

# Weldforce 175MST

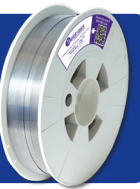
## MIG - Stick - TIG Inverter Welder

Going Gasless? Here's a perfect match!

Australia's No. 1 Gasless Wire



Weldclass Platinum GL-11



### Controls

#### 1. Process Mode

Use to select desired welding process: MIG, TIG or Stick (MMA). Refer to Polarity chart for correct polarity settings.

#### 2. Primary Output Adjustment

**MIG:** Adjusts voltage (heat) and wire speed simultaneously. Refer to settings chart for suggested settings based on material type & thickness.

**Stick (MMA):** Adjusts main current (Amps). Suggested settings for different electrode sizes as marked.

**TIG:** Adjusts main current (Amps).

#### 3. Secondary Adjustment

**MIG:** Adjusts Inductance\*. Refer to settings chart for suggested settings based on material type & thickness.  
\*More inductance causes a wider and more penetrating arc, useful for thicker weld joints. Less inductance will create a narrow more focused arc. Also used to fine tune the arc & optimise performance for different materials/applications & to minimise spatter.

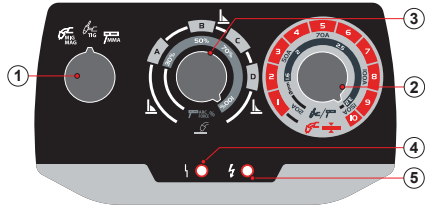
**Stick (MMA):** Adjusts Arc Force\* percentage.

\*Arc Force delivers an short-duration peak of current if it senses the electrode is sticking. Example: If output is set at 100A and Arc Force at 50%, current peak will be 150A.







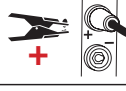
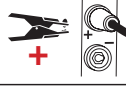
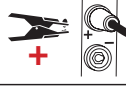









#### 4. Overload/Error Indicator LED

Indicates if duty cycle has been exceeded and thermal protection has been activated (welding output will be disabled until machine cools sufficiently). Also may indicate power supply issues. Refer to manual for more information.

#### 5. Power On/Off Indicator



### Polarity

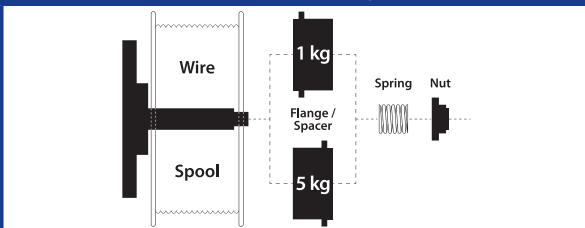
		Torch		Earth Lead	
	MIG with Gas				
	Gasless MIG				
	TIG				
	Stick (MMA)* <small>*Confirm with electrode manufacturer recommendation</small>				

### Torch Parts







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

### Spool Mounting



Spool tension should be just enough to brake spool & prevent free-wheeling. Do not over-tighten as this will put undue strain on drive system.

### Settings Chart

Wire Type	Gas	Wire Size	Inductance 	Material Thickness (mm) / Output Setting*									Drive Roller		Torch Liner
				0.6mm	0.8mm	1.0mm	1.5mm	2.0mm	2.5mm	3.0mm	4.0mm	5.0mm	Type	Part No.	
Gasless / Flux-Cored Steel	-	0.8mm	C	1.5	2	3	4	4.5	6	7	9	-	Knurled Groove 	WC-06425	Blue
		0.9mm	C	1.5	2	2.5	3.5	4.5	6	7	8.5	9			Red
Solid Steel	Mixed Ar+CO <sub>2</sub>	0.6mm	C	2	2.5	3	4.5	6	7.5	9	-	-	V-Groove 	WC-06422	Blue
		0.8-0.9mm	B	2	2	2.5	3.5	4.5	5.5	6.5	8	10			Red
	CO <sub>2</sub>	0.6mm	D	2	2.5	3	4	5.5	7	-	-	-			Blue
		0.8-0.9mm	D	1.5	2	2.5	3	3.5	4	-	-	-			Red
Stainless-Steel	Ar+O <sub>2</sub> / Ar+CO <sub>2</sub>	0.8mm	B	2	2.5	3.5	4	5.5	7.5	9	-	-			Blue
Aluminium	Ar	0.9mm	A	-	3.5	4.5	7	8	9	-	-	-	U-Groove 	WC-06426	Teflon / Poly
		1.0mm	A	-	3	3.5	5.5	7	9	-	-	-			
Bronze (CuSi/CuAl)	Ar	0.8mm	A	-	2.5	3.5	5	6.5	8.5	-	-	-	U or V-Groove	WC-06422	

### 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.

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