
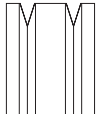





MIG Welding Parameter							Material Thickness			
Welding Material	Wire Type	Polarity	Wire Size	Drive Roller Type	Torch Liner	Shielding Gas	1.6mm	3.0mm	6.0mm	8.0mm
							Settings			
							Key: Voltage / Wirespeed			
Mild Steel	Gasless	Torch (-) Earth (+)	0.8mm	 Knurled Groove	Blue	N/A	2/2	6/6	10/10	-
			0.9mm		Red		1/2	5/6	7/8	10/10
	Solid Steel	Torch (+) Earth (-)	0.6mm	 'V' Groove	Blue	Mixed (Argon + CO ²)	4/6	-	-	-
			0.8mm				3/2	7/7	-	-
			0.9mm		Red		2/2	6/6	9/10	10/10

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.

Keep Tight!



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

Torch Parts



For torch parts, go to: weldclass.com.au/BZL25

Use chart as guide only, as optimal settings will vary with weld joint type and operator technique.
Cells left blank not recommended combination for effective welding results.

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.

Spool, Torch & Wire Set Up

Go to:
Weldclass.com.au/wire180

