



INSTRUCTIONS FOR

**SUPERMIG**

**WELDERS**

MODEL No's:

**SUPERMIG150.V2**

**SUPERMIG160.V2**

**SUPERMIG180.V2**



### MODEL No's: SUPERMIG150.V2, SUPERMIG160.V2, SUPERMIG180.V2

Thank you for purchasing a Sealey Welder. Manufactured to a high standard this product will, if used according to these instructions and properly maintained, give you years of trouble free performance.



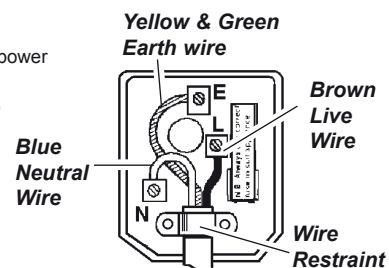
**IMPORTANT: BEFORE USING THIS PRODUCT, PLEASE READ THE INSTRUCTIONS CAREFULLY. MAKE CAREFUL NOTE OF SAFETY INSTRUCTIONS, WARNINGS AND CAUTIONS. THIS PRODUCT SHOULD ONLY BE USED FOR ITS INTENDED PURPOSE. FAILURE TO DO SO MAY CAUSE DAMAGE OR PERSONAL INJURY, AND WILL INVALIDATE THE WARRANTY.**

## 1. SAFETY INSTRUCTIONS

### 1.1. ELECTRICAL SAFETY. WARNING! It is the user's responsibility to read, understand and comply with the following:

You must check all electrical equipment and appliances to ensure they are safe before using. You must inspect power supply leads, plugs and all electrical connections for wear and damage. You must ensure the risk of electric shock is minimised by the installation of appropriate safety devices. An RCCB (Residual Current Circuit Breaker) should be incorporated in the main distribution board. We also recommend that an RCD (Residual Current Device) is used with all electrical products. It is particularly important to use an RCD together with portable products that are plugged into an electrical supply not protected by an RCCB. If in doubt consult a professional electrician. You may obtain a Residual Current Device by contacting your Sealey dealer. **You must** also read and understand the following instructions concerning electrical safety.

- 1.1.1. The **Electricity At Work Act 1989** requires all portable electrical appliances, if used a business premises, to be tested by a qualified Electrician, using a Portable Appliance Tester (PAT), at least once a year .
- 1.1.2. The **Health & Safety at Work Act 1974** makes owners of electrical appliances responsible for the safe condition of the appliance, and the safety of the appliance operator. **If in any doubt about electrical safety, contact a qualified electrician.**
- 1.1.3. Ensure the insulation on all cables and the product itself is safe before connecting to the mains power supply. See 1.1.1. & 1.1.2. above and use a Portable appliance Tester (PAT).
- 1.1.4. Ensure that cables are always protected against short circuit and overload.
- 1.1.5. Regularly inspect power supply, leads, plugs and all electrical connections for wear and damage, especially power connections, to ensure that none is loose.
- 1.1.6. **Important:** Ensure the voltage marked on the product is the same as the electrical power supply to be used, and check that plugs are fitted with the correct capacity fuse. A 13Amp plug may require a fuse smaller than 13Amps for certain products see fuse rating at right.
- 1.1.7. DO NOT pull or carry the powered appliance by its power supply lead. Welders must not be pulled or carried by their output cables.
- 1.1.8. DO NOT pull power plugs from sockets by the power cable.
- 1.1.9. DO NOT use worn or damage leads, plugs or connections. Immediately replace or have repaired by a qualified Electrician. A U.K. 3 pin plug with ASTA/BS approval is fitted. In case of damage, cut off and fit a new plug according to the following instructions (discard old plug safely).



**FUSE RATING  
THIS PRODUCT MUST  
BE FITTED WITH A:  
13 Amp FUSE**

**Ensure the unit is correctly earthed via a three-pin plug.**

**a) Connect the GREEN/YELLOW earth wire to the earth terminal 'E'.**

**b) Connect the BROWN live wire to live terminal 'L'.**

**c) Connect the BLUE neutral wire to the neutral terminal 'N'.**

**After wiring, check there are no bare wires, that all wires have been correctly connected and that the wire restraint is tight.**

Double insulated products are often fitted with live (BROWN) and neutral (BLUE) wires only. Double insulated products are marked with this symbol  .

**To re-wire, connect the brown & blue wires as indicated above. DO NOT connect the brown or blue to the earth terminal.**

- 1.1.10. Some products require more than a 13Amp electrical supply. In such a case, **NO** plug will be fitted. **You must** contact a qualified Electrician to ensure a 30 amp fused supply is available. We recommend you discuss the installation of a industrial round pin plug & socket with your electrician.
- 1.1.11. **Cable extension reels.** When a cable extension reel is used it should be fully unwound before connection. A cable reel with an RCD fitted is recommended since any product which is plugged into the cable reel will be protected. The section of the cable on the cable reel is important. We recommend that at least 1.5mm<sup>2</sup> section cable but to be absolutely sure that the capacity of the cable reel is suitable for this product and for others that may be used in the other output sockets, we recommend the use of 2.5mm<sup>2</sup> section cable.

### 1.2 GENERAL SAFETY

**▲ DANGER! Unplug the welder from the mains power supply before performing maintenance or service.**

- ✓ Keep the welder and cables in good working order and condition. (Take immediate action to repair or replace damaged parts).
- ✓ Use genuine parts and accessories only. (Non recommended parts may be dangerous and will invalidate the warranty).
- ✓ Use an air hose to regularly blow out any dirt from the liner, and keep the welder clean for best and safest performance.
- ✓ Check and spray the gas cup and contact tip regularly with anti-spatter spray available from your Sealey dealer.
- ✓ Locate welder in adequate working area for its function. Ensure area has adequate ventilation as welding fumes are harmful.
- ✓ Keep working area clean, tidy and free from unrelated materials. Also ensure the working area has adequate lighting, and that a fire extinguisher is at hand.
- WARNING! Use welding head shield to protect eyes and avoid exposing skin to ultraviolet rays given off by electric arc. Wear safety welding gauntlets.**
- ✓ Remove ill fitting clothing, remove ties, watches, rings, and other loose jewellery, and contain long hair.
- ✓ Ensure the workpiece is correctly secured before operating the welder.
- ✓ Avoid unintentional contact with workpiece. Accidental or uncontrolled use of the torch may be dangerous and will wear the nozzle.
- ✓ Keep unauthorised persons away from the working area. Any persons working within the area must protective head shield and gloves.
- ✓ Operators must receive adequate training before using the welder. The welder must only be operated under supervision.
- ✓ Stand correctly keeping a good footing and balance, and ensure the floor is not slippery, and wear non-slip shoes.
- ✓ Turn voltage switch to "0" (off) when not in use.
- x DO NOT operate the welder if it or its cables are damaged and DO NOT attempt to fit any non genuine torches, components, or parts to the welder unit.
- x DO NOT get welder wet or use in damp or wet locations or areas where there is condensation.
- ▲ DANGER! DO NOT weld near inflammable materials, solids, liquids, or gases, and DO NOT weld containers or pipes which have held flammable materials or gases, liquids or solids. Avoid operating on materials cleaned with chlorinated solvents or near such solvents.**
- x DO NOT stand welder on a metal workbench, car bodywork or similar object.
- x DO NOT touch any live metal parts of the torch or electrode while the machine is switched on.
- x DO NOT pull the welder by the cable, or the torch, and DO NOT bend or strain cables, protect from sharp or abrasive items, and DO NOT stand on cables or leads. Protect from heat. Long lengths of slack must be gathered & neatly coiled. DO NOT place cables where they endanger others.
- x DO NOT touch the torch or workpiece immediately after welding as they will be very hot. Allow to cool.
- x DO NOT operate welder while under the influence of drugs, alcohol or intoxicating medication, or if fatigued.
- ✓ When not in use store the welder in a safe, dry, childproof area.

### 1.3. GAS SAFETY

- ✓ Store gas cylinders in a vertical position only and ensure the storage area is correctly secured.
- x DO NOT store gas cylinders in areas where temperature exceeds 50°C. DO NOT use direct heat on a cylinder. Always keep gas cylinders cool.
- x DO NOT attempt to repair or modify any part of a gas cylinder or valve, and DO NOT puncture or damage a cylinder.
- x DO NOT obscure or remove any official labels from a cylinder. Always check the gas identity before use. Avoid getting gas cylinders oily or greasy.
- x DO NOT lift a cylinder by its cap, guard or valve. Always keep caps and guards in place and close valve when not in use.

## 2. INTRODUCTION & SPECIFICATION

**IMPORTANT:** These instructions contain information you require to prepare your machine for welding, together with maintenance and a trouble shooting section. If you have no previous experience the instructions are not intended to show you how to become a welder. Should you have no experience, we recommend that you seek training from an expert source. Mig welding is relatively easy to perform, but does require a steady hand and time practising under supervision with scrap metal as it is only with continued practice that you will achieve the desired results.

All our Supermig models are suitable for welding with either CO<sub>2</sub>, Argon or CO<sub>2</sub>/Argon mix gas. Each uses a forced air cooling system to slow transformer heating in order to increase duty cycle and a non live torch to prevent the risk of accidentally striking an arc. All models are supplied with an industrial Argon/CO<sub>2</sub> regulator. Welders are illustrated with gas bottles to give an indication of size only; gas is not included. A contract for the supply of gas should be arranged with your local gas distributor. These Supermigs are compact power sources with integral wire feed which protects the wire from dust and dirt (especially in Body Shops). Your Supermig is designed to operate with two diameters of welding wire, 0.6mm, & 0.8mm. (We recommend that 0.8mm wire is used for welding stainless steel and aluminium).

ALL MODELS ARE EQUIPPED WITH: ✓ Torch, ✓ Mini reel of 0.6mm wire, ✓ Regulator, ✓ Gas hose.

SPECIFICATION	SUPERMIG 150.V2	SUPERMIG 160.V2	SUPERMIG 180.V2
Welding Current	30-150 Amps	30-160 Amps	30-180 Amp
Duty Cycle	100% @ 30A 80% @ 50A	100% @ 45A 60% @ 80A	100% @ 60A 60% @ 80A
	50% @ 70A	20% @ 130A	20% @ 140A
	10% @ 150A	10% @ 150A	10% @ 155A
Absorbed Power	4.3 kW	3.7 kW	5.2kW

## 3. ASSEMBLY

To fit the mains power plug see safety instructions (Chapter 1).

### 3.1. Wheel Assembly

- 3.1.1. Turn machine upside down and remove the screws attached to the bottom front, use these screws to attach the front castor wheels.
- 3.1.2. Take the rear axle and fit a wheel to one end by placing a washer, then the wheel, a second washer and then insert a split pin.
- 3.1.3. Pass the axle through the tube under the gas cylinder carrier, then fit the other washer, wheel, washer, and split pin.

### 3.2. Connecting the gas cylinder

- 3.2.1. When using Argon or Argon mixtures, you will need to use the "bull nose adaptor". Fit the bull nose adaptor to the cylinder with a spanner. (If you intend to use CO<sub>2</sub> gas the regulator will fit directly onto the cylinder.)
- 3.2.2. Fit the gas regulator on to the bull nose adaptor and connect it to the machine gas hose (fig.1).
- 3.2.3. When you are ready to weld set the regulator flow rate to 5-8 litres/min depending on the material to be welded, and whether there are draughts which are strong enough to disturb the gas flow.

### 3.3. Fitting a reel of wire.

The welder is supplied with a mini spool of mild steel wire, but will accept spools of up to 5kg without modification.

- 3.3.1. Small reels of wire will run on the spindle itself. The larger 5kg wire reel will run on the larger diameter flange at the base of the reel spindle. Place the wire reel (C) onto the spindle ensuring that the spool rotates anticlockwise with the wire drawing off the bottom of the reel for the SUPERMIG 150.V2 (see fig.3a) and clockwise, with the wire drawing off the reel from the top for the 160.V2 and 180.V2 models (see fig.3b). Place the plastic reel ring nut (D) over the end of the spindle followed by the reel spring (E). Push the 'handwheel' stub (F) into the end of the spindle against the spring pressure and turn and release it to lock it in position.
- 3.3.2. Undo the wire lock screw and lift the wire feed lever up to the right (fig 3b).
- 3.3.3. Straighten 40-50mm of spool wire (*do not allow wire to uncoil*), and gently push wire through the plastic guide and through the 6 or 8mm feed roller groove and into the torch liner (fig 4). Refer to section 6.3 on how to reverse the roller for either 6 or 8mm wire
- 3.3.4. Carefully return the wire feed lever and secure with the wire lock screw.

### 3.3.5. Feeding the wire through to the torch.

(See fig.5)

- Remove gas cup (a) and contact tip (b) from end of torch as follows:
- a) Take torch in left hand with the torch tip facing to the right.
  - b) Grasp gas cup firmly in your right hand.
  - c) Turn gas cup **clockwise only (c)** and pull cup out to the right.  
 **WARNING!** do not turn gas cup anti-clockwise, as this will damage internal spring.
  - d) Unscrew the copper contact tip (*right hand thread*) to remove.
- Check welder is switched off "0", and that the earth clamp is away from the torch tip. Connect the welder to the mains power supply and set the voltage switch to one.
- 3.3.7. Set the wire speed knob to position 5 or 6. Keeping the torch cable as straight as possible and press the torch switch. The wire will feed through the torch.
  - 3.3.8. When wire has fed through, switch welder off, unplug from mains.
    - a) Take torch in left hand and screw contact tip back into place.
    - b) Grasp gas cup in right hand, push onto torch head and turn **clockwise only**.  
 **WARNING!** do not turn gas cup anti-clockwise, as this will damage internal spring.
    - c) Cut wire so that it is just protruding from the cup.

### 3.4. Setting wire tension **IMPORTANT:** You must set the correct tension, too little or too much tension will cause problematic wire feed and result in poor welding.

- 3.4.1. For mild steel 0.6mm wire the wire lock screw must be fully tightened and undone approximately two complete turns (fig 6).
- 3.4.2. Correct tension between the rollers is checked by slowing down the wire between the fingers. If the top feed roller skids the tension is correct. Try to use the lowest tension possible as too high a tension will disfigure the wire and may result in blowing a fuse on the printed circuit board. When you have completed welding, remove the torch and store in a safe, dry place.  
 Note: Damaged torches and cables are not covered under warranty.

Fig.1

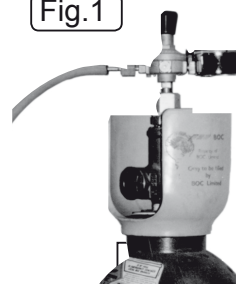
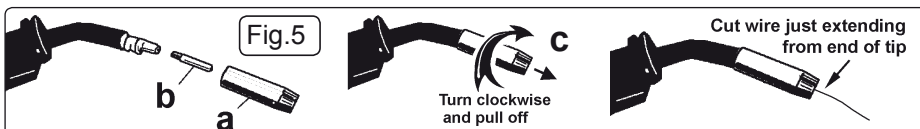
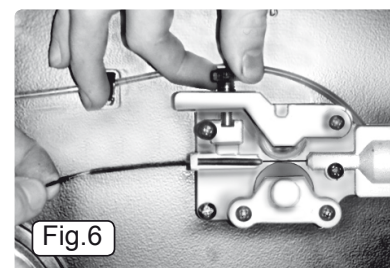
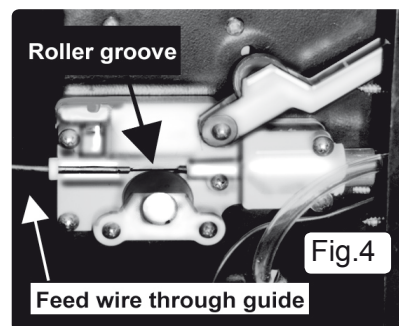
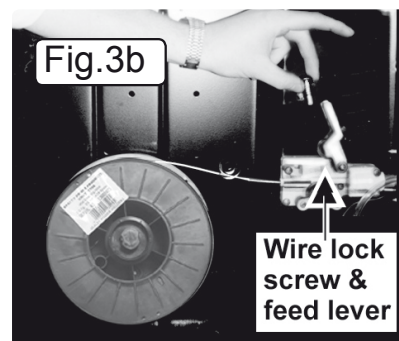
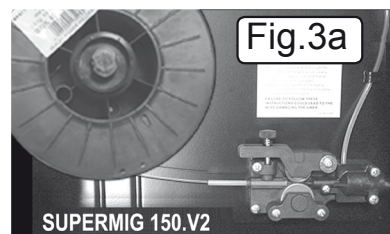
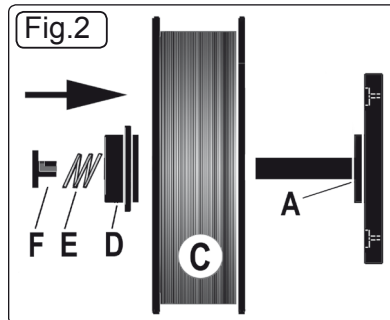


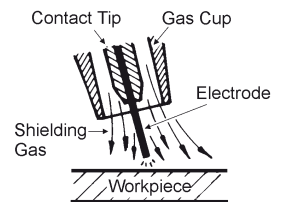
Fig.2



## 4. WELDING PRINCIPLES & PREPARATION

### 4.1. Mig/Mag Welding.

A spool of welding wire is positioned on the welder's spool holder and automatically fed through an insulated liner in the torch to the tip. The torch assembly consists of a switch, liner, gas hose, and control cable. The switch activates the wire feed roller and the gas flow. Conversely, releasing the switch stops the wire feed and gas flow. The weld current is transferred to the electrode (the wire) from the contact tip at the end of the torch. A gas cup fits over the contact tip to direct the gas flow towards the weld ensuring that the arc welding process is shielded from oxidising air contaminants. The shielding gas also assists heating of the weld materials.



The torch is connected to the positive side of a DC rectifier, and the negative clamp is attached to the workpiece.

### 4.2. Spot Welding.

Remove the gas cup and fit a spot welding gas cup (120/722150). Turn the voltage to the highest setting allowed by your machine. Drill a small hole in the top plate. Push the spot gas cup onto the material to be welded. The castellations on the cup keep it the correct distance from the weld pool and allow you to push the two pieces being welded together. Press the torch trigger and hold it for 2 to 3 seconds. The wire will feed through during the allotted time and create the weld.

### 4.3. Preparation for Welding.

**IMPORTANT: BEFORE YOU COMMENCE, MAKE SURE THE MACHINE IS SWITCHED OFF AT THE MAINS. IF WELDING A CAR, DISCONNECT THE BATTERY OR FIT AN ELECTRONIC CIRCUIT PROTECTOR. WE RECOMMEND THE USE OF SEALEY PROSAF/12V OR 24V IN ORDER TO PROTECT SOPHISTICATED ELECTRONICS. ENSURE YOU HAVE READ AND UNDERSTOOD THE ELECTRICAL SAFETY INSTRUCTIONS IN CHAPTER 1.**

#### 4.3.1. Connecting the Earth Lead

To ensure a complete circuit, the earth lead must be securely attached to the work piece that is to be welded.

a) Best connection is obtained by grinding the point of contact on the workpiece before connecting clamp to the workpiece.

b) The weld area must also be free of paint, rust, grease, etc.

c) If welding a vehicle, disconnect the battery or fit a PROSAF/12 "Electronic Circuit Protector" available from your Sealey dealer.

#### 4.3.2. Wire feed switch controls the speed of the wire feed. In principle, the lower the amperage number the slower the wire speed.

#### 4.3.3. To weld mild steel, CO2 gas is suitable for most tasks where spatter and the high build up of weld do not pose a problem.

To achieve a spatter free and flat weld however, **you must use an Argon/CO2 mixture.**

#### 4.3.4. To weld aluminium use: ✓ Argon gas, ✓ 0.8mm contact tip (AK957), ✓ 0.8mm aluminium wire, (MIG/2/KAL08).

Note: Ensure you feed the wire through the correct sized groove in the feed roller (see section 6.3).

## MEANINGS OF MARKINGS, AND SYMBOLS

	Single-Phase transformer
	Flat Characteristic
	MIG/MAG welding
...A/ ... V to ...A/ ... V	Range of output, rated min & max welding current and their corresponding conventional load voltage.

Rated on-load voltage $U^0$ in V	
a) Peak value in case of direct current;	
b) Peak & r.m.s. value in case of alternating current.	
X	Duty cycle (Factor)
12	Rated weld current
$U_2$	Conventional load voltage
	Mains supply and number of phases (i.e. 1 or 3) with symbol for alternating current.
(1)3	

	Alternating current & the rated frequency in hertz i.e. 50Hz
$P_{max}$ ... kW	Maximum power consumption in case of a rotating welding power source. This value will only be given when it is not combined with a prime mover.
$U_1$ ... V/...Hz	Rated values of the supply voltage and the frequency.
/1	Rated supply current.
IP	Degree of protection, i.e. 21 or 23.
	Welding power sources which are suitable for supplying power to welding operations carried out in an environment with increased hazard of electric shock.

## 5. WELDING

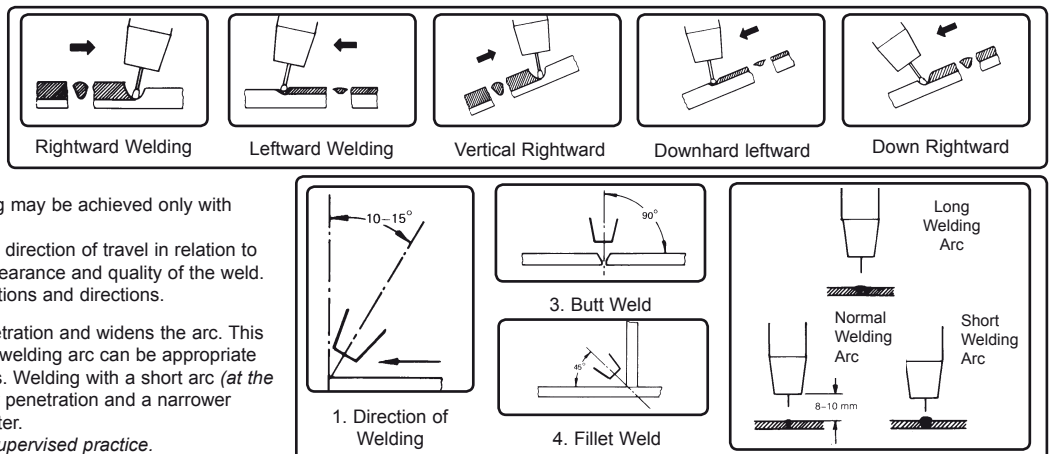
### IMPORTANT.

Should you have no welding experience, we recommend you seek training from an expert source to ensure your personal health & safety. You must familiarise yourself with welding applications and limitations, and specific potential hazards peculiar to welding. Good Mig welding may be achieved only with continued, supervised practice.

For example: Correct torch angle and direction of travel in relation to the workpiece is essential for the appearance and quality of the weld. Illustrations demonstrate various positions and directions.

Welding with a long arc reduces penetration and widens the arc. This in turn results in more spatter. A long welding arc can be appropriate for welding butt joints in thin materials. Welding with a short arc (at the same weld settings) results in greater penetration and a narrower weld and reduces the amount of spatter.

We recommend expert training and supervised practice.



## 6. MAINTENANCE

### 6.1. Wire feed unit

Check the wire feed unit at regular intervals. The feed roller wire guide plays an important part in obtaining consistent results. Poor wire feeding affects welding. Clean the rollers weekly, especially the feed roller groove, removing all dust deposits.

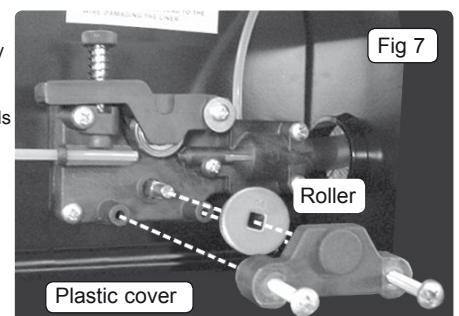
### 6.2. Torch

Protect the torch cable assembly from mechanical wear. Clean the liner from the machine forwards by using compressed air. If the liner is clogged it must be replaced.

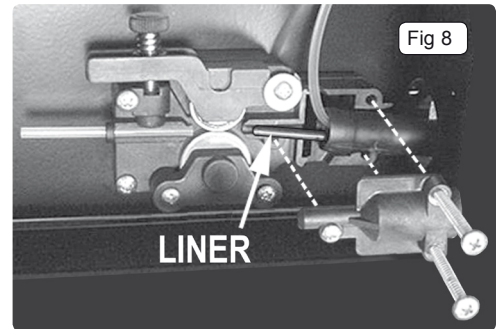
### 6.3. Turning or Changing the Feed Roller

**IMPORTANT: Adjust the feed roller to the corresponding wire size.**

There are two grooves on the feed roller, 0.6mm and 0.8mm. Always use the groove on the outside of the roller, (the groove nearest to you). To remove the feed roller, undo the two screws and remove the plastic cover (fig 7). Clean and turn, or if damaged change the feed roller and replace plastic cover accordingly.



- 6.4. **Contact Tip** (to remove tip follow steps in 3.4.6. and to replace 3.4.9. a & b very carefully).  
The contact tip is a consumable item and must be replaced when the hole becomes enlarged or oval. The contact tip **MUST** be kept free from spatter to ensure an unimpeded flow of gas.
- 6.5. **The Gas Cup (Conical Nozzle)** (to remove cup follow steps in 3.4.6. and to replace 3.4.9. a & b very carefully).  
The gas cup must also be kept clean and free from spatter. Build up of spatter inside the gas cup can cause a short circuit at the contact tip which will result in either the fuse blowing on the printed circuit card, or expensive machine repairs. To keep the contact tip free from spatter, we recommend the use of Sealey anti-spatter spray (MIG/722307) available from your Sealey Dealer. We also recommend that you keep spare tips and gas cups in stock.
- 6.6. **Replacing the Liner** (See fig.8)  
Wind the wire back on to the spool and secure it. Remove the three screws which secure the torch sleeve to the wire feed unit. Take off the plastic cover. The teflon liner should now be visible. Open the torch casing and disconnect the wire liner from the torch head. Pull out the liner and insert a new one. Reassemble the torch, replace the plastic cover and screws on the wire feed unit and trim the liner as close to the feed roller as possible.
- 6.7. **Changing Gears**  
An inexperienced welder can allow spatter to build up in the tip and shroud. In severe cases this can block the feed causing gear stripping in the drive motor. To check if the gears are worn depress the button on the torch with the set switched on. If the gears are worn, a grating sound will be heard coming from the wire feed motor, you may also observe the feed roller vibrating instead of rotating. Should this be the case, open the gearbox, remove the worn or damaged gears and replace with new ones.
- 6.8. **Changing Fuses**  
The fuse is located as follows: Supermigs 150.V2, & 160.V2 on the circuit board behind the wire feed knob. Supermig 180.V2 on the front panel. Fuses are mainly blown for the following reasons:  
✓ Spatter collecting in the gas cup and contact tip causing a short circuit. ✓ Wire tension is too great. ✓ A sudden surge of current.



## 7. TROUBLESHOOTING

PROBLEM	POSSIBLE CAUSE	REMEDY (Numbers refer to chapter and item heading)
1. Power source stops	Overheating protection activated due to overload	Protection automatically resets when transformer has cooled (about 15 min).
2. No weld current, fuse blowing in 13amp plug	Rectifier blown	Replace rectifier.
3. No weld current	Bad connection between clamp & workpiece Break in earth lead Break in torch lead	Clean or grind contact surface and weld area. Repair or replace earth lead. Repair or replace torch.
4. Feed motor not working, lamp is on	Fuse blown Gear damaged or worn Motor defective	Replace fuse 1.5 amp. (Chapter 6). Replace gears. (Chapter 6). Replace motor (Contact service agent).
5. Wire does not feed, feed roller rotates	Pressure roller improperly adjusted Dirt, copper, dust, etc, have collection in torch liner Gas cup (Nozzle) defective Deformed wire	Adjust tension. (Chapter 3). Clean the liner from the machine forward. Use compressed air. If too much dirt, replace the liner. (Chapter 6). Replace gas cup (nozzle) and check tip. (Chapter 6). Check pressure roller tension and adjust if necessary (Chapter 3).
6. Wire feeds unevenly.	Dirt, etc, in liner Gas cup (Nozzle) or contact tip defective Gas cup (Nozzle) spattered Feed roller groove clogged Feed roller groove deformed Wrong tension	Clean the liner from the machine forward. Use compressed air. Replace gas cup (nozzle) or contact tip (Chapter 6). Clean or replace gas cup (nozzle). (Chapter 6). Clean feed roller. (Chapter 6). Replace feed roller. (Chapter 6). Adjust tension. (Chapter 3).
7. Unstable arc.	Incorrect settings Impurities in weld area Worn or defective gas cup (nozzle)	Use recommended settings. (Chapter 4). Clean or grind weld area. (Chapter 4). Replace gas cup (nozzle) and check tip. (Chapter 6).
8. Porous weld	No gas Gas cup clogged Draft blowing away shielding gas Rusty or dirty joints Torch too far from or at wrong angle to work Gas leak	Open gas cylinder, regulate gas flow. Clean or replace cup. (Chapter 6). Screen off welding site or increase gas flow. Clean or grind. (Chapter 4). The distance from gas cup to workpiece should be 8-10mm and torch angle 60°. Check hoses, connections and torch assembly. (Chapter 6). Press the gas cup in correction position.
9. Electrode sticking in contact tip or gas cup (nozzle)	Worn or defective gas cup (nozzle) Electrode deformed Wire speed too slow	Replace gas cup (nozzle). (Chapter 6). Check pressure roller tension. (Chapters 3 & 6). See recommendations for wire speed. (Chapter 4).
10. Irregular weld head	Torch incorrectly held Wire weaving in weld pool	Use torch angle 60°. (Chapter 5). Check pressure roller tension and adjust as needed. (Chapter 3).
11. Weld bead too narrow and raised	Weld current too low Weld speed too high	Increase voltage and wire speed. (Chapter 4). Move torch slower and weave a little more.
12. Weld bead too wide	Weld current too high Weld speed too low Arc too long	Decrease voltage and wire speed. (Chapter 4). Move torch faster and weave less. Bring torch closer to workpiece.
13. Poor penetration	Weld current too low Arc too long	Increase voltage and wire speed. (Chapter 4). Bring torch closer to workpiece.
14. Excessive penetration	Weld current too high weld speed too slow incorrect distance of torch to workpiece	Decrease voltage and wire speed. (Chapter 4). Move torch faster. Torch distance should be 8-10mm. (Chapter 5).
15. Fuse blowing	Tension too great Gas cup contact tip clogged	Release tension. (Chapter 3). Clean gas cup and contact tip. (Chapter 6).



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**Environmental Protection.**



Recycle unwanted materials instead of disposing of them as waste. All tools, accessories and packaging should be sorted, taken to a recycle centre and disposed of in a manner which is compatible with the environment.



When the product is no longer required, it must be disposed of in an environmentally protective way.

**NOTE:** It is our policy to continually improve products and as such we reserve the right to alter data, specifications and component parts without prior notice.

**IMPORTANT:** No liability is accepted for incorrect use of this product.

**WARRANTY:** Guarantee is 12 months from purchase date, proof of which will be required for any claim.

**INFORMATION:** For a copy of our latest catalogue and promotions call us on 01284 757525 and leave your full name and address, including postcode.



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