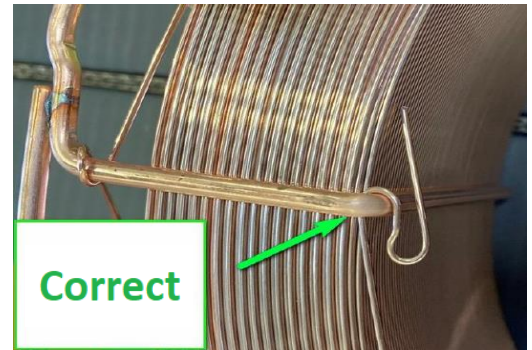


- 1** Before placing the spool on the device, check if the hook has not straightened up during removing the wire of the package. This may cause loosening the last coil wire during welding, and entanglement and jamming of the spool.



- 2** Mount the wire spool in such a way that the wire unwinding direction is consistent with the direction of wire entry into the feeding unit. Check the condition and pressure of the rolls in the splicer feeder. Remember that the bigger the pressure, the bigger the risk of damaging the wire by the welder. On the other hand, too low pressure causes wire sliding in the feeder and its uneven feeding. Remember to use V-shaped rollers for steel wire and U-shaped wire for aluminum wire.

- 3** Check the cylinders and the gas lines tightness. Then set the gas consumption according to the diameter. You can use the formula: $\text{Wire Diameter} \times 10 = X \text{ (l/min)}$. Remember that too large values do not bring benefits at all. Too much shielding gas will cause the shield to mix with oxygen, which will result in i.a. porosity of joints.

- 4** Before welding, make sure that the welded material is properly cleaned.

- 5** Remember not to work on worn welding accessories. Check the condition of the contact tip, nozzle and cartridge in the gun regularly.



The most common welding problems:

- 1** Excessive porosity of joints:
 - a) Check that the gas cylinder is unscrewed and that the system is tight.
 - b) Check the amount of shielding gas supplied during welding. Too low a value as well as too high can cause porosity during welding.
 - c) Avoid welding in drafty open areas.
 - d) Check that you are welding with the correct polarity.
 - e) Check the cleanliness of the material to be welded.

- 2** Excessive amount of spatter:
 - a) Correct the parameters on the welding device.
 - b) Check the cleanliness of the material to be welded.
 - c) Check the polarity and condition of the mounted ground terminal.

- 3** The wire does not come out regularly:
 - a) Check the condition of the feed rollers.
 - b) Check the condition of the cartridge in the welding gun.
 - c) Check the condition of the contact tip.
 - d) Check that the cable is not twisted or bent.

CAUTION

Remember that when installing a wire from another supplier, you must adjust the welding parameters again, because not every wire will react identically to the same parameters set in the welding machine.