

Air-Cooled Semi-Automatic MIG Torches

For Models

238CA, 347CA/PG, 354CA/PG, 407CA/PG, 454CA



INSTALLATION, OPERATIONS AND REPLACEMENT PARTS MANUAL

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INTRODUCTION

Thank you for purchasing an American Weldquip product. The American Weldquip product you have purchased has been carefully manufactured, assembled, and fully tested. This manual contains information on the installation, operation, maintenance, and replacement part breakdown. Please read, understand, and follow all safety instructions, warnings and procedures. Keep this manual handy for referencing installation, operation, maintenance, and part ordering information. While every precaution has been taken as to the accuracy in this manual, American Weldquip, Inc. assumes no responsibility for errors or omissions. American Weldquip, Inc. assumes no liability for damages resulting from the use of the information contained in this manual. American Weldquip, Inc. shall have no liability to the buyer for consequential damages or expenses by any defect whatsoever.

WARRANTY

AMERICAN WELDQUIP MIG guns and parts are warranted to be free of defects in material and/or workmanship for the period of time listed below. For any product found to be defective under normal use, AMERICAN WELDQUIP, INC. at our option, will repair, replace or issue a credit for the value of the defective product. All warranty claims must be submitted by the original purchaser. Use of non-genuine AMERICAN WELDQUIP parts and/or consumables may damage and/or severely limit the performance of the equipment which may limit or void any warranties. AMERICAN WELDQUIP, INC. will not assume responsibility for incidental damages or expenses related to any defect. This warranty does not cover damage caused by misuse or abuse, accident, alteration of product, improper installation, misapplication, lack of reasonable care and maintenance, unauthorized repairs or modifications, loss of use while at a repair facility or other conditions that are beyond the control of American Weldquip, Inc.

A Return Authorization Number (RA#) must be attained from the factory for any product being returned for Warranty Repair or Replacement. All returned product must be shipped freight prepaid by the sender. No- charge replacements, repaired products, or credit will be issued, once the returned product has been evaluated and warranty condition has been verified. If an immediate replacement is required before proper warranty evaluation, a purchase order number is required, and the goods will be invoiced. A credit will be issued once it is determined that a warranty condition exists.

STANDARD WARRANTY

All Semi-Automatic, Automatic, Robotic MIG TORCHES and Components	= 120 Days
MIG Torch Trigger Switches (Contacts only) -Excludes Smoke Extraction	= LIFETIME
Robotic Nozzle Cleaning Stations, Wire Cutter	= 90 Days
Robotic Peripherals, ArcSafe, Gun Mounts	= 90 Days
TIG POINT Tungsten Electrode Grinders	= 90 Days

LIMITED EXTENDED WARRANTY PROTECTION

This limited extended warranty protection expands coverage to loyal customers who use all GENUINE American Weldquip

consumables. Customers filing a claim under the extended warranty will need to prove, by providing past invoices, that they have been purchasing and using Genuine American Weldquip consumables.

All Semi-Automatic, Automatic, Robotic MIG TORCHES and Components	= 1 YEAR
MIG Torch Trigger Switches (Contacts only) -Excludes Smoke Extraction	= LIFETIME
MIG Torch Handles	= LIFETIME
Robotic Nozzle Cleaning Stations, Wire Cutter	= 90 Days
Robotic Peripherals, ArcSafe, Gun Mounts	= 90 Days
TIG POINT Tungsten Electrode Grinders	= 90 Days

CE – EU DECLARATION OF CONFORMITY

This product has met the requirements set by the EU directive and the products listed below are in conformity with the provisions of:

Council Directives - 2014/35/EC Low Voltage Equipment Safety

Council Directives - 2011/65/EU Restriction of the use of certain hazardous substances in electrical and electronic equipment (RoHs)

Harmonization Standard Used - IEC 60974-7:2013 Arc welding equipment – Part 7: Torches

260 Amp Mig Torch - 238CAXX
300 Amp Mig Torch - 347CAXX
350 Amp Mig Torch - 354CAXX
400 Amp Mig Torch - 407CAXX
400 Amp Mig Torch - 456CGXX
500 Amp Mig Torch - 500CGXX
500 Amp Mig Torch - 507CGXX
347 Amp Mig Torch - 347PGXX
407 Amp Mig Torch - 407PGXX

For EU Declaration of Conformity letter for this product please visit our website – www.weldquip.com or email us at technical@weldquip.com or call 330-239-0317.

SAFETY PRECAUTIONS – READ BEFORE USING

Before installing, operating or performing maintenance please read the safety precautions below. Failure to observe safety precautions can result in injury or death.

CALIFORNIA PROPOSITION 65 WARNINGS

This product, when used for welding and cutting, can produce fumes or gases which contain chemicals known to cause birth defects and cancer. (California Health & Safety Code Section 25249.5 et seq.)

EMF – ELECTRICAL AND MAGNETIC FIELDS MAY BE DANGEROUS

Electrical current flowing through any conductor causes localized Electric and Magnetic Fields (EMF). Welding current creates and EMF field around welding cables and welding machines.

WARNING - EMF fields may interfere with some pacemakers and other medical implants. Implanted medical device wearers should consult their doctor before operating or going near any arc welding applications. In addition, exposure to EMF fields in welding may have other unknown health effects.

Welders should use the below procedures to minimize the exposure to EMF fields from the welding circuit.

- 1) Route the cables close together. Secure by twisting, taping or using a cable cover to keep together.
 - 2) Never coil, wrap or drape welding cables around your body.
 - 3) Do not place your body between welding cables. Arrange so that cables are on one side and away from the operator.
 - 4) Connect the work clamp(ground) to the workpiece as close as possible to the area to be welded.
 - 5) Do not sit, lean and stand next to the welding power source.
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FUMES AND GASES CAN BE DANGEROUS



WARNING - WELDING AND CUTTING PRODUCE FUMES AND GASES THAT ARE HAZARDOUS TO YOUR HEALTH

- 1) Do not breathe the fumes and gases as they can cause asphyxiation.
 - 2) Fumes and gases generated from welding can cause severe injury to respiratory system and even death. In poorly vented areas it is required to properly ventilate the area and/or use local forced ventilation or other fume control equipment at the arc to remove welding and cutting fumes and gases.
 - 3) The recommended way to determine adequate ventilation is to sample for the composition and quantity of fumes and gases to which personnel are exposed. The worker exposure level should be checked initially and periodically thereafter to maintain applicable OSHA PEL and ACGIH TVL limits.
 - 4) In a poorly ventilated area, it is necessary to wear an approved air-supplied respirator.
 - 5) Always read and understand the Safety Data Sheets (SDSs) and the manufacturer's instructions for adhesives, coatings, cleaners, consumables, coolants, degreasers, fluxes and metals.
 - 6) Always have a trained watchperson nearby. Welding and cutting fumes and gases can displace air and lower the oxygen level causing injury or death. Be sure the breathing air is safe.
 - 7) Do not weld or cut in locations near degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapors to form highly toxic and irritating gases.
 - 8) Do not weld or cut on coated metals, such as galvanized, lead, or cadmium plated steel, unless the coating is removed from the weld area, the area is well ventilated, and while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes if welded.
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ELECTRIC SHOCK CAN KILL



WARNING - ELECTRICAL SHOCK CAN KILL. DO NOT TOUCH LIVE ELECTRICAL PARTS AND/OR USE IN DAMP LOCATIONS.

- 1) The electrode and work (ground) circuit is electrically “HOT” whenever the welding equipment is on. Do not touch these electrically live parts with your bare skin or wet/damp clothing. Wear dry, hole-free gloves. Incorrectly installed or improperly grounded equipment is a hazard.
- 2) Insulate yourself from work and ground using dry insulating mats or covers big enough to prevent any physical contact with the work or ground.
- 3) Additional safety precautions are required when any of the following electrically hazardous conditions are present: in damp locations or while wearing wet clothing; on metal structures such as floors, gratings or scaffolds; when in cramped positions such as sitting, kneeling or lying; or when there is a high risk of unavoidable or accidental contact with the workpiece or ground. For these conditions, use the following equipment in order presented: 1) a semi-automatic DC constant voltage, 2) a DC manual (stick) welder or 3) an AC welder with reduced open-circuit voltage. In most situations, use of a DC, constant voltage wire welder is recommended and do not work alone!
- 4) Disconnect input power or stop engine before installing or servicing this equipment. Lockout/tag out input power according to OSHA 29 CFR 1910.147 (see Safety Standards).
- 5) Properly install ground and operate this equipment according to its Owner’s Manual and national, state/provincial and local codes.
- 6) Always verify the supply ground. Make sure that input power cord ground wire is properly connected to ground terminal in disconnect box or that cord plug is connected to a properly grounded receptacle outlet.
- 7) Keep cords dry, free of oil and grease and protected from hot metal and sparks.
- 8) Frequently inspect input power cord for damage or bare wiring. Replace cord immediately if damaged. Bare wiring can kill.
- 9) Turn off all equipment when not in use.
- 10) Do not use worn, damaged, undersized or poorly spliced cables. It is illegal to use electrical tape to repair torch power cable or ground cable that has damaged outer insulation. The cable must be replaced.
- 11) Do not drape cables over your body.
- 12) Do not touch electrode if you are in contact with the work, ground or another electrode from a different machine.
- 13) Do not touch electrode holders connected to two welding machines at the same time since double open circuit voltage will be present.
- 14) Use only well-maintained equipment. Repair or replace damaged parts at once. Maintain unit according to manual.
- 15) Wear a safety harness if working above floor level.
- 16) Keep all panels and covers securely in place.
- 17) Clamp work cable with good metal-to-metal contact to workpiece or worktable as near the weld as practical.
- 18) Do not connect more than one electrode or work cable to any single weld output terminal. Disconnect cable for process when not in use.

ARC RAYS HAZARDS



WARNING – A WELDING ARC EMITS ULTRAVIOLET (UV) AND OTHER RADIATION AND CAN CAUSE SERIOUS INJURY TO UNPROTECTED SKIN AND EYES.

- 1) Use a shield with the proper filter and cover plates to protect your eyes from sparks and the rays of the arc when welding or observing open arc welding. Headshield and filter lens should conform to ANSI Z87. 1 standards.
 - 2) Use suitable clothing made from durable flame-resistant material to protect your skin and that of your helpers from the arc rays.
 - 3) Protect other nearby personnel with suitable, non-flammable screening and/or warn them not to watch the arc nor expose themselves to the arc rays or to hot spatter or metal.
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WELDING AND CUTTING CAN CAUSE FIRE OR EXPLOSION



WARNING – Welding and cutting produces sparks that fly off from the arc and can cause fires and/or explosions.

- 1) Welding or cutting on closed containers, such as tanks, drums or pipes can cause them to blow up. Sparks can fly off from the welding or cutting arc. The flying sparks, hot work piece, and hot equipment can cause fires and burns.
 - 2) Accidental contact of electrode to metal objects can cause sparks, explosion, overheating or fire. Check and be sure the area is safe before doing any welding or cutting.
 - 3) Do not weld or cut where flying sparks can strike flammable material.
 - 4) Remove all flammables and fire hazards from the welding area. If this is not possible, tightly cover them with approved covers to prevent the welding sparks from starting a fire.
 - 5) When not welding, make certain no part of the electrode circuit is touching the work or ground. Accidental contact can cause overheating and create a fire hazard.
 - 6) Be alert that welding sparks and hot materials from welding and cutting can easily go through small cracks and openings and cause a fire in the adjacent areas.
 - 7) Follow requirements in OSHA 1910.252 (a) (2) (iv) and NFPA 51B for hot work and have a fire watcher and extinguisher nearby.
 - 8) Do not heat, cut or weld tanks, drums or containers that have held combustibles until the proper steps have been taken to ensure that such procedures will not cause flammable or toxic vapors from substances inside. They can cause an explosion even though they have been “cleaned”. For information, purchase “Recommended Safe Practices for the Preparation for Welding and Cutting of Containers and Piping That Have Held Hazardous Substances”, AWS F4.1 from the American Welding Society.
 - 9) Do not weld or cut where the atmosphere may contain flammable dust, gas, or liquid vapors (such as gasoline).
 - 10) Sparks and spatter are thrown from the welding arc. Wear oil free protective garments such as leather gloves, heavy shirt, cuffless trousers, high shoes and a cap over your hair. Wear ear plugs when welding out of position or in confined places. Always wear safety glasses with side shields when in a welding area.
 - 11) Connect work cable to the work as close to the welding or cutting area as practical to prevent welding or cutting current from traveling long, possibly unknown paths and causing electric shock, sparks and fire hazards.
 - 12) Do not use welder to thaw frozen pipes.
 - 13) Remove any combustibles, such as a butane lighter or matches, from your person before doing any welding or cutting.
 - 14) Inspect area to ensure it is free of sparks, glowing embers, and flames after work is complete.
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CYLINDERS CAN EXPLODE IF DAMAGED



WARNING – Compressed gas cylinders contain gas under high pressure and/or flammable gas. If damaged, the cylinder can explode.

- 1) Use only compressed gas cylinders containing the correct shielding gas for the process used and properly operating regulators designed for the gas and pressure used. All hoses, fittings, etc. should be suitable for the application and maintained in good condition.
- 2) Always keep cylinders in an upright position securely chained to an undercarriage or fixed support.
- 3) Cylinders should be located away from areas where they may be struck or subjected to physical damage and a safe distance from arc welding or cutting operations and any other source of heat, sparks, or flame.
- 4) Never allow the electrode, electrode holder or any other electrically “hot” parts to touch a cylinder.
- 5) Keep your head and face away from the cylinder valve outlet when opening the cylinder valve.
- 6) Valve protection caps should always be in place and hand tight except when the cylinder is in use or connected for use.
- 7) Read and follow the instructions on compressed gas cylinders, associated equipment, and CGA publication P-1, “Precautions for Safe Handling of Compressed Gases in Cylinders,” available from the Compressed Gas Association, 14501 George Carter Way Chantilly, VA 20151.

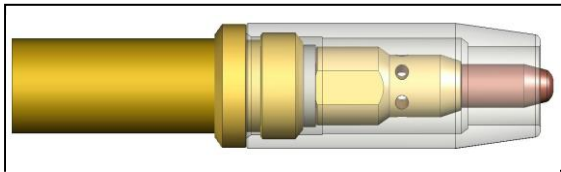
TORCH SPECIFICATIONS

MODEL	AMPERAGE	60% Duty Cycle		100% Duty Cycle	
		CO2	Mixed Gas	CO2	Mixed Gas
238CA	260	260A	230A	230A	210A
347CA	300	300A	270A	270A	250A
354CA	350	350A	320A	315A	300A
407CA	400	400A	350A	350A	325A

Duty Cycle is based on a complete cycle time of 10 minutes. (60% Duty Cycle = 6 minutes weld time, 4 minutes off time).

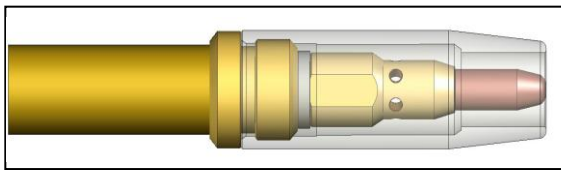
NOZZLE/TIP RELATIONSHIPS

Shown below are typical relationship between the contact tip and nozzle in GMAW Semi-Automatic applications. Nozzles to tip relationships are usually dictated by the process and application but not necessarily the standard. Keep in mind that decreased tip life, increased spatter cleaning cycles may be required if the tip relationship is changed to achieve other objectives.



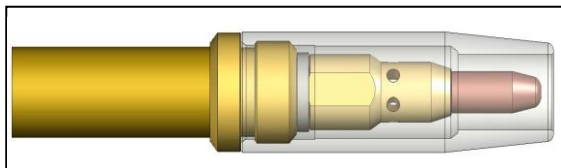
Extended Tip – Short Circuit (Short Arc, Dip Transfer) Welding Applications

The tip stick out is usually 1/8" or 1/4" from the nozzle. Keep in mind that the further the stick out the more susceptible to gas porosity issues. Typically, this used in short circuit, lower amperage applications, and/or where you may need to reach in to a corner.



Flush Tip – Higher current Short Circuit (Short Arc, Dip Transfer) Welding Applications

The tip is flush with the end of the nozzle. Typically used in higher current and voltage short circuit applications.



Recessed Tip – Spray Arc, Pulsed, Flux Core Welding Applications

The tip is usually recessed in the nozzle 1/8" or 1/4". Usually, the higher the heat and/or current the further the recess. However, this is also dependant on the wire used and the arc length requirement.

INSTALLATION

Depending on how your torch was ordered, your American Weldquip torch has been supplied with either a EURO type feeder connection or a DIRECT wire feeder connection. The American Weldquip torch can be installed to the wire feed unit in two ways.

Euro Connection – Feeder Adaptor Kit may be required

Direct Connection

Direct Connect

The direct connect torch system is designed for installation to the wire feeder without the need for any adaptor system. The torch is supplied (depending on the torch configuration ordered) with a feeder connection plug at the rear of the torch, gas connection, feeder control cable.

- 1) Fully insert the torch Direct Connection into wire feeder. Tighten screw or other method on wire feeder to secure torch
- 2) Connect the gas hose to barbed fitting on the direct connect pin if required.
- 3) Connect feeder control cable/plug to torch.
- 4) Connect feeder control cable/plug to the feeder.
- 5) Feed welding wire into the torch and tighten drive rolls.

WARNING: WHEN FEEDING WELD WIRE THROUGH THE TORCH KEEP THE FRONT END OF THE TORCH POINTED AWAY FROM ANY PERSON OR OBJECT. DO NOT POINT AT FACE, HANDS ETC. FAILURE TO DO SO WILL RESULT IN BODILY INJURY AND POSSIBLY DEATH.

Using Feeder Adaptor Kit

In some cases, it may be desirable to use a feeder adaptor kit such as when using different manufactures wire feed units to commonize on a torch configuration.

- 1) Thread feeder adaptor plug into the adaptor block and tighten.
- 2) Insert the adaptor guide tube into the adaptor plug.
- 3) Fully insert the feeder adaptor assembly into the wire feeder. Tighten screw or other method on wire feeder to secure the adaptor assembly.
- 4) If required, connect the feeder control cable/plug to the wiring on the adaptor assembly.
- 5) Connect feeder control cable/plug to the feeder.
- 6) Connect the torch to the feeder adaptor assembly.
- 7) Feed welding wire into the torch and tighten drive rolls.

WARNING: WHEN FEEDING WELD WIRE THROUGH THE TORCH KEEP THE FRONT END OF THE TORCH POINTED AWAY FROM ANY PERSON OR OBJECT. DO NOT POINT AT FACE, HANDS ETC. FAILURE TO DO SO WILL RESULT IN BODILY INJURY AND POSSIBLY DEATH.

MAINTENANCE

Liner Replacement

The standard liner requires the torch be removed from the feeder in order to be changed.

Standard Liner Maintenance

Warnings – To avoid accidental injury ensure power supply and wire feed unit is turned off.

- 1) Trim the end of the weld wire at contact tip.
- 2) Retract or completely remove weld wire so torch can be removed from the wire feeder.
- 3) Remove the nozzle, contact tip and diffuser.
- 4) Loosen the set screw at the torch feeder connection using a 5/64" Allen wrench.
- 5) Making sure the torch cable is straight, grasp the liner at the rear of the torch with a pair of pliers and remove.
- 6) Carefully feed the new liner into the torch using short strokes to avoid kinking. You may need to twist the liner for easier insertion.
- 7) Tighten the set screw to secure the liner in the torch.
- 8) Reinstall the torch to the wire feed unit.
- 9) **IMPORTANT:** at the front end of the torch, push the liner back into the gun and hold in place.
- 10) Trim the liner to 3/4" stick out from the end of the gooseneck.
- 11) Replace the Diffuser, contact tip and nozzle.
- 12) Feed welding wire into the torch and tighten drive rolls.

WARNING: WHEN FEEDING WELD WIRE THROUGH THE TORCH KEEP THE FRONT END OF THE TORCH POINTED AWAY FROM ANY PERSON OR OBJECT. DO NOT POINT AT FACE, HANDS ETC. FAILURE TO DO SO WILL RESULT IN BODILY INJURY AND POSSIBLY DEATH.

Gooseneck Replacement

- 1) Secure Gooseneck in a vice.
- 2) Remove the liner from the torch.

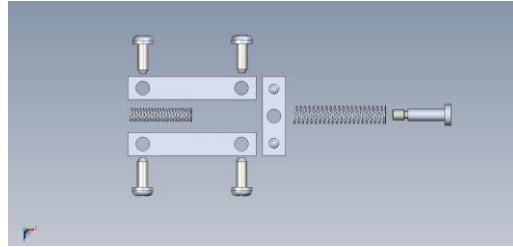
- 3) Remove the four handle screws and separate the handle assembly.
- 4) Using a wrench loosen the gooseneck / cable connection and remove from the cable assembly.
- 5) Remove the Body Insulator from the old gooseneck and install on the new one.
- 6) Thread the new gooseneck on to the cable assembly and tighten.
- 7) Install the bottom handle assembly (trigger side) onto the gooseneck/cable assembly. The trigger wires will fit through the hole on the bottom of the body insulator. Make sure the insulator is fully inserted into the bottom handle.
- 8) Slide the handle spring or cable support up and insert in the rear of the handle.
- 9) Install the top handle and secure with the (4) screws. **IMPORTANT:** Ensure the trigger wires are not pinched between the handle.
- 10) Reinstall the diffuser, contact tip and nozzle.

Trigger Switch Replacement

CA SERIES TORCHES

The new Trigger Switch Assembly contains –

- 1ea. Trigger Paddle
- 2ea. Springs
- 4ea. Screws – for 2 outer contacts.
- 1ea. Shoulder Screw
- 2ea. Copper Outer Contact Plates
- 1ea. Copper Contact Plate



- 1) Secure Gooseneck in a vice.
- 2) Remove the four handle screws and separate the handle assembly.
- 3) Remove the trigger paddle shoulder screw and spring securing the center copper blade to the trigger paddle. If using the extended trigger, there are two screws that secure the trigger paddle and must be removed.
- 4) Remove the (4) screws securing the copper contact assemblies and remove the trigger leads and contacts.
- 5) Using a screwdriver, gently push from the inside of the handle on the trigger paddle where it attaches to the handle and remove the trigger paddle and return spring.
- 6) Insert the return spring (the smaller diameter spring) into the seat on the bottom handle assembly.
- 7) Carefully insert the new trigger paddle into the handle assembly and tap the paddle in on the pivot point in the handle. The Trigger should snap in place.
- 8) Place the copper cross contact on the shoulder screw, then install the remaining spring over the screw, and thread into the trigger paddle until tight. **DO NOT OVER TIGHTEN.**
- 9) Using the (4) four screw provided attach the (2) two outer contact plates and install the (2) two trigger leads under the front contact plate screws.
- 10) Install the bottom handle assembly (trigger side) onto the gooseneck/cable assembly. The trigger wires will fit in the hole on the bottom of the body insulator. Make sure the trigger wires stay seated in the body insulator and the insulator is fully inserted into the bottom handle.
- 11) Slide the handle spring or cable support up and insert in the rear of the handle.
- 12) Install the top handle and secure with the (4) four screws provided. **IMPORTANT:** Ensure the trigger wires are not pinched between the handle.

PG – PISTOL GRIP SERIES TORCHES

- 1) Secure Gooseneck in a vice.
- 2) Remove the six (6) handle screws and separate the handle assembly.
- 3) Remove the trigger from the handle half and remove the trigger wires.
- 4) Reinstall the trigger wires on the new switch assembly.
- 5) Reinstall the trigger assembly inside the handle half.
- 6) Install the top handle half to the bottom handle half. **IMPORTANT:** Ensure the trigger wires are not pinched between the handle.
- 7) Reinstall the six (6) handle screws and tighten.

Unicable Replacement

- 1) Secure Gooseneck in a vice.
- 2) Remove the liner from the torch.
- 3) Remove the four handle screws and separate the handle assembly.
- 4) Using a wrench loosen the gooseneck / cable connection and remove from the cable assembly.
- 5) Thread the gooseneck on to the new cable assembly and tighten.
- 6) Install the bottom handle assembly (trigger side) onto the gooseneck/cable assembly. The trigger wires will fit in the hole on the bottom of the body insulator. Make sure the trigger wires stay seated in the body insulator and the insulator is fully inserted into the bottom handle.

- 7) Slide the handle spring or cable support up and insert in the rear of the handle.
- 8) Install the top handle and secure with the (4) screws. **IMPORTANT:** Ensure the trigger wires are not pinched between the handle.
- 9) Reinstall the diffuser, contact tip and nozzle.
- 10) On the rear of the old cable assembly turn and remove the spring guard hand nut and slide back on the cable.
- 11) Remove the screw securing the handle to the feeder pin adaptor and separate the handle.
- 12) Unthread the power cable from the feeder adaptor block.
- 13) Slide the threaded rear handle support nut and rear spring onto the new cable assembly.
- 14) Thread the power cable to the feeder pin adaptor and tighten.
- 15) Install the trigger wire using (2) butt splices.
- 16) Install the bottom handle assembly onto the feeder adaptor assembly.
- 17) Carefully route the trigger lead thru the opening in the handle half. Make sure the trigger wires are not pinched between the handle halves.
- 18) Install the other handle half and screw the rear handle support nut and rear spring on the rear handle assembly.
- 19) Install the screw on the rear handle and feeder adaptor.
- 20) Reinstall the liner.

DAILY MAINTENANCE

A few minutes per day performing a quick check of your mig torch will help to decrease weld problems, minimize downtime, and help increase consumable life.

At Beginning of Shift

- Inspect the cable for cuts, nicks or tears. If you can see bare copper return for maintenance.
- Inspect the front-end consumables. Clean weld spatter and inspect the nozzle insulator. If nozzle insulation is damaged is should be replaced.
- Check that the gas diffuser is tight on the gooseneck.
- Check the gas holes on the diffuser and clean if necessary.
- Check and tighten the contact tip.
- Check all electrical connections including the power cable from the power supply, torch/feeder connections, and control cables for loose connections. Tighten if necessary. Loose connections can cause overheating of cables and/or loss of electrical power.

OPTIONS

<u>Part Number</u>	<u>Description</u>
75000009	Gun Hanger
75000007-ET	Extended Trigger – Includes bottom Handle Half
75000030	Heat Shield

NOZZLE SELECTION CHART

300 SERIES NOZZLES

PART #	DESCRIPTION	BORE SIZE	MATERIAL	BORE ID		INSULATOR REQUIRED
				DIMENSION	O.A.L.	
75133801	NOZZLE - CONICAL	3/8" (9.5mm)	NI PLATED BRASS	.375" (9.5mm)	2.820" (71.6mm)	NONE REQ.
75133802	NOZZLE - BOTTLE NOSE	3/8" (9.5mm)	NI PLATED BRASS	.375" (9.5mm)	2.820" (71.6mm)	NONE REQ.
75135601-I	NOZZLE - CONICAL	9/16" (14.2mm)	NI PLATED BRASS	.593" (15.1mm)	2.820" (71.6mm)	INSTALLED
75135002-I	NOZZLE - TAPERED	1/2" (12.7mm)	NI PLATED BRASS	.500" (12.7mm)	2.820" (71.6mm)	INSTALLED
75135003-I	NOZZLE - TAPERED	1/2" (12.7mm)	NI PLATED BRASS	.500" (12.7mm)	2.672" (67.96mm)	INSTALLED
75135602-I	NOZZLE - CONICAL	9/16" (14.2mm)	NI PLATED BRASS	.593" (15.1mm)	2.545" (64.6mm)	INSTALLED
75135004	NOZZLE - CONICAL SHORT	1/2" (12.7mm)	NI PLATED BRASS	.500" (12.7mm)	1.937" (49.2mm)	NONE REQ.

400 SERIES NOZZLES

PART #	DESCRIPTION	BORE SIZE	MATERIAL	BORE		INSULATOR REQUIRED
				ID DIMENSION	O.A.L.	
75146201-I	NOZZLE - BOTTLE NOSE	5/8" (15.9mm)	NI PLATED BRASS	.625" (15.9mm)	3.125" (79.4mm)	INSTALLED
75145001	NOZZLE - BOTTLE NOSE	1/2" (12.7mm)	NI PLATED BRASS	.500" (12.7mm)	3.031" (77.0mm)	75001733
75146202	NOZZLE - CONICAL	5/8" (15.9mm)	NI PLATED BRASS	.625" (15.9mm)	3.125" (79.4mm)	75001738
75146202C	NOZZLE - CONICAL	5/8" (15.9mm)	NI PLATED COPPER	.625" (15.9mm)	3.125" (79.4mm)	75001738
75146202CU	NOZZLE - CONICAL	5/8" (15.9mm)	BARE COPPER	.625" (15.9mm)	3.125" (79.4mm)	75001738
75145601-I	NOZZLE - TAPERED	9/16" (14.2mm)	NI PLATED BRASS	.563" (14.2mm)	3.125" (79.4mm)	INSTALLED
75145002C	NOZZLE - TAPERED	1/2" (12.7mm)	NI PLATED COPPER	.531" (13.5mm)	3.125" (79.4mm)	75001738
75145002CU	NOZZLE - TAPERED	1/2" (12.7mm)	BARE COPPER	.531" (13.5mm)	3.125" (79.4mm)	75001738
75145003	NOZZLE - TAPERED (LONG)	1/2" (12.7mm)	NI PLATED BRASS	.500" (12.7mm)	3.915" (99.4mm)	NONE REQ.
75146501S	NOZZLE - SPOT	5/8" (15.9mm)	NI PLATED BRASS	.656" (16.7mm)	3.437" (87.3mm)	75001738
75146204-I	NOZZLE - CONICAL	5/8" (15.9mm)	NI PLATED BRASS	.625" (15.9mm)	2.820" (71.6mm)	INSTALLED
75146204CU	NOZZLE - CONICAL	5/8" (15.9mm)	BARE COPPER	.625" (15.9mm)	2.820" (71.6mm)	75001738
75145602-I	NOZZLE - SMALL CONICAL	9/16" (14.2mm)	NI PLATED BRASS	.593" (15.1mm)	2.820" (71.6mm)	INSTALLED
75144301-I	NOZZLE - TAPERED	7/16" (11.1mm)	NI PLATED BRASS	.438" (11.1mm)	2.820" (71.6mm)	INSTALLED
75145004	NOZZLE - BOTTLE NOSE	1/2" (12.7mm)	NI PLATED BRASS	.500" (12.7mm)	3.125" (79.4mm)	75001733
75146205-I	NOZZLE - CONICAL	5/8" (15.9mm)	NI PLATED BRASS	.625" (15.9mm)	3.031" (77.0mm)	INSTALLED
75146205CU	NOZZLE - TAPERED	5/8" (15.9mm)	BARE COPPER	.625" (15.9mm)	3.031" (77.0mm)	75001738
75146206-I	NOZZLE - SHORT CONICAL	5/8" (15.9mm)	NI PLATED BRASS	.625" (15.9mm)	1.875" (47.6mm)	INSTALLED
75146207-I	NOZZLE - SHORT CONICAL	5/8" (15.9mm)	NI PLATED BRASS	.625" (15.9mm)	2.187" (55.6mm)	INSTALLED
75147501	NOZZLE - CYLINDRICAL	3/4" (19.0mm)	NI PLATED BRASS	.703" (17.9mm)	3.125" (79.4mm)	75001738
75147501CU	NOZZLE - CYLINDRICAL	3/4" (19.0mm)	BARE COPPER	.703" (17.9mm)	3.125" (79.4mm)	75001738
75145603-I	NOZZLE - SHORT TAPERED	9/16" (14.2mm)	NI PLATED BRASS	.563" (14.2mm)	2.375" (60.3mm)	INSTALLED
75145005	NOZZLE - BOTTLE NOSE	1/2" (12.7mm)	NI PLATED BRASS	.500" (12.7mm)	2.820" (71.6mm)	75001733
75144302-I	NOZZLE - TAPERED	7/16" (11.1mm)	NI PLATED BRASS	.438" (11.1mm)	3.125" (79.4mm)	INSTALLED

500 SERIES NOZZLES

PART #	DESCRIPTION	BORE SIZE	MATERIAL	BORE		INSULATOR REQUIRED
				ID DIMENSION	O.A.L.	
75156201	NOZZLE - TAPERED	9/16" (14.2mm)	NI PLATED BRASS	.563" (14.2mm)	2.670" (67.8mm)	175001740
75156201-I	NOZZLE - TAPERED	9/16" (14.2mm)	NI PLATED BRASS	.563" (14.2mm)	2.670" (67.8mm)	INSTALLED
75157501	NOZZLE - CONICAL	3/4" (19.0mm)	NI PLATED BRASS	.703" (17.9mm)	3.187" (81.0mm)	75001740
75157501-I	NOZZLE - CONICAL	3/4" (19.0mm)	NI PLATED BRASS	.703" (17.9mm)	3.187" (81.0mm)	INSTALLED

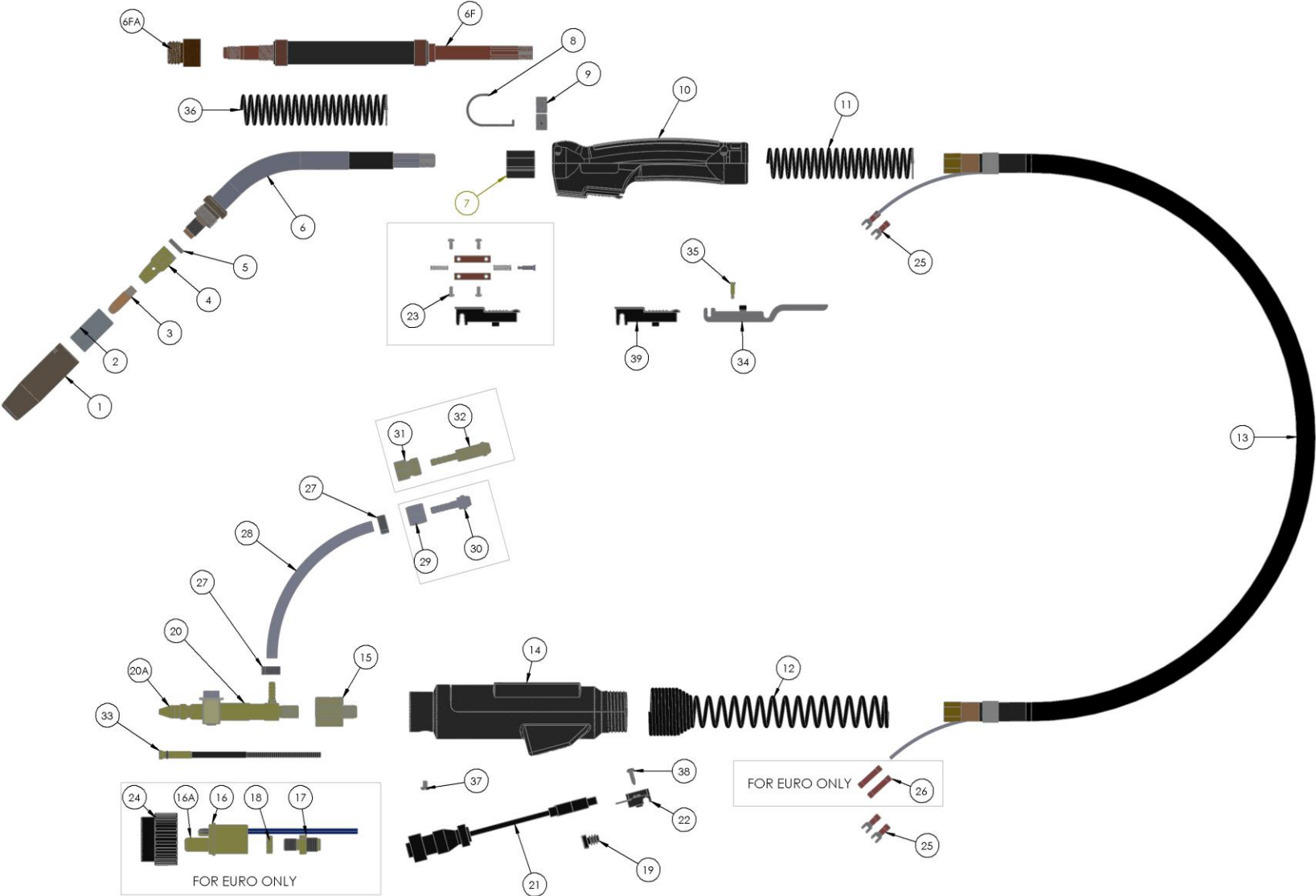
CONTACT TIP SELECTION CHART

M6 CONTACT TIPS			
PART #	WIRE SIZE	NOMINAL I.D.	DESCRIPTION
<u>COPPER (CU)</u>			
75023511	.023" (.6mm)	.034"	CONTACT TIP (STANDARD)
75030511	.030" (.8mm)	.038"	CONTACT TIP (STANDARD)
75035511	.035" (.9mm)	.044"	CONTACT TIP (STANDARD)
75035512	.040" (1mm)	.048"	CONTACT TIP (STANDARD)
75045511	.045" (3/64") (1.2mm)	.053"	CONTACT TIP (STANDARD)
75045512	.045" (3/64") (1.2mm)	.059"	CONTACT TIP (STANDARD)
<u>M8 CONTACT TIPS</u>			
PART #	WIRE SIZE	NOMINAL I.D.	DESCRIPTION
<u>COPPER (CU)</u>			
75030014	.030" (.8mm)	.038"	CONTACT TIP (STANDARD)
75035014	.035" (.9mm)	.044"	CONTACT TIP (STANDARD)
75040014	.040" (1.0mm)	.048"	CONTACT TIP (STANDARD)
75045014	.045" (3/64") (1.2mm)	.054"	CONTACT TIP (STANDARD)
75052014	.052" (1.3mm)	.061"	CONTACT TIP (STANDARD)
75062014	.062" (1/16") (1.6mm)	.073"	CONTACT TIP (STANDARD)
75062015	.062" (1/16") (1.6mm)	.076"	CONTACT TIP (STANDARD)
75078014	.078" (5/64") (2.0 mm)	.087"	CONTACT TIP (STANDARD)
75093014	.093" (3/32") (2.4mm)	.106"	CONTACT TIP (STANDARD)
<u>M8 HRT – EXTENDED LIFE CONTACT TIPS</u>			
PART #	WIRE SIZE	NOMINAL I.D.	DESCRIPTION
20030400	.030" (.8mm)	.037"	.315 OD CONTACT TIP
20035400	.035" (.9MM)	.041"	.315 OD CONTACT TIP
20040400	.040" (1.0mm)	.050"	.315 OD CONTACT TIP
20045400	.045" (3/64") (1.2mm)	.054"	.315 OD CONTACT TIP
20035500	.035" (.9mm)	.044"	.395 OD CONTACT TIP
20040500	.040" (1.0mm)	.050"	.395 OD CONTACT TIP
20045500	.045" (3/64") (1.2mm)	.054"	.395 OD CONTACT TIP
20052500	.052" (1.3mm)	.061"	.395 OD CONTACT TIP
20062500	.062" (1/16") (1.6mm)	.073"	.395 OD CONTACT TIP

LINER SELECTION CHART

PART #	DESCRIPTION
75010215T	.023-.030 LINER, 10FT – T STYLE
75015215T	.023-.030 LINER, 15FT – T STYLE
75010222T	.035-.045 LINER, 10FT – T STYLE
75015222T	.035-.045 LINER, 15FT – T STYLE
75025222T	.035-.045 LINER, 25FT – T STYLE
75010228T	.045-1/16 LINER, 10FT – T STYLE
75015228T	.045-1/16 LINER, 15FT – T STYLE
75025228T	.045-1/16 LINER, 25FT – T STYLE
75010229T	5/64-3/32 LINER, 10FT – T STYLE
75015229T	5/64-3/32 LINER, 15FT – T STYLE
75025229T	5/64-3/32 LINER, 25FT – T STYLE

PARTS BREAKDOWN – 238, 347, 407, 454



NO.	DESCRIPTION	238	347	354	407	454
1	CONICAL NOZZLE	SEE NOZZLE SELECTION CHART PAGE 10				
	TAPERED NOZZLE	SEE NOZZLE SELECTION CHART PAGE 10				
	BOTTLENOSE NOZZLE	SEE NOZZLE SELECTION CHART PAGE 10				
2	NOZZLE INSULATOR	SEE NOZZLE SELECTION CHART PAGE 10				
3	CONTACT TIP	SEE CONTACT TIP SELECTION CHART PAGE 11				
4	GAS DIFFUSER, STANDARD	75002007	75002007	75004033	75004033	75004033
	GAS DIFFUSER, SHORT	75002007S	75002007S	75004033S	75004033S	75004033S
	GAS DIFFUSER, LONG	75002007L	75002007L	75004033L	75004033L	75004033L
	GAS DIFFUSER, X-LONG	75002007XL	75002007XL	75004033XL	75004033XL	75004033XL
5	INSULATING WASHER	75001003	75001005	75001004	75001004	75001004
6	GOOSENECK, 60 DEGREE – CA SERIES	75003004	75004004	75004354	75004036	75004454
	GOOSENECK, 45 DEGREE- CA SERIES	75003003	75004003	75004354-45	75004035	75004454-45
	GOOSENECK, 180 DEGREE- PGRIP	N/A	75003051	75003051	75004051	N/A
	GOOSENECK, 22 DEGREE- PGRIP	N/A	75003052	75003052	75004052	N/A
	GOOSENECK, 45 DEGREE- PGRIP	N/A	75003053	75003053	75004053	N/A
6F	FLEX NECK (COMES WITH 6FA & 7)	N/A	N/A	750CAFLEX	750CAFLEX	750CAFLEX
6FA	FLEX NECK NOZZLE SEAT (REQUIRED)	N/A	N/A	75077FLX	75077FLX	75077FLX
7	BODY INSULATOR	75003002	75003002	75003002	75003002	75003002
8	GUN HANGER HOOK	75000009	75000009	75000009	75000009	75000009
9	GUN HANGER BRACKET	75000030C	75000030C	75000030C	75000030C	75000030C
10	HANDLE ASSEMBLY – STD.	75000003	75000003	75000003	75000003	75000003
	HANDLE ASSEMBLY – PISTOL GRIP	N/A	75000003P	75000003P	75000003P	N/A
	HANDLE ASSEMBLY – EXT. TRIGGER	75000003-ET	75000003-ET	75000003-ET	75000003-ET	75000003-ET
	HANDLE TOP – STD.	75000006	75000006	75000006	75000006	75000006
	HANDLE TOP – DUAL SCHEDULE	N/A	75000006-SW	75000006-SW	75000006-SW	75000006-SW
	HANDLE BOTTOM – STD.	75000007	75000007	75000007	75000007	75000007
	HANDLE BOTTOM – EXT. TRIGGER	75000007-ET	75000007-ET	75000007-ET	75000007-ET	75000007-ET
	HANDLE SCREWS – STD (4 REQUIRED)	75000008	75000008	75000008	75000008	75000008
	HANDLE SCREW- PGRIP (6 REQUIRED)	N/A	75000008P	75000008P	75000008P	N/A
NS	SWITCH ASSY – DUAL SCHEDULE	N/A	75000017	75000017	75000017	75000017
NS	SWITCH ASSY. – MULTI-SCHEDULE	N/A	75000018	75000018	75000018	75000018
NS	DS/MS SWITCH CONNECTORS	N/A	75077018	75077018	75077018	75077018
11	FRONT SUPPORT SPRING	75002005	75002005	75002005	75002005	75002005
12	REAR SUPPORT SPRING	75002019	75002019	75002019	75002019	75002019
13	10' POWER CABLE	75010207	75010307	75010307	75010407	75010407
	12' POWER CABLE	75012207	75012307	75012307	75012407	75012407
	15' POWER CABLE	75015207	75015307	75015307	75015407	75015407
	20' POWER CABLE	75020207	75020307	75020307	75020407	75020407
	25' POWER CABLE	75025207	75025307	75025307	75025407	75025407
14	REAR ADAPTOR SUPPORT	75077006	75077006	75077006	75077006	75077006
15	DIR CON ADAPT BLK	37077003	37077003	37077003	37077003	37077003
15F	DIR CON ADAPT BLK – FRONIUS KIT (INCLUDES 20,20A FRONIUS VERSION)	37677710	37677710	37677710	37677710	37677710
16	EURO BLOCK	37030001	37030001	37030001	37030001	37030001
16A	EURO BLOCK RETAINING NUT	37077005	37077005	37077005	37077005	37077005
17	ADAPTOR SCREW	75001151	75001151	75001151	75001151	75001151
18	LOCK NUT	75001029	75001029	75001029	75001029	75001029
19	HOLE PLUG	38000003	38000003	38000003	38000003	38000003

NO.	DESCRIPTION	238	347	354	407	454
20	DIR CON FEEDER PLUG					
	MILLER	37577705	37577705	37577705	37577705	37577705
	OTC / DAIHEN	37577700	37577700	37577700	37577700	37577700
	OTC DP SERIES	37577701	37577701	37577701	37577701	37577701
	LINCOLN LN7	37577832	37577832	37577832	37577832	37577832
	PANASONIC	37577999	37577999	37577999	37577999	37577999
	TWECO #4	37577699	37577699	37577699	37577699	37577699
	TWECO #5	37577930	37577930	37577930	37577930	37577930
	FRONIUS	37577706	37577706	37577706	37577706	37577706
20A	CAP - MILLER FEEDER PIN	37577705-N	37577705-N	37577705-N	37577705-N	37577705-N
	CAP - OTC FEEDER PIN	38277001-N078	38277001-N078	38277001-N078	38277001-N078	38277001-N078
	CAP – EURO	37077005	37077005	37077005	37077005	37077005
	CAP – FRONIUS FEEDER PIN	37577706-N	37577706-N	37577706-N	37577706-N	37577706-N
NS	O-RING- MILLER PIN	37577102	37577102	37577102	37577102	37577102
NS	O-RING- TWECO #4 PIN	37677102	37677102	37677102	37677102	37677102
NS	O-RING- TWECO #5 PIN	75000021	75000021	75000021	75000021	75000021
21	CONTROL CABLE, MILLER	37777501	37777501	37777501	37777501	37777501
	CONTROL CABLE, LINCOLN	37777505	37777505	37777505	37777505	37777505
	CONTROL CABLE, OTC	37777503	37777503	37777503	37777503	37777503
	CONTROL CABLE, TWECO	37777500	37777500	37777500	37777500	37777500
22	CABLE CONNECTOR	38000001	38000001	38000001	38000001	38000001
23	TRIGGER SWITCH ASSY-STD.	75000004	75000004	75000004	75000004	75000004
NS	TRIGGER SWITCH ASSY- PISTOL GRIP	N/A	75000011P	75000011P	75000011P	N/A
24	EURO ADAPT NUT	75077014	75077014	75077014	75077014	75077014
25	TRIGGER WIRE CONNECTOR	75077024	75077024	75077024	75077024	75077024
26	BUTT SPLICE	75077066	75077066	75077066	75077066	75077066
27	7/16 HOSE CLAMP	38577108	38577108	38577108	38577108	38577108
28	GAS HOSE PER FOOT	38577087	38577087	38577087	38577087	38577087
29	TYPE B GAS NUT	38677145	38677145	38677145	38677145	38677145
30	TYPE B GAS NIPPLE	38677144	38677144	38677144	38677144	38677144
31	INERT GAS NUT	38677141	38677141	38677141	38677141	38677141
32	INERT GAS NIPPLE	38677142	38677142	38677142	38677142	38677142
33	LINER	SEE LINER SELECTION CHART PAGE 11				
34	EXTENDED TRIGGER PADDLE	75000005-E	75000005-E	75000005-E	75000005-E	75000005-E
35	EXTENDED TRIGGER SCREW	75000013	75000013	75000013	75000013	75000013
36	THERMAL SPRING – GOOSENECK <i>(Optional)</i>	75002010	75002010	75002010	75002010	75002010
37	ADAPTOR SCREW	75077011	75077011	75077011	75077011	75077011
38	CONNECTING SCREW	38000002	38000002	38000002	38000002	38000002
39	TRIGGER PADDLE	75000042	75000042	75000042	75000042	75000042

Notes:



AMERICAN WELDQUIP

1375 Wolf Creek Trail – P.O. Box 397
Sharon Center, Ohio 44274
330-239-0317 Telephone / 800-949-9353 Fax

