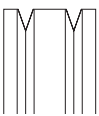
Weldclass

FORCE 160MST
Quick Reference Chart

MIG Welding Parameter

Welding Material	Wire Type	Wire Size	Drive Roller Type	Shielding Gas	Material Thickness: 1.0mm	2.0mm	3.0mm	5.0mm
					Settings: Voltage / Wirespeed			
Mild Steel	Gasless	0.8mm	Knurled Groove 	N/A	2/5	4/7	6/9	9/9
		0.9mm			3/4	4/4.5	5/5	7/8
	Solid Steel	0.6mm	'V' Groove 	Mixed (Argon + CO^2)	3/6	5/9	-	-
		0.8mm			3/5	6/8	6/9	-
		0.9mm			3/4	5/6	7/9	9/9

IMPORTANT!

Keep Tight!

Ensure that all connections are very tight before welding.

Loose cable connections will affect welding performance and can cause the connection to burn out.

Tip: Disconnect the polarity cable, twist the connector 360° in the direction opposite the arrow shown, then reconnect. This will keep the connection tight.

Polarity

Process	Torch	Earth Lead
MIG (With Gas)	+	-
Gasless MIG	-	+
Stick* (MMA)* *Confirm with electrode manufacturer recommendation	+	-
TIG	-	+

Wire Jam Troubleshooting

- If wire jam occurs when the torch becomes hot, this is often because the heat causes the wire and the tip to expand (which shrinks the hole in the tip). Using a slightly oversize tip can prevent this – eg: for 0.9mm wire, use a 1.0mm tip.
- Do NOT over-tighten the drive roll tension – this will accelerate wear of the drive system, may distort the wire & will cause further wire feed problems.
- Refer to instruction manual for other causes of wire jamming.

Help | Support | Videos

Weldclass.com.au /support160mst

Torch Parts

Go to: weldclass.com.au/BZL15

Use chart as guide only, as optimal settings will vary with weld joint type and operator technique.