



### MIG Welding Parameters

### Material Thickness

Welding Material	Wire Type	Wire Size	Drive Roller Type	Torch Liner	Shielding Gas	1.6mm	3.0mm	6.0mm	8.0mm
						Dial Position			
						Voltage / Wirespeed			
Mild Steel	Gasless	0.8mm	Knurled Groove	Blue	N/A	2/2	6/6	10/10	-
		0.9mm		Red		1/2	5/6	7/8	10/10
	Solid Steel	0.6mm	'V' Groove	Blue	Mixed (Argon + CO <sub>2</sub> )	4/6	-	-	-
		0.8mm				3/2	7/7	-	-
		0.9mm		Red		2/2	6/6	9/10	10/10

### 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/support180mst](http://Weldclass.com.au/support180mst)



### IMPORTANT!

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.

**Keep Tight!**



### Polarity

Process	Torch		Earth Lead	
MIG (With Gas)				
Gasless MIG				
Stick* (MMA)*				
TIG				

### Torch Parts



For torch parts, go to: [weldclass.com.au/BZL25](http://weldclass.com.au/BZL25)