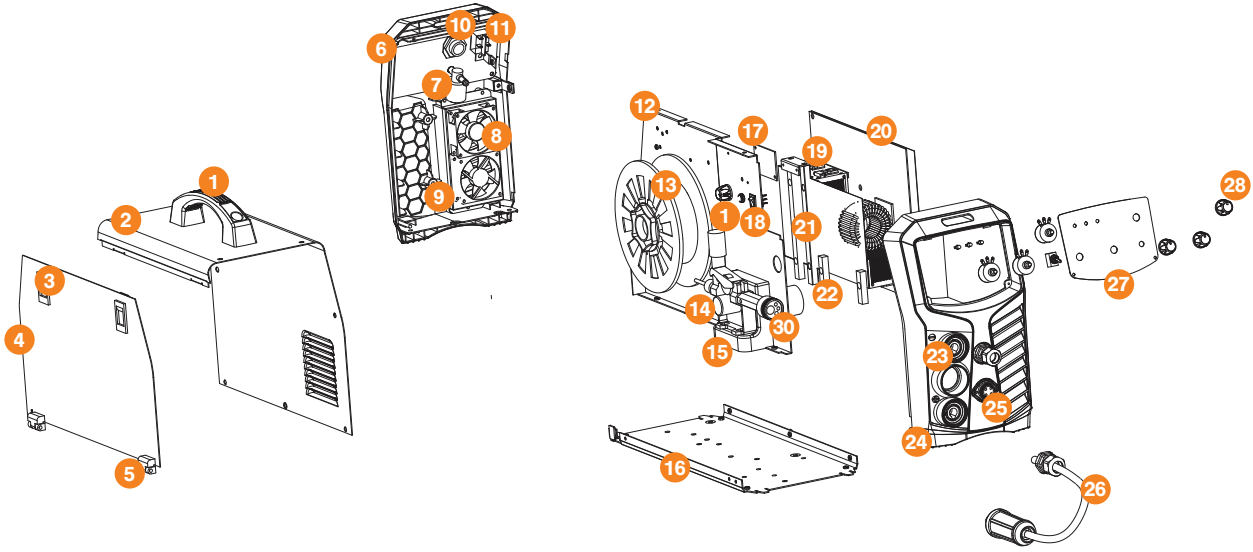
U Groove Roller (Aluminium Wire)

SKU	Description
0.8-1.0U30/22	Drive Roll U Groove 1.0-1.2mm
0.9-1.0U30/22	Drive Roll U Groove 0.9-1.0mm
0.9-1.2U30/22	Drive Roll U Groove 0.9-1.2mm
1.0-1.2U30/22	Drive Roll U Groove 1.0-1.2mm

Knurled/F Groove (Flux-Cored Wire)

SKU	Description
0.8-0.9F30/22	Drive Roll Knurled 0.8-0.9mm
0.9-1.2F30/22	Drive Roll Knurled 0.9-1.2mm

MACHINE PARTS BREAKDOWN



MACHINE SPARES

1	10050074	Handle
2	-	Side Penal
3	10016524	Door Holder
4	-	Basecover
5	10052166	Loose-Leaf
6	10068849	Rear Panel
7	10001381	Solenoid Valve
8	10041446	Fan
9	10068372	Fan Bracket
10	10004897	Cable Clip
11	10047746	Power Switch
12	-	Median Septum
13	10054475	Wire Feeding Spool
14	10068410	Wire Feeding
15	10041716	Fixed Cover For Wire Feeder

MACHINE SPARES

16	10068307	Base Board
17	10070464	Vrd Board
18	10062441	Rocker Switch
19	10054623	Inverter
20	10070471	Main Board
21	10054164	Long Column
22	10054163	Short Column
23	10045432	Quick Socket
24	10068848	Front Panel
25	10068218	Aviation Socket
26	10068359	Hand Line
27	-	Front Panel Baffle
28	30000208	Knob
29	10044633	Inching Switch
30	10068360	Central Socket

WARNING: There are extremely dangerous voltage and power levels present inside this unit. Do not attempt to diagnose or repair unit by removing external cover unless you are an authorised repair agent for UNIMIG.

MIG TROUBLESHOOTING

1. Excessive Spatter.

- **Wire feed speed set too high.** Select lower wire feed speed.
- **Voltage too high.** Select a lower voltage setting.
- **Wrong polarity set.** Select the correct polarity for the wire being used - see machine setup guide.
- **Stick out too long.** Bring the torch closer to the work.
- **Contaminated base metal.** Remove materials like paint, grease, oil, and dirt, including mill scale from base metal.
- **Contaminated MIG wire.** Use clean dry rust free wire. Do not lubricate the wire with oil, grease etc.
- **Inadequate gas flow or too much gas flow.** Check the gas is connected, check hoses, gas valve and torch are not restricted. Set the gas flow between 6-12 l/min flow rate. Check hoses and fittings for holes, leaks etc.

2. Porosity: Small cavities or holes resulting from gas pockets in weld metal.

- **Wrong gas.** Check that the correct gas is being used.
- **Inadequate gas flow or too much gas flow.** Check the gas is connected, check hoses, gas valve and torch are not restricted. Set the gas flow between 10 - 15 l/min flow rate. Check hoses and fittings for holes, leaks etc. Protect the welding zone from wind and drafts.
- **Moisture on the base metal.** Remove all moisture from base metal before welding.
- **Contaminated base metal.** Remove materials like paint, grease, oil, and dirt, including mill scale from base metal.
- **Contaminated MIG wire.** Use clean dry rust free wire. Do not lubricate the wire with oil, grease etc.
- **Gas nozzle clogged with spatter, worn or out of shape.** Clean or replace the gas nozzle.
- **Missing or damaged gas diffuser.** Replace the gas diffuser.
- **MIG torch Euro connect O-ring missing or damaged.** Check and replace the O-ring.

3. Wire stubbing during welding.

- **Holding the torch too far away.** Bring the torch closer to the work and maintain stick out of 5-10mm.
- **Welding voltage set too low.** Increase the voltage.
- **Wire Speed set too high.** Decrease the wire feed speed.

4. Lack of fusion: Failure of weld metal to fuse completely with base metal or a proceeding weld bead.

- **Contaminated base metal.** Remove materials like paint, grease, oil, and dirt, including mill scale from base metal.
- **Not enough heat input.** Select a higher voltage range and /or adjust the wire speed to suit.
- **Improper welding technique.** Keep the arc at the leading edge of the weld pool. Gun angle to work should be between 5 & 15°. Direct the arc at the weld joint. Adjust work angle or widen groove to access bottom during welding. Momentarily hold arc on side walls if using weaving technique.

5. Excessive penetration: Weld metal melting through base metal.

- **Too much heat.** Select a lower voltage range and /or adjust the wire speed to suit. Increase travel speed.

6. Lack of penetration: Shallow fusion between weld metal and base metal

- **Poor incorrect joint preparation.** Material too thick. Joint preparation and design needs to allow access to bottom of groove while maintaining proper welding wire extension and arc characteristics. Keep the arc at the leading edge of the weld pool and maintain the gun angle at 5 & 15° keeping the stick out between 5-10mm.
- **Not enough heat input.** Select a higher voltage range and /or adjust the wire speed to suit. Reduce travel speed.
- **Contaminated base metal.** Remove materials like paint, grease, oil, and dirt, including mill scale from base metal.

7. No wire feed.

- **Wrong mode selected.** Check that the TIG/MMA/MIG selector switch set to MIG position.
- **Wrong torch selector switch.** Check that the STANDARD/SPOOL GUN selector switch is set to STANDARD position for MIG welding and SPOOL GUN when using the spool gun.

8. Inconsistent/interrupted wire feed .

- **Adjusting wrong dial.** Be sure to adjust the WIRE FEED and VOLTAGE dials for MIG welding. The AMPERAGE dial is for STICK and TIG welding mode.
- **Wrong polarity selected.** Select the correct polarity for the wire being used - see machine setup guide.
- **Incorrect wire speed setting.** Adjust the wire feed speed.
- **Voltage setting incorrect.** Adjust the voltage setting.
- **MIG torch lead too long.** Small diameter wires and soft wires like aluminium don't feed well through long torch leads - replace the torch with a lesser length torch.
- **MIG torch lead kinked or too sharp angle being held.** Remove the kink, reduce the angle or bend.
- **Contact tip worn, wrong size, wrong type.** Replace the tip with correct size and type.
- **Liner worn or clogged (the most common causes of bad feeding).** Try to clear the liner by blowing out with compressed air as a temporary cure, it is recommended to replace the liner.
- **Wrong size liner.** Install the correct size liner.
- **Blocked or worn inlet guide tube.** Clear or replace the inlet guide tube.
- **Wire misaligned in drive roller groove.** Locate the wire into the groove of the drive roller.
- **Incorrect drive roller size.** Fit the correct size drive roller e.g.; 0.8mm wire requires 0.8mm drive roller.
- **Wrong type of drive roller selected.** Fit the correct type roller (e.g. knurled rollers needed for flux cored wires).
- **Worn drive rollers.** Replace the drive rollers.
- **Drive roller pressure too high.** Can flatten the wire electrode causing it to lodge in the contact tip - reduce the drive roller pressure.
- **Too much tension on wire spool hub.** Reduce the spool hub brake tension.
- **Wire crossed over on the spool or tangled.** Remove the spool untangle the wire or replace the wire.
- **Contaminated MIG wire.** Use clean dry rust free wire. Do not lubricate the wire with oil, grease etc.

STICK (MMA) TROUBLESHOOTING

1. No arc.

- **Incomplete welding circuit.** Check earth lead is connected. Check all cable connections. .
- **Wrong mode selected.** Check the MMA selector switch is selected.
- **No power supply.** Check that the machine is switched on and has a power supply.

2. Porosity: Small cavities or holes resulting from gas pockets in weld metal.

- **Arc length too long.** Shorten the arc length.
- **Work piece dirty, contaminated or moisture.** Remove moisture and materials like paint, grease, oil, and dirt, including mill scale from base metal.
- **Damp electrodes.** Use only dry electrodes.

3. Excessive Spatter.

- **Amperage too high.** Decrease the amperage or choose a larger electrode.
- **Arc length too long.** Shorten the arc length.

4. Weld sits on top, lack of fusion.

- **Insufficient heat input.** Increase the amperage or choose a larger electrode.
- **Work piece dirty, contaminated or moisture.** Remove moisture and materials like paint, grease, oil, and dirt, including mill scale from base metal.
- **Poor welding technique.** Use the correct welding technique or seek assistance for the correct technique.

5. Lack of penetration.

- **Insufficient heat input.** Increase the amperage or choose a larger electrode.
- **Poor welding technique.** Use the correct welding technique or seek assistance for the correct technique.
- **Poor joint preparation.** Check the joint design and fit up, make sure the material is not too thick. Seek assistance for the correct joint design and fit up.

6. Excessive penetration: Burn through.

- **Excessive heat input.** Reduce the amperage or use a smaller electrode.
- **Incorrect travel speed.** Try increasing the weld travel speed.

7. Uneven weld appearance.

- **Unsteady hand, wavering hand.** Use two hands where possible to steady up, practise your technique.

8. Distortion: Movement of base metal during welding.

- **Excessive heat input.** Reduce the amperage or use a smaller electrode.
- **Poor welding technique.** Use the correct welding technique or seek assistance for the correct technique.
- **Poor joint preparation and or joint design.** Check the joint design and fit up, make sure the material is not too thick. Seek assistance for the correct joint design and fit up.

9. Electrode welds with different or unusual arc characteristic.

- **Incorrect polarity.** Change the polarity, check the electrode manufacturer for correct polarity.



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