

MIG



STICK



TIG



### Transmig 185 Ultra

AUTO SET WELDING INVERTER





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This Operating Manual has been designed to instruct you on the correct use and operation of your CIGWELD product. Your satisfaction with this product and its safe operation is our ultimate concern. Therefore please take the time to read the entire manual, especially the Safety Precautions. They will help you to avoid potential hazards that may exist when working with this product.

We have made every effort to provide you with accurate instructions, drawings, and photographs of the product(s) while writing this manual. However errors do occur and we apologize if there are any contained in this manual.

Due to our constant effort to bring you the best products, we may make an improvement that does not get reflected in the manual. If you are ever in doubt about what you see or read in this manual with the product you received, then check for a newer version of the manual on our website or contact our customer support for assistance.

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Above all, we are committed to develop technologically advanced products to achieve a safer working environment for industry operators.

**WARNINGS**

*Read and understand this entire Manual and your employer's safety practices before installing, operating, or servicing the equipment.*

*While the information contained in this Manual represents the Manufacturer's best judgement, the Manufacturer assumes no liability for its use.*

Operating Manual Number 0-5494 for:  
Cigweld Transmig 185 Ultra Inverter Plant

Part Number W1006185

Published by:

CIGWELD Pty Ltd  
CIGWELD An ESAB Brand  
71 Gower Street,  
Preston, Victoria, Australia, 3072  
Tel: +61 3 9474 7400 Fax: +61 3 9474 7391

[www.cigweld.com.au](http://www.cigweld.com.au)

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Publication Date: 15-05-2018  
Revision Date: 05-07-2018

**Record the following information for Warranty purposes:**

Where Purchased: \_\_\_\_\_

Purchase Date: \_\_\_\_\_

Equipment Serial #: \_\_\_\_\_



## DECLARATION OF CONFORMITY

According to

The Arc Welding Power Source Directive AS 60974.1-2006 (equivalent to IEC 60974-1 Ed. 2.1)

The EMC Directive IEC 60974-10:2014 published on 06 February 2014

**Type of equipment**

Welding Inverter Power Source

**Type designation etc.**

Welding Performance

**Brand name or trade mark**

Cigweld

**Manufacturer or his authorised representative established within the EEA**

**Name, address, telephone No:**

Cigweld Pty Ltd  
71 Gower Street  
Preston, Victoria, Australia, 3072  
Phone: +61 3 9474 7400

**The following harmonised standard in force within the EEA has been used in the design:**

AS 60974.1-2006, Arc Welding Equipment - Welding Power Sources (IEC 60974-1:2000, MOD)  
IEC 60974-10-2014, Arc Welding Equipment - Part 10: Electromagnetic Compatibility (EMC) Requirements  
AS 1674.2-2007, Safety in Welding and Allied Processes

*Additional Information: Restrictive use, Class A equipment, intended for use in location other than resid*

**By signing this document, the undersigned declares as manufacturer, or the manufacturer's authorised representative established within the EEA, that the equipment in question complies with the safety requirements stated above.**

**Date**

11-05-2018

**Signature**



Ken Konopa

**Position**

Vice President,  
Global Welding



2018

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## SECTION 1: ARC WELDING SAFETY INSTRUCTIONS AND WARNINGS



### WARNING

**PROTECT YOURSELF AND OTHERS FROM POSSIBLE SERIOUS INJURY OR DEATH. KEEP CHILDREN AWAY. PACEMAKER WEARERS KEEP AWAY UNTIL CONSULTING YOUR DOCTOR. DO NOT LOSE THESE INSTRUCTIONS. READ OPERATING/INSTRUCTION MANUAL BEFORE INSTALLING, OPERATING OR SERVICING THIS EQUIPMENT.**

Welding products and welding processes can cause serious injury or death, or damage to other equipment or property, if the operator does not strictly observe all safety rules and take precautionary actions.

Safe practices have developed from past experience in the use of welding and cutting. These practices must be learned through study and training before using this equipment. Some of these practices apply to equipment connected to power lines; other practices apply to engine driven equipment. Anyone not having extensive training in welding and cutting practices should not attempt to weld.

Safe practices are outlined in the Australian Standard AS1674.2-2007 entitled: Safety in welding and allied processes Part 2: Electrical. This publication and other guides to what you should learn before operating this equipment are listed at the end of these safety precautions. **HAVE ALL INSTALLATION, OPERATION, MAINTENANCE, AND REPAIR WORK PERFORMED ONLY BY QUALIFIED PEOPLE.**

### 1.01 Arc Welding Hazards



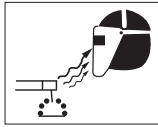
### WARNING

#### ***ELECTRIC SHOCK can kill.***

*Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on. The input power circuit and machine internal circuits are also live when power is on. In semiautomatic or automatic wire welding, the wire, wire reel, drive roll housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is a hazard.*

1. Do not touch live electrical parts.
2. Wear dry, hole-free insulating gloves and body protection.
3. Insulate yourself from work and ground using dry insulating mats or covers.
4. Disconnect input power or stop engine before installing or servicing this equipment. Lock input power disconnect switch open, or remove line fuses so power cannot be turned on accidentally.
5. Properly install and ground this equipment according to its Owner's Manual and national, state, and local codes.
6. Turn off all equipment when not in use. Disconnect power to equipment if it will be left unattended or out of service.
7. Use fully insulated electrode holders. Never dip holder in water to cool it or lay it down on the ground or the work surface. Do not touch holders connected to two welding machines at the same time or touch other people with the holder or electrode.
8. Do not use worn, damaged, undersized, or poorly spliced cables.
9. Do not wrap cables around your body.
10. Ground the workpiece to a good electrical (earth) ground.
11. Do not touch electrode while in contact with the work (ground) circuit.
12. Use only well-maintained equipment. Repair or replace damaged parts at once.
13. In confined spaces or damp locations, do not use a welder with AC output unless it is equipped with a voltage reducer. Use equipment with DC output.
14. Wear a safety harness to prevent falling if working above floor level.
15. Keep all panels and covers securely in place.





### WARNING

**ARC RAYS** can burn eyes and skin; **NOISE** can damage hearing.

*Arc rays from the welding process produce intense heat and strong ultraviolet rays that can burn eyes and skin. Noise from some processes can damage hearing.*

1. Use a Welding Helmet or Welding Faceshield fitted with a proper shade of filter (see ANSI Z49.1 and AS 1674 listed in Safety Standards) to protect your face and eyes when welding or watching.
2. Wear approved safety glasses. Side shields recommended.
3. Use protective screens or barriers to protect others from flash and glare; warn others not to watch the arc.
4. Wear protective clothing made from durable, flame-resistant material (wool and leather) and foot protection.
5. Use approved ear plugs or ear muffs if noise level is high.
6. Never wear contact lenses while welding.

### Recommended Protective Filters for Electric Welding

Description of Process	Approximate Range of Welding Current in Amps	Minimum Shade Number of Filter(s)
Manual Metal Arc Welding - covered electrodes (MMAW)	Less than or equal to 100	8
	100 to 200	10
	200 to 300	11
	300 to 400	12
	Greater than 400	13
Gas Metal Arc Welding (GMAW) (MIG) other than Aluminium and Stainless Steel	Less than or equal to 150	10
	150 to 250	11
	250 to 300	12
	300 to 400	13
	Greater than 400	14
Gas Metal Arc Welding (GMAW) (MIG) Aluminium and Stainless Steel	Less than or equal to 250	12
	250 to 350	13
Gas Tungsten Arc Welding (GTAW) (TIG)	Less than or equal to 100	10
	100 to 200	11
	200 to 250	12
	250 to 350	13
	Greater than 350	14
Flux-cored Arc Welding (FCAW) -with or without shielding gas.	Less than or equal to 300	11
	300 to 400	12
	400 to 500	13
	Greater than 500	14
Air - Arc Gouging	Less than or equal to 400	12
Plasma - Arc Cutting	50 to 100	10
	100 to 400	12
	400 to 800	14
Plasma - Arc Spraying	—	15
Plasma - Arc Welding	Less than or equal to 20	8
	20 to 100	10
	100 to 400	12
	400 to 800	14
Submerged - Arc Welding	—	2(5)
Resistance Welding	—	Safety Spectacles or eye shield

Refer to standard AS/NZS 1338.1:1992 for comprehensive information regarding the above table.

**WARNING**

*FUMES AND GASES can be hazardous to your health.*

*Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.*

1. Keep your head out of the fumes. Do not breathe the fumes.
2. If inside, ventilate the area and/or use exhaust at the arc to remove welding fumes and gases.
3. If ventilation is poor, use an approved air-supplied respirator.
4. Read the Material Safety Data Sheets (MSDSs) and the manufacturer's instruction for metals, consumables, coatings, and cleaners.
5. Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Shielding gases used for welding can displace air causing injury or death. Be sure the breathing air is safe.
6. Do not weld in locations near degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapours to form highly toxic and irritating gases.
7. Do not weld 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 if necessary, while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes if welded.

**WARNING**

*WELDING can cause fire or explosion.*

*Sparks and spatter fly off from the welding arc. The flying sparks and hot metal, weld spatter, hot workpiece, and hot equipment can cause fires and burns. Accidental contact of electrode or welding wire to metal objects can cause sparks, overheating, or fire.*

1. Protect yourself and others from flying sparks and hot metal.
2. Do not weld where flying sparks can strike flammable material.

3. Remove all flammables within 35 ft (10.7 m) of the welding arc. If this is not possible, tightly cover them with approved covers.
4. Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas.
5. Watch for fire, and keep a fire extinguisher nearby.
6. Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.
7. Do not weld on closed containers such as tanks or drums.
8. Connect work cable to the work as close to the welding area as practical to prevent welding current from travelling long, possibly unknown paths and causing electric shock and fire hazards.
9. Do not use welder to thaw frozen pipes.
10. Remove stick electrode from holder or cut off welding wire at contact tip when not in use.

**WARNING**

*FLYING SPARKS AND HOT METAL can cause injury.*

*Chipping and grinding cause flying metal. As welds cool, they can throw off slag.*

1. Wear approved face shield or safety goggles. Side shields recommended.
2. Wear proper body protection to protect skin.

**WARNING**

*CYLINDERS can explode if damaged.*

*Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Since gas cylinders are normally part of the welding process, be sure to treat them carefully.*

1. Protect compressed gas cylinders from excessive heat, mechanical shocks, and arcs.
2. Install and secure cylinders in an upright position by chaining them to a stationary support or equipment cylinder rack to prevent falling or tipping.
3. Keep cylinders away from any welding or other electrical circuits.
4. Never allow a welding electrode to touch any cylinder.

5. Use only correct shielding gas cylinders, regulators, hoses, and fittings designed for the specific application; maintain them and associated parts in good condition.
6. Turn face away from valve outlet when opening cylinder valve.
7. Keep protective cap in place over valve except when cylinder is in use or connected for use.
8. Read and follow instructions on compressed gas cylinders, associated equipment, and CGA publication P-1 listed in Safety Standards.

**WARNING**

*MOVING PARTS can cause injury.*

Moving parts, such as fans, rotors, and belts can cut fingers and hands and catch loose clothing.

1. Keep all doors, panels, covers, and guards closed and securely in place.
2. Stop engine before installing or connecting unit.
3. Have only qualified people remove guards or covers for maintenance and troubleshooting as necessary.
4. To prevent accidental starting during servicing, disconnect negative (-) battery cable from battery.
5. Keep hands, hair, loose clothing, and tools away from moving parts.
6. Reinstall panels or guards and close doors when servicing is finished and before starting engine.

**WARNING**

*This product, when used for welding or cutting, produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety code Sec. 25249.5 et seq.)*

**NOTE**

*Considerations About Welding And The Effects of Low Frequency Electric and Magnetic Fields*

The following is a quotation from the General Conclusions Section of the U.S. Congress, Office of Technology Assessment, Biological Effects of Power Frequency Electric & Magnetic Fields - Background Paper, OTA-BP-E-63 (Washington, DC: U.S. Government Printing Office, May 1989): "...there is now a very large volume of scientific findings based on experiments at the cellular level and from studies with animals and people which clearly establish that low frequency magnetic fields and interact with, and produce changes in, biological systems. While most of this work is of very high quality, the results are complex. Current scientific understanding does not yet allow us to interpret the evidence in a single coherent framework. Even more frustrating, it does not yet allow us to draw definite conclusions about questions of possible risk or to offer clear science-based advice on strategies to minimize or avoid potential risks."

To reduce magnetic fields in the workplace, use the following procedures.

1. Keep cables close together by twisting or taping them.
2. Arrange cables to one side and away from the operator.
3. Do not coil or drape cable around the body.
4. Keep welding power source and cables as far away from body as practical.

**ABOUT PACEMAKERS:**

*The above procedures are among those also normally recommended for pacemaker wearers. Consult your doctor for complete information.*

## 1.02 Principal Safety Standards

Safety in Welding and Cutting, ANSI Standard Z49.1, from American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126.

Safety and Health Standards, OSHA 29 CFR 1910, from Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402.

Recommended Safe Practices for the Preparation for Welding and Cutting of Containers That Have Held Hazardous Substances, American Welding Society Standard AWS F4.1, from American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126.

National Electrical Code, NFPA Standard 70, from National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1, from Compressed Gas Association, 1235 Jefferson Davis Highway, Suite 501, Arlington, VA 22202.

Code for Safety in Welding and Cutting, CSA Standard W117.2, from Canadian Standards Association, Standards Sales, 178 Rexdale Boulevard, Rexdale, Ontario, Canada M9W 1R3.

Safe Practices for Occupation and Educational Eye and Face Protection, ANSI Standard Z87.1, from American National Standards Institute, 1430 Broadway, New York, NY 10018.

Cutting and Welding Processes, NFPA Standard 51B, from National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

Safety in welding and allied processes Part 1: Fire Precautions, AS 1674.1-1997 from SAI Global Limited, [www.saiglobal.com](http://www.saiglobal.com).

Safety in welding and allied processes Part 2: Electrical, AS 1674.2-2007 from SAI Global Limited, [www.saiglobal.com](http://www.saiglobal.com).

Filters for eye protectors - Filters for protection against radiation generated in welding and allied operations AS/NZS 1338.1:1992 from SAI Global Limited, [www.saiglobal.com](http://www.saiglobal.com).

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## SECTION 2: INTRODUCTION

### 2.01 How To Use This Manual

To ensure safe operation, read the entire manual, including the chapter on safety instructions and warnings.

Throughout this manual, the words WARNING, CAUTION, and NOTE may appear. Pay particular attention to the information provided under these headings. These special annotations are easily recognized as follows:

**NOTE!**

An operation, procedure, or background information which requires additional emphasis or is helpful in efficient operation of the system.

**WARNING**

A procedure which, if not properly followed, may cause injury to the operator or others in the operating area.

**CAUTION**

A procedure which, if not properly followed, may cause damage to the equipment.

**WARNING**

Gives information regarding possible electrical shock injury. Warnings will be enclosed in a box such as this.

**DANGER**

Means immediate hazards which, if not avoided, will result in immediate, serious personal injury or loss of life.

Additional copies of this manual may be purchased by contacting Cigweld at the address and phone number for your location listed in the inside back cover of this manual. Include the Owner's Manual number and equipment identification numbers.

### 2.02 Equipment Identification

The unit's identification number (specification or part number), model, and serial number usually appear on a nameplate attached to the control panel. In some cases, the nameplate may be attached to the rear panel. Equipment which does not have a control panel such as gun and cable assemblies is identified only by the specification or part number printed on the shipping container. Record these numbers on the bottom of page i for future reference.

### 2.03 Receipt Of Equipment

When you receive the equipment, check it against the invoice to make sure it is complete and inspect the equipment for possible damage due to shipping. If there is any damage, notify the carrier immediately to file a claim. Furnish complete information concerning damage claims or shipping errors to the location in your area listed in the inside back cover of this manual.

Include all equipment identification numbers as described above along with a full description of the parts in error.

Move the equipment to the installation site before un-crating the unit. Use care to avoid damaging the equipment when using bars, hammers, etc., to uncrate the unit.

### 2.04 Symbol Chart

Note that only some of these symbols will appear on your model.

	On		Single Phase		Wire Feed Function
	Off		Three Phase		Wire Feed Towards Workpiece With Output Voltage Off.
	Dangerous Voltage		Three Phase Static Frequency Converter-Transformer-Rectifier		Welding Gun
	Increase/Decrease		Remote		Purging Of Gas
	Circuit Breaker		Duty Cycle		Continuous Weld Mode
	AC Auxiliary Power		Percentage		Spot Weld Mode
	Fuse		Panel/Local		Spot Time
	Amperage		Shielded Metal Arc Welding (SMAW)		Prewflow Time
	Voltage		Gas Metal Arc Welding (GMAW)		Postflow Time
	Hertz (cycles/sec)		Gas Tungsten Arc Welding (GTAW)	 2 Step Trigger Operation Press to initiate wirefeed and welding, release to stop.	
	Frequency		Air Carbon Arc Cutting (CAC-A)	 4 Step Trigger Operation Press and hold for preflow, release to start arc. Press to stop arc, and hold for preflow.	
	Negative		Constant Current		
	Positive		Constant Voltage Or Constant Potential		
	Direct Current (DC)		High Temperature		Burnback Time
	Protective Earth (Ground)		Fault Indication		Disturbance In Ground System
	Line		Arc Force		Inches Per Minute
	Line Connection		Touch Start (GTAW)		Metres Per Minute
	Auxiliary Power		Variable Inductance		Spool Gun
	Receptacle Rating-Auxiliary Power		Voltage Input		Auto Settings for MIG, STICK, TIG

Art # A-04937\_AC

## 2.05 Description

The Cigweld Transmig 185 Ultra takes the guess work out of welding with an impressive AUTO SET function that allows the user to weld like a Pro with no previous welding experience necessary.

Simply select the material type, thickness & consumable diameter and AUTO SET will pre-set the Wirefeed Speed (Amperage) and Voltage (MIG) along a pre-programmed synergic line. Experienced welders can then customise their settings by tweaking their speed and heat according to their technique and other factors.

A sophisticated Memory function allows you to return to your previous weld or save up to nine of your favourite weld settings.

The Ultra is a 185 Amp Professional multi process welding inverter, capable of producing outstanding weld results in either AUTO SET or Manual Mode in GMAW/FCAW (MIG), MMAW (Stick) and GTAW (Lift TIG).

A 4.3" colour LCD screen allows full interactive digital control over your weld settings in a simple to navigate and easy to read interface. The LCD screen is protected by recessed panelling, a screen protector and a flip up display cover.

The 185 Ultra comes with an integrated wirefeeder that holds up to a 200mm spool, and boasts a range of Professional Features to ensure optimal welding results: Burnback Control, Arc Control, 2T/4T, Spot/Stitch Weld, Pre/Post Flow, Up/Down Slope, Arc Force, Hot Start, Anti-Stick and VRD (applicable in Stick mode only).

Most importantly the 185 Ultra is fitted with a 10Amp plug, allowing you the flexibility to plug and play anywhere in your home or workshop. The power source weighs just over 17kg, and all accessories can be packed inside a convenient purpose built heavy duty backpack, making the Ultra portable and ideal for any home or jobsite.

The Ultra package comes standard with the Tweco Fusion DX250 Digital MIG gun which allows remote operation of volts and wirefeed speed in the palm of your hand. While the euro connection makes it compatible with most other MIG Guns and also the SGT250\* Spool gun for your precision aluminium work.

Backed by a 3 year warranty\*\* and fully compliant to Australian Standard AS 60974.1 and IEC 60974.1 you know you have a safe product you can trust.

With excellent welding performance across a broad range of applications anyone can weld like a Pro! You set the process and the Ultra will do the rest!

The following instructions detail how to correctly and safely set up the machine and give guidelines on gaining the best efficiency and quality from the Power Source. Please read these instructions thoroughly before using the unit.



### NOTE

\*Wirefeed speed is adjustable from the power source only (no remote speed control on the Spool gun).

\*\*Refer to the complete Warranty Schedule at the back of the manual.

## 2.06 User Responsibility

This equipment will perform as per the information contained herein when installed, operated, maintained and repaired in accordance with the instructions provided. This equipment must be checked periodically. Defective equipment (including welding leads) should not be used. Parts that are broken, missing, plainly worn, distorted or contaminated, should be replaced immediately. Should such repairs or replacements become necessary, it is recommended that such repairs be carried out by appropriately qualified persons approved by CIGWELD. Advice in this regard can be obtained by contacting an Accredited CIGWELD Distributor.

This equipment or any of its parts should not be altered from standard specification without prior written approval of CIGWELD. The user of this equipment shall have the sole responsibility for any malfunction which results from improper use or unauthorized modification from standard specification, faulty maintenance, damage or improper repair by anyone other than appropriately qualified persons approved by CIGWELD.

## 2.07 Transporting Methods

This unit is equipped with a handle for carrying purposes.

**WARNING**

ELECTRIC SHOCK can kill. DO NOT TOUCH live electrical parts. Disconnect input power conductors from de-energized supply line before moving the welding power source.

**WARNING**

FALLING EQUIPMENT can cause serious personal injury and equipment damage.

Lift unit with handle on top of case.

Use handcart or similar device of adequate capacity.

If using a fork lift vehicle, place and secure unit on a proper skid before transporting.

## 2.08 Packaged Items

### Transmig 185 Ultra Plant (Part No. W1006185)

- Transmig 185 Inverter Power Source
- Tweco Fusion DX250 MIG Torch, 3m
- Argon Regulator/Flowmeter
- Feed rolls: 0.8/0.9mm V Groove (fitted)  
1.0/1.2mm U Groove; 0.8/0.9mm V Knurled
- Contact Tips: 0.8mm (fitted); 0.9mm; 1.0mm
- Twistlock Electrode Holder with 4m Lead
- Work Clamp with 4m Lead
- Shielding Gas Hose Assembly
- Accessories Backpack
- Shoulder Strap
- Operating Manual

## 2.09 Duty Cycle

The rated duty cycle of a Welding Power Source, is a statement of the time it may be operated at its rated welding current output without exceeding the temperature limits of the insulation of the component parts. To explain the 10 minute duty cycle period the following example is used. Suppose a Welding Power Source is designed to operate at a 15% duty cycle, 90 amperes at 23.6 volts. This means that it has been designed and built to provide the rated amperage (90A) for 1.5 minutes, i.e. arc welding time, out of every 10 minute period (15% of 10 minutes is 1.5 minutes). During the other 8.5 minutes of the 10 minute period the Welding Power Source must idle and be allowed to cool.

## 2.10 Specifications

Description	Transmig 185 Ultra
Transmig 185 Ultra Plant Part Number	W1006185
Power Source Dimensions	H520mm x W220mm x D420mm
Power Source Weight	17.4kg
Plant (Package) Weight	30.0kg
Cooling	Fan Cooled
Welder Type	Multi Process Inverter Power Source
Australian Standard	AS60974-1 / IEC60974-1
Number of Phases	Single Phase
Nominal Supply Voltage	240 VAC $\pm$ 15%
Nominal Supply Frequency	50 / 60Hz
Factory Fitted Supply Plug Rating	10 Amps
Effective Input Current ( $I_{1\text{eff}}$ ) [Refer Note 1]	9.5 Amps
Maximum Input Current ( $I_{1\text{max}}$ )	24.5 Amps
Minimum Single Phase Generator Recommendation [Refer Note 3]	10 kVA (at 0.8 Power Factor) 8 kW (at 1.0 Power Factor)
Output Terminal Type	Dinse™ Style 50
Protection Class	IP23S
Welding Environment Classification	Suitable for Welding in Category C Environments; Suitable for Indoor and Outdoor Welding
<b>MIG (GMAW / FCAW) Welding</b>	
Welding Current Range	30 – 185A
Welding Voltage Range	15.5 – 23.3V DC
Wirefeed Speed Range (Metres per Minute)	1.5 – 16.4
Welding Output, 40°C, 10 min	185A @ 20%, 23.3V 116A @ 60%, 19.8V 90A @ 100%, 18.5V
Nominal Open Circuit Voltage MIG Weld Mode	48V DC (Trigger Switch Depressed when not Welding)
<b>STICK (MMAW)</b>	
Welding Current Range	10 – 185A
Welding Output, 40°C, 10 min.	185A @ 15%, 27.4V 95A @ 60%, 23.8V 80A @ 100%, 23.2V
Open Circuit Voltage (VRD On)	<26V DC
Open Circuit Voltage (VRD Off)	48V DC
<b>TIG (GTAW)</b>	
Welding Current Range	10 – 185A
Welding Output, 40°C, 10 min.	185A @ 20%, 17.4V 116A @ 60%, 14.6V 90A @ 100%, 13.6V
Open Circuit Voltage (VRD On)	<26V DC
Open Circuit Voltage (VRD Off)	48V DC

Table 2-1: Transmig 185 Ultra Specification



**NOTE 1**

Due to variations that can occur in manufactured products, claimed performance, voltages, ratings, all capacities, measurements, dimensions and weights quoted are approximate only. Achievable capacities and ratings in use and operation will depend upon correct installation, use, applications, maintenance and service.

**NOTE 2**

The Effective Input Current should be used for the determination of cable size & supply requirements.

**NOTE 3**

Motor start fuses or thermal circuit breakers are recommended for this application. Check local requirements for your situation in this regard.

**NOTE 4**

Minimum Generator Recommendation at the Maximum Output Duty Cycle.

Due to large variations in performance and specifications of different brands and types of generators, CIGWELD cannot guarantee full welding output power or duty cycle on every brand or type of generator.

Some small generators incorporate low cost circuit breakers on their outputs. These circuit breakers usually will have a small reset button, and will trip much faster than a switchboard type circuit breaker. This may result in not being able to achieve full output or duty cycle from the power source / generator combination. For this reason we recommend a generator that incorporates switchboard type circuit breakers.

CIGWELD recommends that when selecting a generator, that the particular power source / generator combination be adequately trialled to ensure the combination performs to the users expectations.

**NOTE 5**

CIGWELD reserves the right to change product performance and specifications without notice.

**NOTE 6**

If an extension lead is required to be used it is recommended to use a minimum size of 1.5mm<sup>2</sup> Heavy Duty Extension Lead. Longer extension leads may impact welding performance and operation.

## 2.11 Options and Accessories

We recommend genuine CIGWELD products.

The biggest range and best quality with guaranteed performance.

Part Number	Description
W4018900	Tweco Professional Fusion DX250 Digital MIG Torch, 3.0 metre EURO
W4013701	Tweco Professional Fusion 250 MIG Torch, 3.0 metre EURO
OTWF212X3035	Tweco Professional Fusion 250 MIG Torch, 3.6 metre EURO
See Page 9-1	Tweco Fusion DX250 MIG Torch Consumables
OTWX212/3035	TWECO #2, 250A MIG torch, 3.6 metre EURO
W4012300	Tweco Mig Torch Consumables Organiser
For Cigweld MIG Wires see the Selection Chart on Page 5-23	
W4011250	SGT250 Spool Gun*
7977036	Feed Roll 0.6/0.8mm V groove (hard)
7977660	Feed Roll 0.9/1.2mm V groove (hard)
7977731	Feed Roll 0.8/0.9mm U groove (soft)
7977264	Feed Roll 1.0/1.2mm U groove (soft)
7977732	Feed Roll 0.8/0.9mm V groove knurled (flux cored)
704277	Feed Roll 1.2/1.6mm V groove knurled (flux cored)
W7004913	Shielding Gas Hose Assembly
WSPLIER	MIG Pliers
W4013801	TIG Torch 17V with 4m lead
*Note: When using the SGT250 Spool Gun with the Transmig 185 Ultra the remote wirefeed speed control located on the Spool Gun is not operational. Wirefeed speed for the Spool Gun can only be adjusted using the 185 Ultra Power Source wire feed speed control.	

Table 2-2: Transmig 185 Ultra Optional Accessories

### TIG Torch Consumables

Part Number	Description
BG10N49/R	Nozzle Alumina 8mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N48/R	Nozzle Alumina 10mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N47/R	Nozzle Alumina 11mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N46/R	Nozzle Alumina 12.5mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N22/R	Collet 1.0mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N23/R	Collet 1.6mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N24/R	Collet 2.4mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N25/R	Collet 3.2mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N30/R	Collet Body 1.0mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N31/R	Collet Body 1.6mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N32/R	Collet Body 2.4mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG10N28/R	Collet Body 3.2mm, for 17, 26 & 18 TIG Torches (pkt of 5)
BG57Y02/R	Back Cap – Long for 17, 26 & 18 TIG Torches (pkt of 2)
BG57Y04/R	Back Cap – Short for 17, 26 & 18 TIG Torches (pkt of 2)

Table 2-3

**TIG Electrodes**

Part Number	Description
699846	Ceriated Electrode 1.6mm x 175mm AC/DC Grey (Pkt of 10)
699847	Ceriated Electrode 2.4mm x 175mm AC/DC Grey (Pkt of 10)
699848	Ceriated Electrode 3.2mm x 175mm AC/DC Grey (Pkt of 10)

Table 2-4

**Related Products**

Part Number	Description
646754	WeldSkill TIG Welding Gloves
646755	WeldSkill Heavy Duty Welding Gloves
454332	Prolite Auto-Darkening Welding Helmet - SPACE
454333	Prolite Auto-Darkening Welding Helmet - CLAW
454351	ProPlus Digital Auto-Darkening Welding Helmet - WEB
454353	ProPlus Digital Auto-Darkening Welding Helmet - PRO RACER
Note: CIGWELD Electrodes see Page 7-15.	

Table 2-5

## SECTION 3: INSTALLATION

### 3.01 Environment

These units are designed for use in environments with increased hazard of electric shock as outlined in AS 60974.1 and AS 1674.2. Additional safety precautions may be required when using unit in an environment with increased hazard of electric shock. Please refer to relevant local standards for further information prior to using in such areas.

- A. Examples of environments with increased hazard of electric shock are:
1. In locations in which freedom of movement is restricted, so that the operator is forced to perform the work in a cramped (kneeling, sitting or lying) position with physical contact with conductive parts.
  2. In locations which are fully or partially limited by conductive elements, and in which there is a high risk of unavoidable or accidental contact by the operator.
  3. In wet or damp hot locations where humidity or perspiration considerable reduces the skin resistance of the human body and the insulation properties of accessories.
- B. Environments with increased hazard of electric shock do not include places where electrically conductive parts in the near vicinity of the operator, which can cause increased hazard, have been insulated.

### 3.02 Location

Be sure to locate the welder according to the following guidelines:

- A. In areas, free from moisture and dust.
- B. Ambient temperature between 0° C to 40° C.
- C. In areas, free from oil, steam and corrosive gases.
- D. In areas, not subjected to abnormal vibration or shock.
- E. In areas, not exposed to direct sunlight or rain.
- F. Place at a distance of 300mm or more from walls or similar that could restrict natural air flow for cooling.

G. The enclosure design of this power source meets the requirements of IP23S as outlined in AS60529. This provides adequate protection against solid objects (greater than 12mm), and direct protection from vertical drops. Under no circumstances should the unit be operated or connected in a micro environment that will exceed the stated conditions. For further information please refer to AS 60529.

H. Precautions must be taken against the power source toppling over. The power source must be located on a suitable horizontal surface in the upright position when in use.

### 3.03 Ventilation

Since the inhalation of welding fumes can be harmful, ensure that the welding area is effectively ventilated.

### 3.04 Mains Supply Voltage Requirements

The Mains supply voltage should be within  $\pm 15\%$  of the rated mains supply voltage. Too low a voltage may cause poor welding performance. Too high a supply voltage will cause components to overheat and possibly fail.

The Welding Power Source must be:

- Correctly installed, if necessary, by a qualified electrician.
- Correctly earthed (electrically) in accordance with local regulations.
- Connected to the correct size power point and fuse as per the Specifications on Page 2-5.



#### WARNING

Any electrical work must be carried out by a qualified Electrical Tradesperson..

### 3.05 Electromagnetic Compatibility

**WARNING**

Extra precautions for Electromagnetic Compatibility may be required when this Welding Power Source is used in a domestic situation..

#### A. Installation and Use - Users Responsibility

The user is responsible for installing and using the welding equipment according to the manufacturer's instructions. If electromagnetic disturbances are detected then it shall be the responsibility of the user of the welding equipment to resolve the situation with the technical assistance of the manufacturer. In some cases this remedial action may be as simple as earthing the welding circuit, see NOTE below. In other cases it could involve constructing an electromagnetic screen enclosing the Welding Power Source and the work, complete with associated input filters. In all cases, electromagnetic disturbances shall be reduced to the point where they are no longer troublesome.

**NOTE!**

The welding circuit may or may not be earthed for safety reasons. Changing the earthing arrangements should only be authorised by a person who is competent to assess whether the changes will increase the risk of injury, e.g. by allowing parallel welding current return paths which may damage the earth circuits of other equipment. Further guidance is given in IEC 60974-13 Arc Welding Equipment - Installation and use (under preparation).

#### B. Assessment of Area

Before installing welding equipment, the user shall make an assessment of potential electromagnetic problems in the surrounding area. The following shall be taken into account

1. Other supply cables, control cables, signalling and telephone cables; above, below and adjacent to the welding equipment.
2. Radio and television transmitters and receivers.
3. Computer and other control equipment.
4. Safety critical equipment, e.g. guarding of industrial equipment.
5. The health of people around, e.g. the use of pacemakers and hearing aids.

6. Equipment used for calibration and measurement.
7. The time of day that welding or other activities are to be carried out.
8. The immunity of other equipment in the environment: the user shall ensure that other equipment being used in the environment is compatible: this may require additional protection measures.

The size of the surrounding area to be considered will depend on the structure of the building and other activities that are taking place. The surrounding area may extend beyond the boundaries of the premises.

#### C. Methods of Reducing Electromagnetic Emissions

##### 1. Mains Supply

Welding equipment should be connected to the mains supply according to the manufacturer's recommendations. If interference occurs, it may be necessary to take additional precautions such as filtering of the mains supply. Consideration should be given to shielding the supply cable of permanently installed welding equipment in metallic conduit or equivalent. Shielding should be electrically continuous throughout its length. The shielding should be connected to the Welding Power Source so that good electrical contact is maintained between the conduit and the Welding Power Source enclosure.

##### 2. Maintenance of Welding Equipment

The welding equipment should be routinely maintained according to the manufacturer's recommendations. All access and service doors and covers should be closed and properly fastened when the welding equipment is in operation. The welding equipment should not be modified in any way except for those changes and adjustments covered in the manufacturer's instructions. In particular, the spark gaps of arc striking and stabilising devices should be adjusted and maintained according to the manufacturer's recommendations.



### 3. Welding Cables

The welding cables should be kept as short as possible and should be positioned close together, running at or close to the floor level.

### 4. Equipotential Bonding

Bonding of all metallic components in the welding installation and adjacent to it should be considered. However, Metallic components bonded to the work piece will increase the risk that the operator could receive a shock by touching the metallic components and the electrode at the same time. The operator should be insulated from all such bonded metallic components.

### 5. Earthing of the Workpiece

Where the workpiece is not bonded to earth for electrical safety, nor connected to earth because of its size and position, e.g. ship's hull or building steelwork, a connection bonding the workpiece to earth may reduce emissions in some, but not all instances. Care should be taken to prevent the earthing of the workpiece increasing the risk of injury to users, or damage to other electrical equipment. Where necessary, the connection of the workpiece to earth should be made by direct connection to the workpiece, but in some countries where direct connection is not permitted, the bonding should be achieved by suitable capacitance, selected according to national regulations.

### 6. Screening and Shielding

Selective screening and shielding of other cables and equipment in the surrounding area may alleviate problems of interference. Screening the entire welding installation may be considered for special applications.

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## SECTION 4: OPERATION

### 4.01 Overview

Conventional operating procedures apply when using the Welding Power Source, i.e. connect work lead directly to workpiece and the electrode wire is fed via the MIG Torch (Consult the electrode wire manufacturers information for the correct polarity). The welding current range values should be used as a guide only. Current delivered to the arc is dependent on the welding arc voltage, and as welding arc voltage varies between different classes of electrode wire, welding current at any one setting would vary according to the type of electrode wire in use. The operator should use the welding current range values as a guide, then finally adjust the current setting to suit the application.

### 4.02 Transmig 185 Ultra Power Source Controls and Features

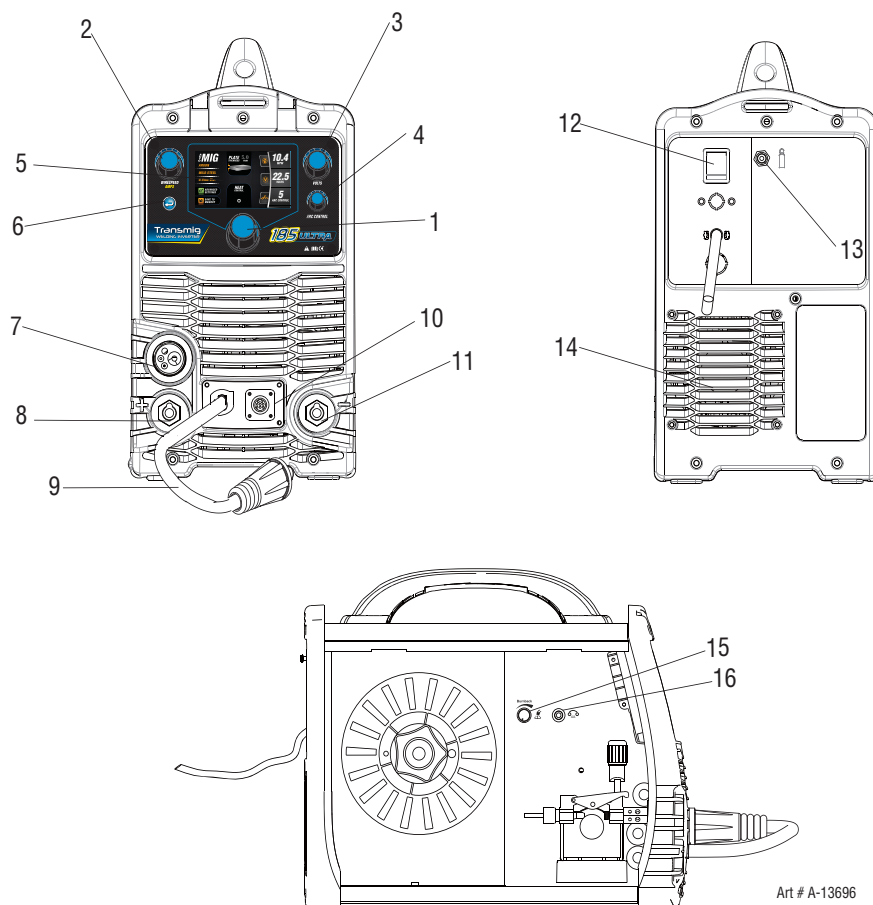


Figure 4-1: Wire Feed Compartment Control

### 1) Control Knob (Refer to Figure 4-1)

Turn or press the Control Knob to select from the menu or change values.



To select an option from the displayed menu:

- Options will be highlighted in sequence at every turn;
- Turn clockwise or anti-clockwise to change selection;
- Press Control Knob to confirm the selection or to enter the next level menu.
- Press and hold the Control Knob for approximately 2 seconds and the screen will directly return to Home page (welding modes selection screen) from any page.

To change values:

- Turn clockwise to increase the value;
- Turn anti-clockwise to decrease the value;
- Turn slowly in order to adjust value in small increments.
- Turn quickly in order to adjust value in larger increments.

### 2) Wirespeed / Amperage Control (Refer to Figure 4-1)

In MIG (GMAW / FCAW) mode, the amperage knob adjusts the speed of the wire feed motor (which in turn adjusts the output current by varying the amount of MIG wire delivered to the welding arc). The optimum wire speed required will be dependent on the type of welding application.

The amperage control knob adjusts the amount of welding current delivered by the power source. In STICK (MMAW) and TIG (GTAW) modes, the amperage control knob directly adjusts the power inverter to deliver the desired level of output current.

Turning this knob slowly increments value in small amounts and turning this knob quickly will increment value in large amounts.

In Auto Set MIG Mode adjusting the Wirespeed Control will alter the Wire Feed Speed which may also change the plate thickness.

Whilst adjusting the Wire Feed Speed Control this may also Synergically adjust the voltage value.

In Manual MIG Mode the setup chart on the inside of the wire feed compartment door provides a brief summary of the required output settings for a basic range of MIG welding applications.

Note:

When using the SGT250 Spool Gun with the Transmig 185 Ultra the remote wirefeed speed control located on the Spool Gun is not operational. Wirefeed speed for the Spool Gun can only be adjusted using the 185 Ultra Power Source wire feed speed control.

### 3) Voltage Control (Refer to Figure 4-1)

Turning this knob slowly increments value in small amounts and turning this knob quickly will increment value in large amounts.

In MIG (GMAW/FCAW) mode only, the voltage control knob is used to adjust the output voltage of the unit. The welding voltage is increased by turning the knob clockwise or decreased by turning the knob anti-clockwise. The optimum voltage level required will be dependent on the type of welding application.

In Manual MIG Mode, the setup chart on the inside of the wire feed compartment door provides a brief summary of the required output settings for a basic range of MIG welding applications.

In Auto MIG mode adjusting the Wire Feed Speed Control may also Synergically adjust the voltage value.

In Auto MIG mode adjusting the voltage control knob will adjust the heat setting off the Auto MIG synergic line (which is set at 0 on the Heat Control).

Adjusting the Voltage Control knob clockwise increases the voltage by 0.2V increments along the Heat Scale. Heat Control +9 = 1.8V volt increase.

Adjusting the Voltage Control knob anti-clockwise decreases the voltage by 0.2V increments along the Heat Scale. Heat Control -9 = 1.8V volt decrease.



Figure 4-2 Heat Control

#### 4) Arc Control (Inductance) (Refer to Figure 4-1)

The arc control operates in MIG (GMAW) mode only and is used to adjust the intensity of the welding arc. Lower arc control settings make the arc softer with less weld spatter. Higher arc control settings give a stronger driving arc which can increase weld penetration.

#### 5) LCD Screen (Refer to Figure 4-1)

A 4.3 inch LCD screen is installed on the front panel to display welding mode menu, information, welding parameter and many other advanced settings.



Figure 4-3: Home Page

Welding modes can be selected on the Home page. Detailed operation method is introduced in Section 5, 6 and 7 for MIG (GMAW / FCAW), TIG (GTAW) and STICK (MMAW) process. Detailed LCD operation method is introduced in Section 4. 03.

#### 6) Back Button (Refer to Figure 4-1)



Press Back Button to return to previous LCD screen.

**7) MIG Torch Adaptor (Euro Style) (Refer to Figure 4-1)**

The MIG torch adaptor is the connection point for the MIG welding torch or SGT 250 Spool Gun if used. Connect the torch by pushing the torch connector into the brass torch adaptor firmly and screwing the plastic torch nut clockwise to secure in position. To remove the MIG Torch simply reverse these directions.

**8) Positive Welding Output Terminal (Refer to Figure 4-1)**

The positive welding terminal is used to connect the welding output of the power source to the appropriate welding accessory such as the MIG torch (via the MIG torch polarity lead), electrode holder lead or work lead. Positive welding current flows from the power source via this Dinse terminal. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.

**CAUTION**

Loose welding terminal connections can cause overheating and result in the male plug being fused in the Dinse terminal.

**9) MIG Torch Polarity Lead (Refer to Figure 4-1)**

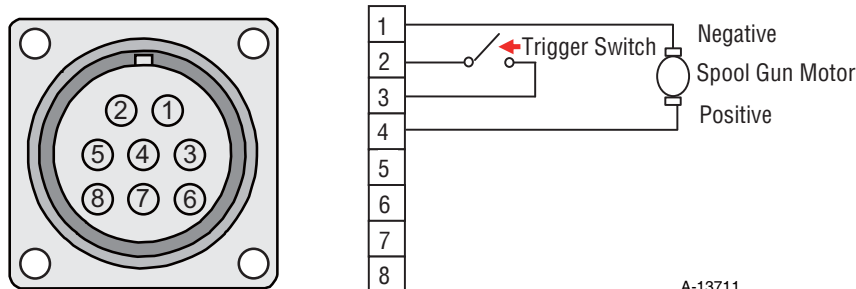
The polarity lead is used to connect the MIG torch to the appropriate positive or negative output terminal (allowing polarity reversal for different welding applications). In general, the polarity lead should be connected in to the positive welding terminal (+) when using steel, stainless steel or aluminium electrode wire. When using gasless wire, the polarity lead is generally connected to the negative welding terminal (-). If in doubt, consult the manufacturer of the electrode wire for the correct polarity. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.

**CAUTION**

Loose welding terminal connections can cause overheating and result in the male plug being fused in the Dinse terminal.

**10) Remote Control Socket (Refer to Figure 4-1)**

The 8 pin Remote Control Socket is used to connect remote control devices to the welding power source. To make connections, align keyway, insert plug, and rotate threaded collar fully clockwise.



A-13711

Figure 4-4: Remote Control Socket

Socket Pin	Function
1	Spool Gun Motor Negative
2	Trigger Switch Input
3	Trigger Switch Input
4	Spool Gun Motor Positive
5	Not Connected
6	Not Connected
7	Not Connected
8	Not Connected

Table 4-1

\*Note: When using the SGT250 Spool Gun with the Transmig 185 Ultra the remote wirefeed speed control located on the Spool Gun is not operational. Wirefeed speed for the Spool Gun can only be adjusted using the 185 Ultra Power Source wire feed speed control.

**11) Negative Welding Output Terminal (Refer to Figure 4-1)**

The negative welding terminal is used to connect the welding output of the power source to the appropriate welding accessory such as the MIG torch (via the MIG torch polarity lead), TIG torch or work lead. Negative welding current flows to the power source via this Dinse terminal. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.

**CAUTION**

Loose welding terminal connections can cause overheating and result in the male plug being fused in the Dinse terminal.

**12) Input Supply ON/OFF Switch (Refer to Figure 4-1)**

This switch is used to turn the unit ON/OFF. When this switch is turned ON the LCD Screen on the front panel will illuminate.

**NOTE**

If the Power Source is repeatedly switched On then Off rapidly or the supply to the power source is turned On and Off rapidly it may not turn On due to inbuilt protective devices acting. If this occurs leave the Power Source On/Off switch turned to the Off position for several minutes to allow for the protective devices to reset.



**13) Gas Inlet (MIG mode only) (Refer to Figure 4-1)**

The Gas Inlet connection is used to supply the appropriate MIG welding gas to the unit. Refer to section 5.09 or 5.11 for MIG set up details. Ensure that the shielding gas hose connection is sufficiently tight at the regulator connection and the quick connect fitting "locks" into place correctly on the rear of the power source.

**WARNING**

Only Inert Shielding Gases specifically designed for welding applications should be used.

**14) Fan on Demand (Refer to Figure 4-1)**

The Transmig 185 Ultra is fitted with a fan on demand feature. Fan on demand automatically switches the cooling fan off when it is not required. This has two main advantages; (1) to minimize power consumption, and (2) to minimise the amount of contaminants such as dust that are drawn into the power source.

Note that the fan will only operate when required for cooling purposes and will automatically switch off when not required.

**15) Burnback Control (located in wirefeed compartment) (Refer to Figure 4-1)**

The burnback control is used to adjust the amount of MIG wire that protrudes from the MIG torch after the completion of MIG welding (commonly referred to as stick out). To decrease the burnback time (or lengthen the amount of wire protruding from the MIG torch at the completing of welding), turn the burnback control knob anti clockwise. To increase the burnback time (or shorten the amount of wire protruding from the torch at the completing of welding), turn the Burnback Control knob clockwise.

**16) 4A Circuit Breaker (Refer to Figure 4-1)**

The 4A Circuit Breaker protects the unit from electrical faults and will operate in the event of a motor overload.

**NOTE**

If a circuit breaker trips, a short cooling period must be allowed before an attempt is made to reset the unit by pressing the circuit breaker reset button..

**17) Hot Start Feature (Not Shown)**

This feature operates in Stick (Manual Arc) mode. The Hot Start feature improves the arc start characteristics by momentarily increasing the welding current to a level above the preset amperage (Welding Current). This is a preset feature and is not adjustable.

**18) Anti Stick Feature (Not Shown)**

This feature operates in Stick (Manual Arc) mode. The anti stick feature senses when the electrode sticks and automatically reduces the current to prevent the Stick Electrode from sticking to the work piece. This is a preset feature and is not adjustable.

**4.03 LCD Screen Operation****1) Information**

Information menu can be displayed when Information button on the Home page is selected. In Information menu the user can consult welding setup diagrams for MIG Gasless (FCAW), TIG (GTAW) and STICK (MMAW) welding processes, check software version and restore to factory settings. Setup diagram for MIG Gas Shielded (GMAW) can be found under MIG mode menu (see details in Section 5. 09).



Figure 4-5: Highlighted Information Icon



Figure 4-6: Information Menu

To consult welding setup diagrams, turn the Control Knob and select welding mode. Setup guide for the selected welding mode will be displayed. Press OK button on the screen or press Back Button in order to return to the upper level menu.



Figure 4-7: Setup Diagram Menu



Figure 4-8: MIG Gasless (FCAW) Setup Diagram

When software version number is required, select Software Version from Information menu.



Figure 4-9: Software Version Selected



Figure 4-10: Software Version

## 2) Restore Factory Settings

To restore to factory settings, select Factory Reset from the Information menu. Press Control Knob when "YES" is highlighted and press Control Knob again to confirm "YES" when "YES/NO" window pops out for double confirmation. This will remove all stored memory settings, previous weld data and advanced settings presets and return to the factory settings.



Figure 4-11: Factory Reset Selected



Figure 4-12: Confirm Operation



Figure 4-13: Double Confirmation

### 3) Memory

Welding parameter for frequently used welding purposes can be saved to memory for future use. SAVE TO MEMORY button can be found on welding summary screen for MIG (GMAW / FCAW), TIG (GTAW) and STICK (MMAW) welding modes. Select SAVE TO MEMORY button by turning and pressing Control Knob and the display will enter Memory menu.



Figure 4-14: Save To Memory Selected

Turn the Control Knob to select a highlighted memory location that can be overwritten and confirm YES to save to memory and confirm YES to overwrite the selected previous memory.



Figure 4-15: Memory Menu



Figure 4-16: Confirm to Save to Memory



Figure 4-17: Confirm to Overwrite Memory

To recall welding parameter which has been saved to Memory, select MEMORY from the Home page and press Control Knob.



Figure 4-18: Memory Selected



Figure 4-19: Select Memory to Recall

Previous weld if selected will return to the previous weld screen either in MIG, TIG or Stick.

#### 4) Advanced Settings

Advanced features can be selected or set on welding summary page of MIG (GMAW / FCAW), TIG (GTAW) or STICK (MMAW) mode.



Figure 4-20: MIG Advanced Settings Menu



Figure 4-21: TIG Advanced Settings Menu



Figure 4-22: STICK Advanced Setting

##### a. TRIGGER MODE (MIG and Lift TIG modes)

The Trigger Mode control is used to switch the functionality of the torch trigger between 2T (normal) and 4T (latch mode). In 2T mode, the torch trigger must remain depressed for the welding output to be active. Press and hold the torch trigger to activate the power source (weld). Release the torch trigger switch to cease welding. 4T mode of welding is mainly used for long welding runs to reduce operator fatigue. In this mode the operator can press and release the torch trigger and the output will remain active. To deactivate the power source, the trigger switch must again be depressed and released, thus eliminating the need for the operator to hold the torch trigger.



**b. WIREFEEDER / SPOOL GUN (MIG mode)**

The Wirefeeder / Spool Gun selection is used in Mig Mode for wire feeding motor selection. When SPOOL GUN is ON and 8 pin plug of spool gun is connected to 8 pin socket on the front panel, the unit will detect the remote device and work accordingly. Note that only the trigger from the spool gun is connected via the 8 pin connection. When using the SGT250 Spool Gun with the Transmig 185 Ultra the remote wirefeed speed control located on the Spool Gun is not operational. Wirefeed speed for the Spool Gun can only be adjusted using the 185 Ultra Power Source wire feed speed control. When wirefeeder is ON, the unit will not detect the remote device and only the wire drive in the power source is operational and controlled from the power source controls only.

**c. SPOT WELDING (MIG mode)**

Spot welding is used to weld two thin plates together at a desired location by melting the top and bottom plates together to form a nugget between them. The weld time is set by the Spot Time.

**d. STITCH (MIG mode)**

Stitch is used to weld two or more components by stitch or interval weld together. The weld time is set by the Stitch Time and the non weld time is set by the Dwell Time.

**e. SW TIME (MIG mode)**

SW Time refers to spot time when Spot Welding is ON or STITCH time when Stitch is ON. Spot time is the time used for Spot weld mode. Adjustable time range is 0 - 20 seconds, factory default 2.0 seconds. Stitch time is the time used for the weld time in Stitch weld mode. Note Spot Welding must be ON in order to access Stitch Welding.

**f. DWELL TIME (MIG mode)**

Dwell Time is the time used for the non weld time in Stitch weld mode. Adjustable time range is 0 - 10 seconds, factory default 0.5 seconds.

**g. PRE FLOW (MIG mode)**

Shielding gas flows for the time specified before an arc is initiated. Adjustable time range is 0 - 10 seconds, factory default 0.1 seconds.

**h. POST FLOW (MIG mode)**

Shielding gas flows for the time specified after an arc has extinguished. Adjustable time range is 0 - 10 seconds, factory default 0.5 seconds.

**i. UP SLOPE (TIG mode)**

This parameter is used to set the time for the weld current to ramp up, after the torch trigger switch has been pressed then released, from initial current to peak or base current. Adjustable time range is 0 - 10 seconds, factory default 0.1 second.

**j. DOWN SLOPE (TIG mode)**

Down slope allows the user to select the ramp down time at the completion of the weld. The main function of down slope is to allow the welding current to be gradually reduced over a pre-set time frame such that the welding pool is given time to cool sufficiently. Adjustable range is 0 - 10 seconds, factory default 0.1 seconds.

Note that when in 2T normal mode, the unit will enter down slope mode as soon as the trigger switch is released. If no down slope time is selected then the welding output will cease immediately. If the unit is set to 4T latch mode, to enter down slope mode the trigger must be held in for the selected time period (ie press and release trigger to commence welding, then press and hold trigger again to enter down slope mode). Should the trigger be released during the down slope phase (4T only), the output will cease immediately.

**k. ARC FORCE**

In STICK (MMAW) mode, Arc Force control provides an adjustable amount of welding force (or “dig”) control. This feature can be particularly beneficial in providing the operator the ability to compensate for variability in joint fit-up in certain situations with particular electrodes. In general increasing the arc force control toward ‘100%’ (maximum arc force) allows greater penetration control to be achieved. Arc force is increased by turning the Home Knob clockwise or decreased by turning the knob anti-clockwise.

**l. VRD (STICK mode)**

A VRD (voltage reduction device) is a hazard reducing device designed to reduce electric shock hazards present on the output of welding power source when operating in STICK (MMAW) mode. Note that the presence of VRD should not be used as a substitute for the use of appropriate safety practices as indicated in Section One of this manual.

The VRD is ON when the VRD is active. Under this condition the open circuit voltage of the unit is limited to below 26V DC, thus reducing the potential of serious electric shock (such as when changing electrodes).

The VRD is OFF when the VRD is inactive. Under this condition the output voltage of the unit will be at welding potential which in some cases may exceed 26V DC.

**5) Error**

There are two possible Error screens.

1. Over Current Error (Figure 4-22)
2. Over Temperature Error (Figure 4-23)

If either of these screens appear, refer to Power Source Problems Table in Section 8.04.



Figure 4-23: Over Current Error



Figure 4-24: Over Temperature Error

#### 4.04 TWECO Fusion DX250 Digital Control MIG Torch, 3M, Euro (W4018900)

Tweco Fusion DX250 digital control MIG torch is supplied with Transmig 185 Ultra. It allows the user to adjust wire feed speed or voltage via buttons on the torch handle. Press and release button quickly for fine adjustment of wirespeed or voltage. Press and hold the button to increase in larger increments. Whilst adjusting these parameters via the torch controls these values can be viewed on the LCD screen.

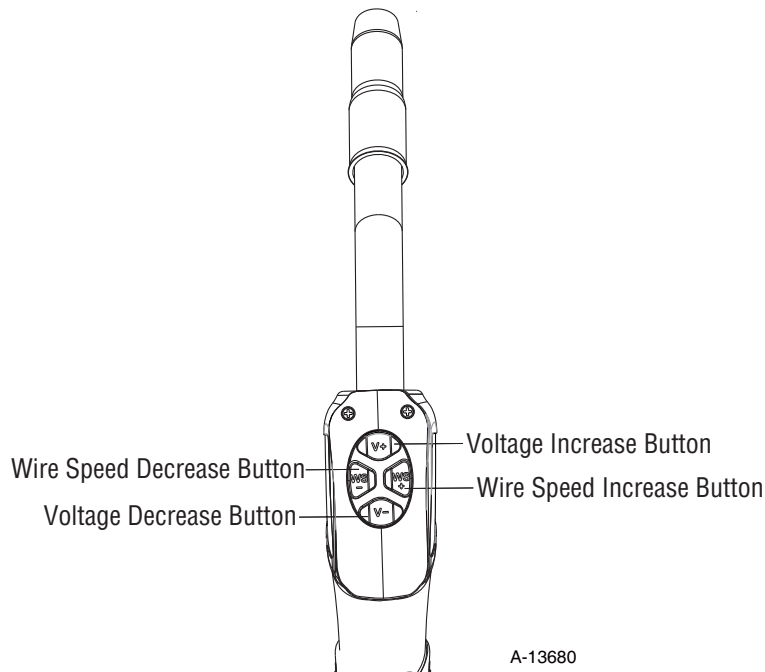


Figure 4-25: Tweco Fusion DX250 Torch Buttons



Figure 4-26: MIG Welding Summary Screen



## SECTION 5: MIG (GMAW) WELDING

### 5.01 Shielding Gas Regulator/Flowmeter Operating Instructions

**WARNING**

This equipment is designed for use with welding grade (Inert) shielding gases only.

**Shielding Gas Regulator/Flowmeter Safety**

This regulator/flowmeter is designed to reduce and control high pressure gas from a cylinder or pipeline to the working pressure required for the equipment using it.

If the equipment is improperly used, hazardous conditions are created that may cause accidents. It is the users responsibility to prevent such conditions. Before handling or using the equipment, understand and comply at all times with the safe practices prescribed in this instruction.

SPECIFIC PROCEDURES for the use of regulators/flowmeters are listed below.

1. NEVER subject the regulator/flowmeter to inlet pressure greater than its rated inlet pressure.
2. NEVER pressurize a regulator/flowmeter that has loose or damaged parts or is in a questionable condition. NEVER loosen a connection or attempt to remove any part of a regulator/flowmeter until the gas pressure has been relieved. Under pressure, gas can dangerously propel a loose part.
3. DO NOT remove the regulator/flowmeter from a cylinder without first closing the cylinder valve and releasing gas in the regulator/flowmeter high and low pressure chambers.
4. DO NOT use the regulator/flowmeter as a control valve. When downstream equipment is not in use for extended periods of time, shut off the gas at the cylinder valve and release the gas from the equipment.
5. OPEN the cylinder valve SLOWLY. Close after use.

**User Responsibilities**

This equipment will perform safely and reliable only when installed, operated and maintained, and repaired in accordance with the instructions provided. Equipment must be checked periodically and repaired, replaced, or reset as necessary for continued safe and reliable performance. Defective equipment should not be used. Parts that are broken, missing, obviously worn, distorted, or contaminated should be replaced immediately.

The user of this equipment will generally have the sole responsibility for any malfunction, which results from improper use, faulty maintenance, or by repair by anyone other than an accredited repairer.

**CAUTION**

Match regulator/flowmeter to cylinder. NEVER CONNECT a regulator/flowmeter designed for a particular gas or gases to a cylinder containing any other gas.

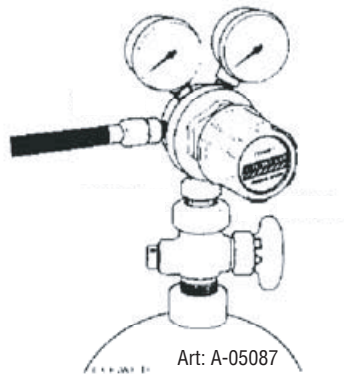


Figure 5-1: Fit Regulator/flowmeter to Cylinder

### Installation

1. Remove cylinder valve plastic dust seal. Clean the cylinder valve outlet of impurities that may clog orifices and damage seats before connecting the regulator/flowmeter.

Crack the valve (open then close) momentarily, pointing the outlet away from people and sources of ignition. Wipe with a clean lint free cloth.

2. Match regulator/flowmeter to cylinder. Before connecting, check that the regulator/flowmeter label and cylinder marking agree and that the regulator/flowmeter inlet and cylinder outlet match. NEVER CONNECT a regulator/flowmeter designed for a particular gas or gases to a cylinder containing any other gas.
3. Connect the regulator/flowmeter inlet connection to cylinder or pipeline and tighten it firmly but not excessively, with a suitable spanner.
4. Connect and tighten the outlet hose firmly and attach down-stream equipment.
5. To protect sensitive down-stream equipment a separate safety device may be necessary if the regulator/flowmeter is not fitted with a pressure relief device.

### Operation

With the regulator/flowmeter connected to cylinder or pipeline, and the adjustment screw/knob fully disengaged, pressurize as follows:

1. Stand to one side of regulator/flowmeter and slowly open the cylinder valve. If opened quickly, a sudden pressure surge may damage internal regulator/flowmeter parts.
2. With valves on downstream equipment closed, adjust regulator/flowmeter to approximate working pressure. It is recommended that testing for leaks at the regulator/flowmeter connection points be carried out using a suitable leak detection solution or soapy water.
3. Purge air or other unwanted welding grade shielding gas from equipment connected to the regulator/flowmeter by individually opening then closing the equipment control valves. Complete purging may take up to ten seconds or more, depending upon the length and size of the hose being purged.

## Adjusting Flow Rate

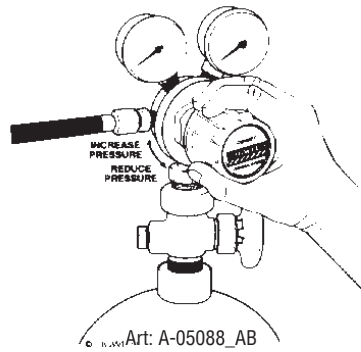


Figure 5-2: Adjust Flow Rate

With the regulator/flowmeter ready for operation, adjust working flow rate as follows:

1. Slowly turn adjusting screw/knob in (clockwise) direction until the outlet gauge indicates the required flow rate.



**NOTE!**

It may be necessary to re-check the shielding gas regulator/flowmeter flow rate following the first weld sequence due to back pressure present within shielding gas hose assembly.

2. To reduce flow rate, allow the welding grade shielding gas to discharge from regulator/flowmeter by opening the downstream valve. Bleed welding grade shielding gas into a well ventilated area and away from any ignition source. Turn adjusting screw counterclockwise, until the required flow rate is indicated on the gauge. Close downstream valve.

## Shutdown

Close cylinder valve whenever the regulator/flowmeter is not in use. To shut down for extended periods (more than 30 minutes).

1. Close cylinder or upstream valve tightly.
2. Open downstream equipment valves to drain the lines. Bleed gas into a well ventilated area and away from any ignition source.
3. After gas is drained completely, disengage adjusting screw and close downstream equipment valves.
4. Before transporting cylinders that are not secured on a cart designed for such purposes, remove regulators/flowmeters.

## 5.02 Attaching the Tweco Fusion DX250 Digital Control MIG Torch (Euro)

Fit the MIG Torch to the power source by pushing the MIG torch connector into the MIG torch adaptor and screwing the plastic torch nut clockwise to secure the MIG torch to the MIG torch adaptor.

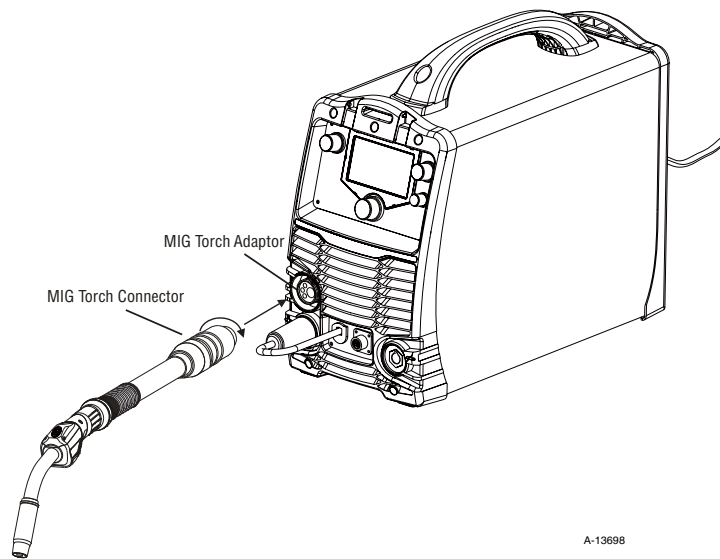


Figure 5-3: Attaching MIG Torch

## 5.03 Installing Minispool (100mm diameter)

As delivered from the factory, the unit is fitted with a Wire Spool Hub which accepts a Handispool of 200mm diameter.

In order to fit a Minispool (100mm diameter) assemble parts in the sequence shown below in Figure 5-4.

Adjustment of the nut with nylon insert will control the Mig Wire Spool Brake. Clockwise rotation of this nut with nylon insert tightens the brake. The brake is correctly adjusted when the spool stops within 10 to 20mm (measured at the outer edge of the spool) after Mig Torch trigger is released. Wire should be slack without becoming dislodged from the spool. Note Wire Spool Hub not required to be used for 100mm size spools. As shown.



### CAUTION

Overtension of brake will cause rapid wear of mechanical WIREFEED parts, overheating of electrical componentry and possibly an increased incidence of electrode wire Burnback into contact tip.

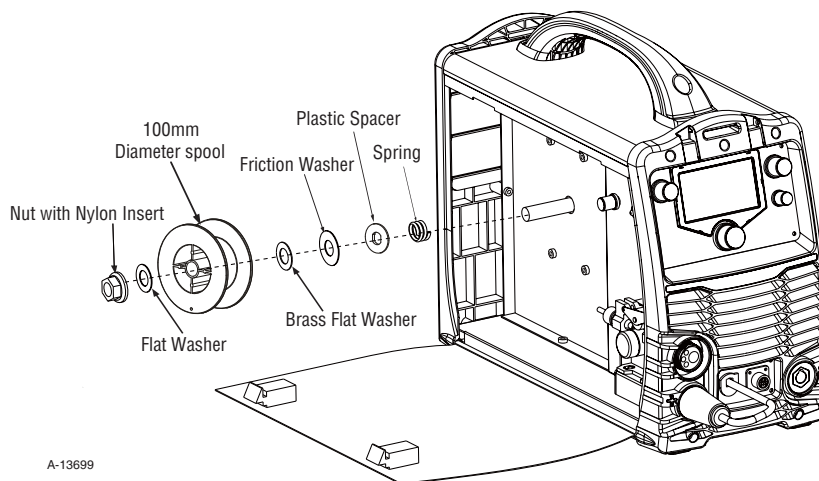


Figure 5-4: 100mm Spool Installation

### 5.04 Installing Handispool (200mm diameter)

As delivered from the factory, the unit is set for a Handispool (200mm diameter).

In order to re-fit a 200mm spool assemble parts in the sequence shown below in Figure 5-5.

Adjustment of the nut with nylon insert will control the Mig Wire Spool Brake. Clockwise rotation of this nut with nylon insert tightens the brake. The Brake is correctly adjusted when the spool stops within 10 to 20mm (measured at the outer edge of the spool) after Mig Torch trigger is released. Wire should be slack without becoming dislodged from the spool.



#### CAUTION

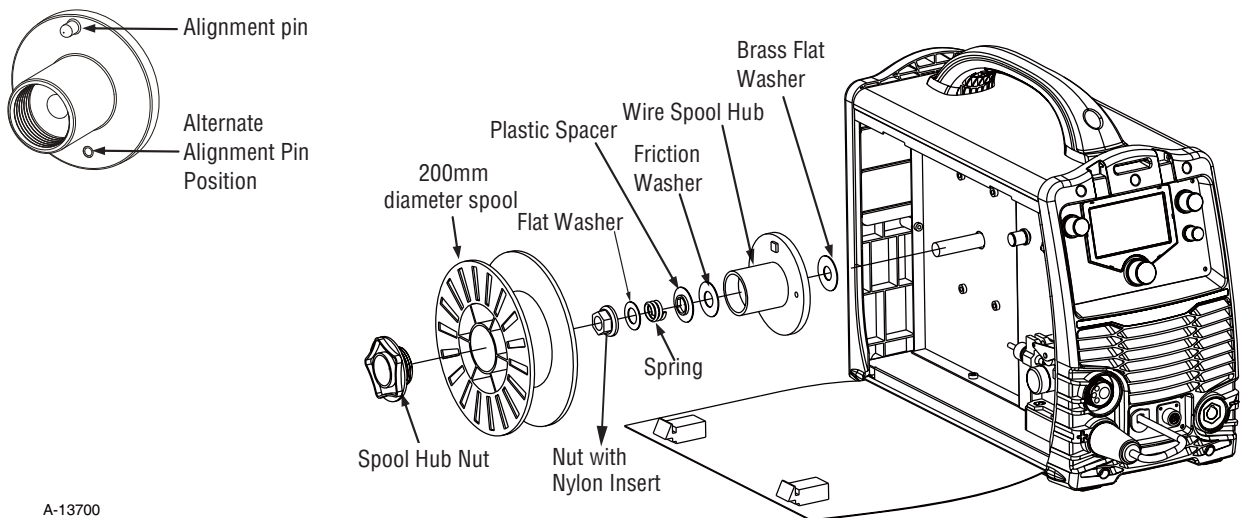
Overtension of brake will cause rapid wear of mechanical WIREFEED parts, overheating of electrical componentry and possibly an increased incidence of electrode wire Burnback into contact tip.

Ensure that the alignment pin on the wire spool hub aligns with the hole allocated in the Handispool.



#### NOTE!

This alignment pin can be removed by unscrewing in an anticlockwise direction and locating in the appropriate position.



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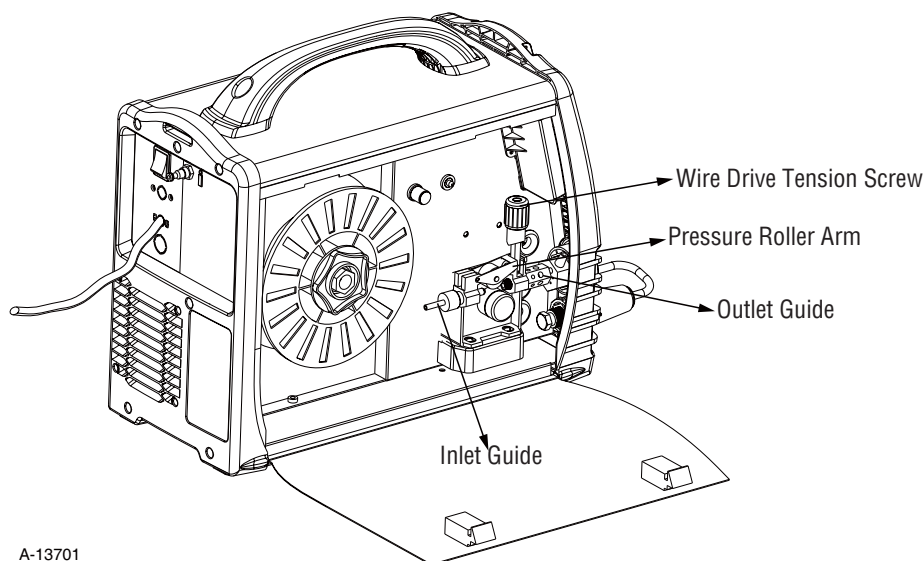
Figure 5-5: 200mm Handispool Installation

### 5.05 Inserting Wire into the Wire Feed Mechanism

Release the tension from the pressure roller by turning the adjustable wire drive tension screw in an anti-clockwise direction. Then to release the pressure roller arm pull the pressure roller arm tension screw forward to release the pressure roller arm (Figure 5-6). With the MIG welding wire feeding from the bottom of the spool (Figure 5-7) pass the electrode wire through the inlet guide, between the rollers, through the outlet guide and into the MIG torch. Re-secure the pressure roller arm and wire drive tension screw and adjust the pressure accordingly (Figure 5-6). Remove the contact tip from the MIG torch. With the MIG Torch lead reasonably straight, feed the wire through the torch by depressing the trigger switch. Fit the appropriate contact tip.

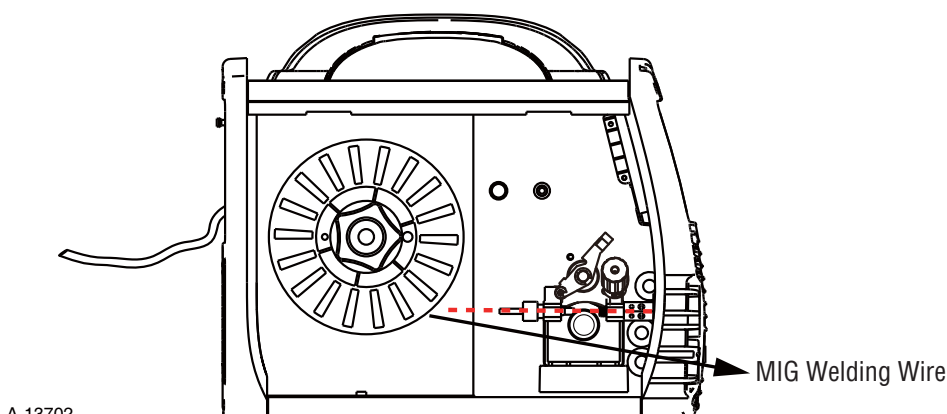
**WARNING**

Before connecting the work clamp to the work make sure the mains power supply is switched off. The electrode wire will be at welding voltage potential while it is being feed through the system. Keep Mig Torch away from eyes and face.



A-13701

Figure 5-6: Wire Drive Assembly Components



A 13702

Figure 5-7: Mig Welding Wire - Installation

## 5.06 Feed Roller Pressure Adjustment

The pressure (top) roller applies pressure to the grooved feed roller via an adjustable pressure screw. These devices should be adjusted to a minimum pressure that will provide satisfactory WIREFEED without slippage. If slipping occurs, and inspection of the wire contact tip reveals no wear, distortion or burn back jam, the conduit liner should be checked for kinks and clogging by metal flakes and swarf. If it is not the cause of slipping, the feed roll pressure can be increased by rotating the pressure screw clockwise.



### WARNING

Before changing the feed roller ensure that the mains supply to the power source is switched off.



### CAUTION

The use of excessive pressure may cause rapid wear of the feed rollers, shafts and bearing.

## 5.07 Changing the Feed Roll

To change feed roll remove the feed roll retaining screw by turning in an anticlockwise direction. Once the feed roll is removed then to replace feed roll simply reverse these directions.

A dual groove feed roller is supplied as standard. It can accommodate 0.8/0.9mm diameter hard wires. Select the roller required with the chosen wire size marking facing outward.

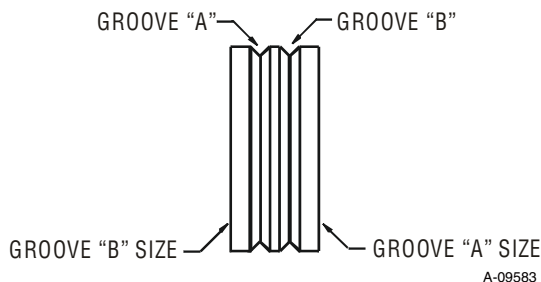


Figure 5-8: Dual Groove Feed Roller

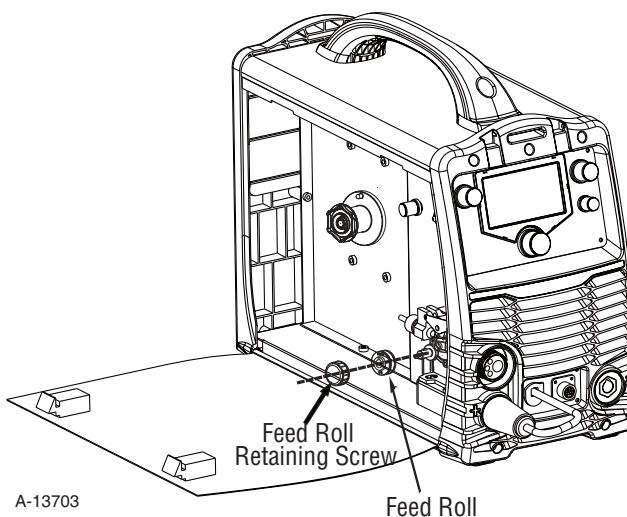


Figure 5-9: Changing the Feed Roll



## 5.08 Wire Reel Brake

The wire reel hub incorporates a friction brake which is adjusted during manufacture for optimum breaking. If it is considered necessary, adjustment can be made by turning the large nut inside the open end of the hub clockwise to tighten the brake. Correct adjustment will result in the wire reel circumference continuing no further than 10-20mm after release of the trigger. The electrode wire should be slack without becoming dislodged from wire spool.

**CAUTION**

Overtension of brake will cause rapid wear of mechanical WIREFEED parts, overheating of electrical componentry and possibly an increased incidence of electrode wire Burnback into contact tip.

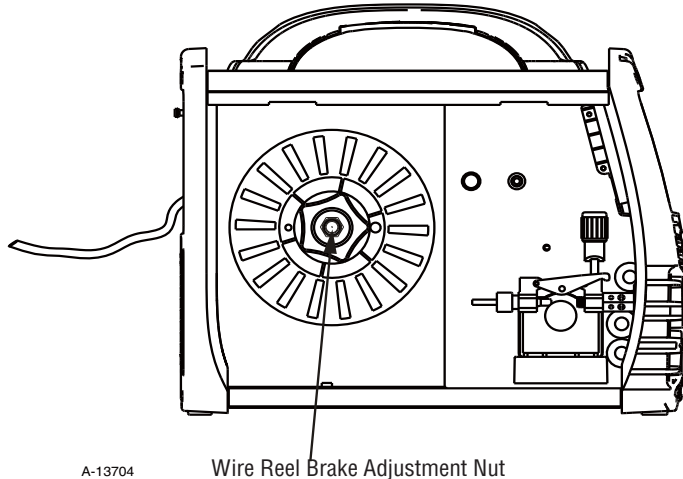


Figure 5-10: Wire Reel Brake

## 5.09 Setup for Auto Set (Synergic) MIG (GMAW) Welding with Gas Shielded Mig Wire

- Switch the Power Source On/Off switch located on the rear of the Power Source to the OFF position.
- Fit the MIG Torch to the Power Source. (Refer to Section 5.02 Attaching the Tweco Fusion DX250 MIG Torch).
- Connect the Mig torch polarity lead to the positive welding terminal (+). If in doubt, consult the electrode wire manufacturer. Welding current flows from the Power Source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.

**CAUTION**

Loose welding terminal connections can cause overheating and result in the male plug being fused in the terminal. Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.

- Fit the welding grade shielding gas regulator / flowmeter to the shielding gas cylinder (refer to Section 5.01) then connect the shielding gas hose from the shielding gas regulator / flowmeter outlet to the quick connect Shielding Gas Inlet fitting gas on the rear of the Transmig 185 Ultra Power Source. Ensure that the shielding gas hose connection is sufficiently tight at the regulator connection and the quick connect fitting "locks" into place correctly on the rear of the power source.

**WARNING**

Secure the welding grade shielding gas cylinder in an upright position by chaining it to a suitable stationary support to prevent falling or tipping.

- Fit the correct Feed Roll for the Gas Shielded MIG wire being used. Refer to Section 2.11 Options and Accessories for Feed Roll types and Part Numbers.

- F. Place the MIG wire spool onto the spool holder. Refer to Sections 5.03 for 100mm diameter spools or 5.04 for 200mm diameter spools.
- G. Feed wire through the wire drive mechanism. Refer to Section 5.05.
- H. Switch the Power Source On/Off switch located on the rear of the Power Source to the On position and ensure the LCD screen is illuminated.
- I. Select MIG Auto Set mode.



Figure 5-11: Home Screen

- J. Select welding material type.



Figure 5-12: Welding Material Menu

- K. Select welding wire diameter.



Figure 5-13: Wire Diameter Menu

- L. Select material thickness.



Figure 5-14: Material Thickness Screen

- M. Welding summary screen displays preset welding parameter.



Figure 5-15: MIG Welding Summary Screen

- N. To set trigger mode (2T / 4T), preflow time, post flow time, and spot welding parameters, select ADVANCED SETTINGS. Refer to Section 4.03.4 for detailed explanation of advanced features. When finished setting, select OK to return to welding summary screen.



Figure 5-16: MIG Advanced Settings Menu

- O. Actual welding amperage and voltage will be displayed during welding and held for 10 seconds after welding.



Figure 5-17: Welding Screen

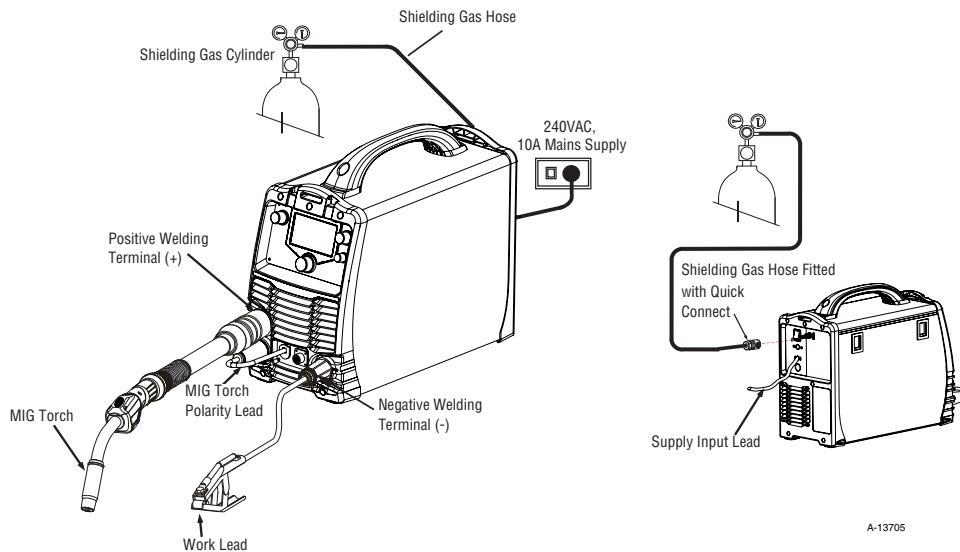


Figure 5-18: Setup for Mig Welding with Gas Shielded Mig Wire

## 5.10 Setup for Auto Set (Synergic) MIG (FCAW) Welding with Gasless MIG Wire

- Switch the Power Source On/Off switch located on the rear of the Power Source to the OFF position.
- Fit the MIG Torch to the Power Source. (Refer to Section 5.02 Attaching the Tweco Fusion DX250 MIG Torch).
- Connect the Mig Torch polarity lead to the negative welding terminal (-). If in doubt, consult the electrode wire manufacturer. Welding current flows from the power source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.



### CAUTION

Loose welding terminal connections can cause overheating and result in the male plug being fused in the terminal. Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.

- Connect the work lead to the positive welding terminal (+). If in doubt, consult the electrode wire manufacturer. Welding current flows from the power source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.



### WARNING

Before connecting the work clamp to the work make sure the mains power supply is switched off.

- Fit the correct V Knurled Feed Roll for the Gasless MIG wire being used. Refer to Section 2.11 Options and Accessories for Feed Roll types and Part Numbers

- F. Place the MIG wire spool onto the spool holder. Refer to Sections 5.03 for 100mm diameter spools or 5.04 for 200mm diameter spools.
- G. Feed wire through the wire drive mechanism. Refer to Section 5.05.
- H. Switch the Power Source On/Off switch located on the rear of the Power Source to the On position and ensure the LCD on the Front Panel is illuminated.
- I. Select MIG Auto Set mode.



Figure 5-19: Home Screen

- J. Select welding material type.



Figure 5-20: Welding Material Menu

- K. The 'Check Polarity' screen will be displayed for 10 seconds. To move on to the next screen immediately - press the Control Knob.



Figure 5-21: Check Polarity Screen

- L. Select welding wire diameter.



Figure 5-22: Wire Diameter Menu

- M. Select material thickness.



Figure 5-23: Material Thickness Screen

- N. Welding summary screen displays preset welding parameter.



Figure 5-24: MIG Welding Summary Screen

- O. To set trigger mode (2T / 4T), preflow time, post flow time, and spot welding parameters, select ADVANCED SETTINGS. Refer to Section 4.03.4 for detailed explanation of advanced features. When finished setting, select OK to return to welding summary screen.



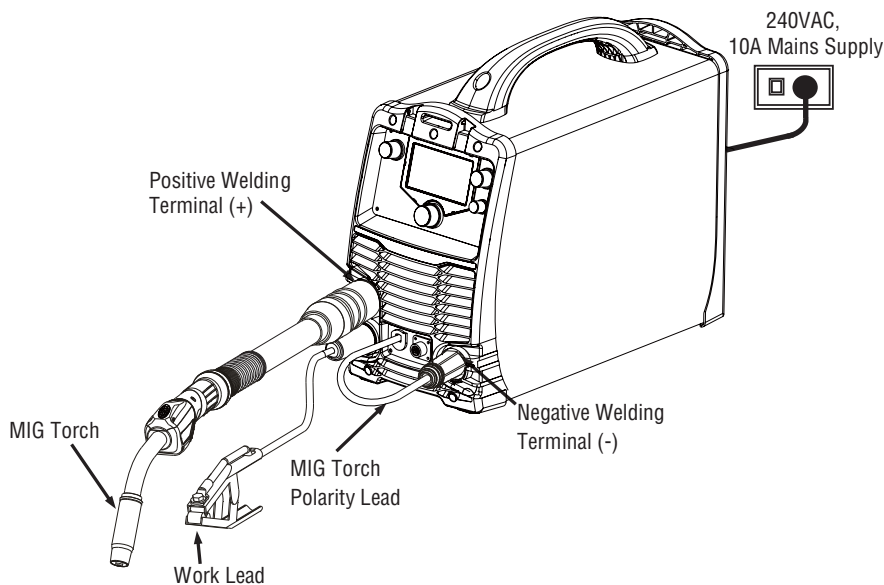
Figure 5-25: MIG Advanced Settings Menu



- P. Actual welding amperage and voltage will be displayed during welding and held for 10 seconds after welding.



Figure 5-26: Welding Screen



A-13706

Figure 5-27: Setup for Mig Welding with Gasless Mig Wire

## 5.11 Setup for Manual MIG (GMAW) Welding with Gas Shielded MIG Wire

- Switch the Power Source On/Off switch located on the rear of the Power Source to the OFF position.
- Fit the MIG Torch to the Power Source. (Refer to Section 5.02 Attaching the Tweco Fusion DX250 MIG Torch).
- Connect the Mig torch polarity lead to the positive welding terminal (+). If in doubt, consult the electrode wire manufacturer. Welding current flows from the Power Source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.



### CAUTION

Loose welding terminal connections can cause overheating and result in the male plug being fused in the terminal. Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.

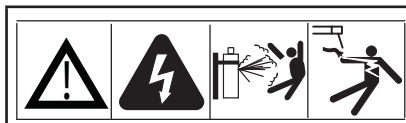
- Connect the work lead to the negative welding terminal (-). If in doubt, consult the electrode wire manufacturer. Welding current flows from the Power Source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.



### WARNING

Before connecting the work clamp to the work make sure the mains power supply is switched off.

- E. Fit the welding grade shielding gas regulator/flowmeter to the shielding gas cylinder (refer to Section 5.01) then connect the shielding gas hose from the shielding gas regulator/flowmeter outlet to the quick connect Shielding Gas Inlet fitting gas on the rear of the Transmig 185 Ultra Power Source. Ensure that the shielding gas hose connection is sufficiently tight at the regulator connection and the quick connect fitting "locks" into place correctly on the rear of the power source.

**WARNING**

Secure the welding grade shielding gas cylinder in an upright position by chaining it to a suitable stationary support to prevent falling or tipping.

- F. Fit the correct Feed Roll for the Gas Shielded MIG wire being used. Refer to Section 2.11 Options and Accessories for Feed Roll types and Part Numbers.
- G. Place the MIG wire spool onto the spool holder. Refer to Sections 5.03 for 100mm diameter spools or 5.04 for 200mm diameter spools.
- H. Feed wire through the wire drive mechanism. Refer to Section 5.05.
- I. Switch the Power Source On/Off switch located on the rear of the Power Source to the On position and ensure the LCD screen is illuminated.
- J. Select MIG Manual mode to enter welding summary screen. Turn wirefeed speed control knob or voltage control knob to preset wire feed speed and voltage. As a guide for the welding parameter settings for the welding job refer to the Weld Guide located on the inside of the wirefeed compartment door. After welding, current and voltage value will be held for 10 seconds.



Figure 5-28: Home Screen



Figure 5-29: MIG Manual Mode Welding Summary Screen

- K. To set trigger mode (2T / 4T), preflow time, post flow time, and spot welding parameters, select ADVANCED SETTINGS. Refer to Section 4.03.4 for detailed explanation of advanced features. When finished setting, select OK to return to welding summary screen.



Figure 5-30: MIG Advanced Settings Menu

See overpage for setup diagram for MIG welding with gas shielded MIG wire.

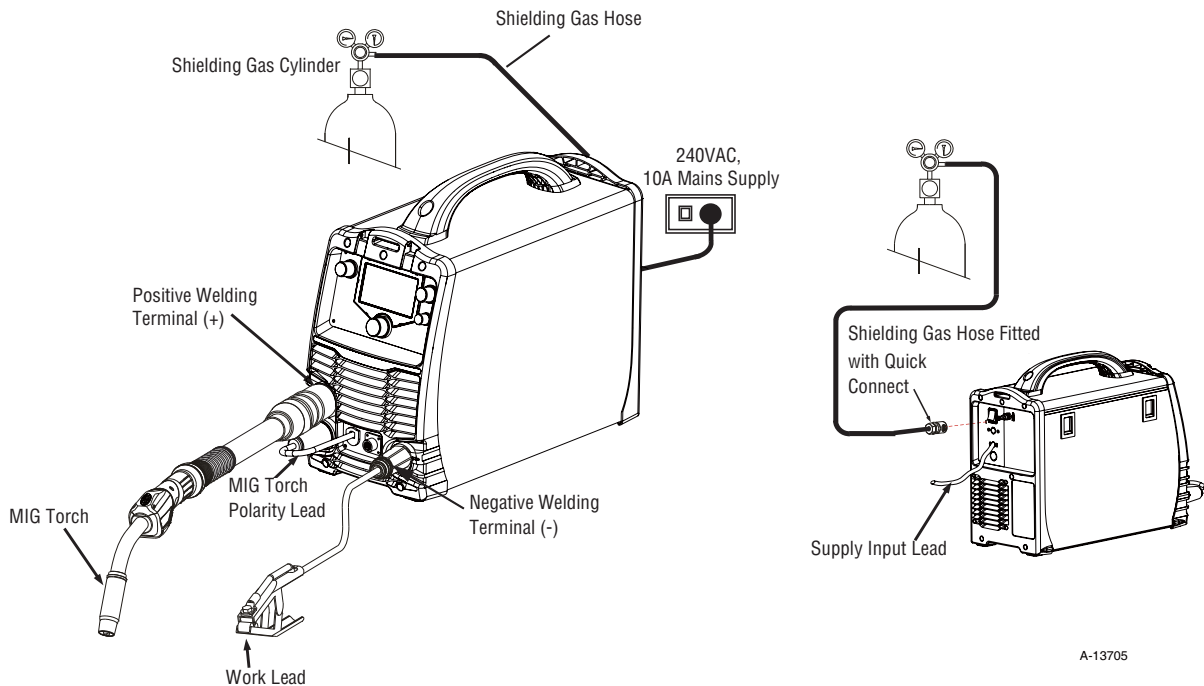


Figure 5-31: Setup for Mig Welding with Gas Shielded Mig Wire

## 5.12 Setup for Manual MIG (FCAW) Welding with Gasless MIG Wire

- Switch the Power Source On/Off switch located on the rear of the Power Source to the OFF position.
- Fit the MIG Torch to the Power Source. (Refer to Section 5.02 Attaching the Tweco Fusion DX250 MIG Torch).
- Connect the Mig Torch polarity lead to the negative welding terminal (-). If in doubt, consult the electrode wire manufacturer. Welding current flows from the power source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.



### CAUTION

Loose welding terminal connections can cause overheating and result in the male plug being fused in the terminal. Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.

- Connect the work lead to the positive welding terminal (+). If in doubt, consult the electrode wire manufacturer. Welding current flows from the power source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.



### WARNING

Before connecting the work clamp to the work make sure the mains power supply is switched off.

- Fit the correct V Knurled Feed Roll for the Gasless MIG wire being used. Refer to Section 2.11 Options and Accessories for Feed Roll types and Part Numbers
- Place the MIG wire spool onto the spool holder. Refer to Sections 5.03 for 100mm diameter spools or 5.04 for 200mm diameter spools.
- Feed wire through the wire drive mechanism. Refer to Section 5.05.
- Switch the Power Source On/Off switch located on the rear of the Power Source to the On position and ensure the LCD Screen on the Front Panel is illuminated.



- I. Select MIG Manual Set mode from home page. Welding summary screen displays preset value of wire feed speed, voltage and arc control. As a guide for the welding parameter settings for the welding job refer to the Weld Guide located on the inside of the wirefeed compartment door. Welding current and voltage will be held for 10 seconds after welding.



Figure 5-32: Home Screen

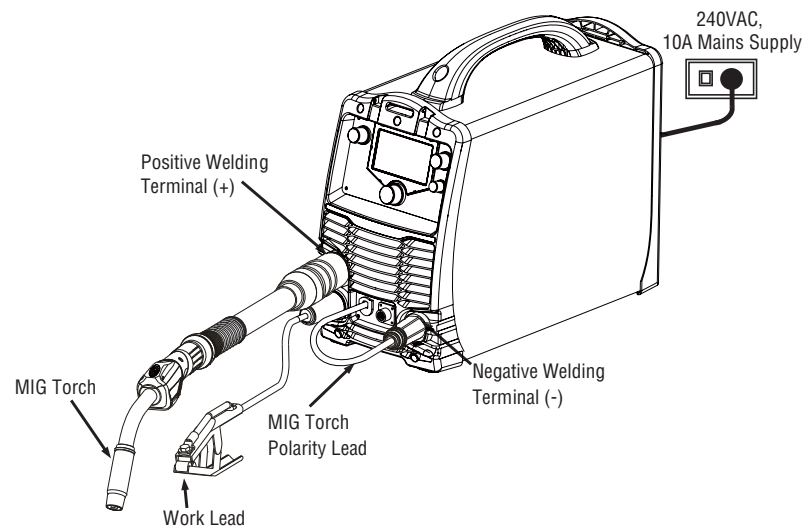


Figure 5-33: MIG Manual Mode Welding Summary Screen

- J. To set trigger mode (2T / 4T), preflow time, post flow time, and spot welding parameters, select ADVANCED SETTINGS. Refer to Section 4.03.4 for detailed explanation of advanced features. When finished setting, select OK to return to welding summary screen.



Figure 5-34: MIG Advanced Settings Menu



A-13706

Figure 5-35: Setup for Mig Welding with Gasless Mig Wire

### 5.13 Setup for SPOOL GUN MIG (GMAW) Welding with Gas Shielded Mig Wire

- A. Switch the Power Source On/Off switch located on the rear of the Power Source to the OFF position.
- B. Connect the Mig torch polarity lead to the positive welding terminal (+). If in doubt, consult the wire manufacturer. Welding current flows from the Power Source via Dinse type terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.

**CAUTION**

Loose welding terminal connections can cause overheating and result in the male plug being fused in the terminal. Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.

- B. Fit the Euro Spool Gun to the power source using the front panel EURO torch adaptor (refer also to Section 5.02 Attaching the Tweco Fusion DX250 Mig Gun). Connect the 8 pin Remote Control Plug to the 8 pin Remote Control Socket on the power source. Ensure 8 pin plug is correctly fitted to the 8 pin socket on front panel and collar on plug is tightened firmly.

**NOTE!**

When using the SGT250 Spool Gun with the Transmig 185 Ultra the remote wirefeed speed control located on the Spool Gun is not operational. Wirefeed speed for the Spool Gun can only be adjusted using the 185 Ultra Power Source wire feed speed control.

- C. Connect the work lead to the negative welding terminal (-). If in doubt, consult the wire manufacturer. Welding current flows from the Power Source via Dinse type terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.

**WARNING**

Before connecting the work clamp to the work make sure the mains power supply is switched off.

- D. Fit the welding grade shielding gas regulator/flowmeter to the shielding gas cylinder (refer to Section 5.01) then connect the shielding gas hose from the shielding gas regulator/flowmeter outlet to the quick connect Shielding Gas Inlet fitting gas on the rear of the Transmig 185 Ultra Power Source. Ensure that the shielding gas hose connection is sufficiently tight at the regulator connection and the quick connect fitting "locks" into place correctly on the rear of the power source.
- E. Switch the Power Source On/Off switch located on the rear of the Power Source to the On position and ensure the LCD Screen on the Front Panel is illuminated.
- F. Select MANUAL SET mode from home page.



Figure 5-36: Home Screen

- G. Select Advanced Settings. Set Wirefeeder OFF and Spool Gun ON.



Figure 5-37: MIG Advanced Settings Menu

- H. Welding summary screen displays preset value of wire feed speed, voltage and arc control. Turn wire speed control knob or voltage control knob to make necessary adjustment. Welding current and voltage will be held for 10 seconds after welding.



Figure 5-38: MIG Manual Mode Welding Summary Screen

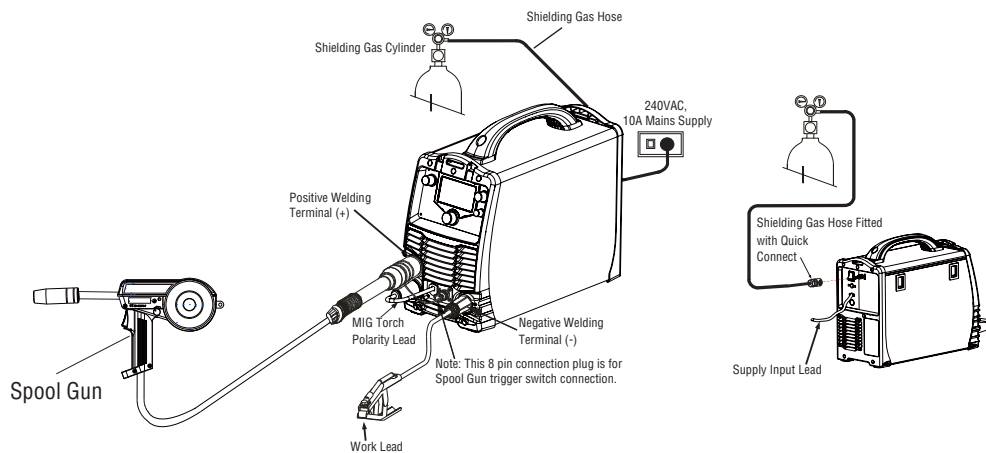


Figure 5-39: Setup for Spool Gun Mig Welding with Gas Shielded Mig Wire



**NOTE!**

When using the SGT250 Spool Gun with the Transmig 185 Ultra the remote wirefeed speed control located on the Spool Gun is not operational. Wirefeed speed for the Spool Gun can only be adjusted using the 185 Ultra Power Source wire feed speed control.

## 5.14 MIG (GMAW/FCAW) Basic Welding Technique

Two different welding processes are covered in this section (GMAW and FCAW), with the intention of providing the very basic concepts in using the Mig mode of welding, where a welding gun is hand held, and the electrode (welding wire) is fed into a weld puddle, and the arc is shielded by an inert welding grade shielding gas or inert welding grade shielding gas mixture.

**GAS METAL ARC WELDING (GMAW):** This process, also known as MIG welding, CO<sub>2</sub> welding, Micro Wire Welding, short arc welding, dip transfer welding, wire welding etc., is an electric arc welding process which fuses together the parts to be welded by heating them with an arc between a solid continuous, consumable electrode and the work. Shielding is obtained from an externally supplied welding grade shielding gas or welding grade shielding gas mixture. The process is normally applied semi automatically; however the process may be operated automatically and can be machine operated. The process can be used to weld thin and fairly thick steels, and some non-ferrous metals in all positions.

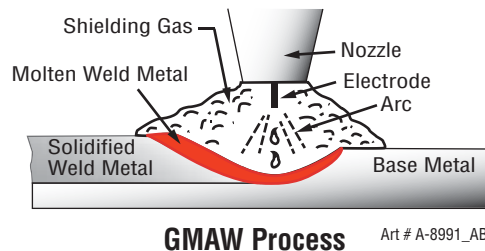


Figure 5-40

**FLUX CORED ARC WELDING (FCAW):** This is an electric arc welding process which fuses together the parts to be welded by heating them with an arc between a continuous flux filled electrode wire and the work. Shielding is obtained through decomposition of the flux within the tubular wire. Additional shielding may or may not be obtained from an externally supplied gas or gas mixture. The process is normally applied semi automatically; however the process may be applied automatically or by machine. It is commonly used to weld large diameter electrodes in the flat and horizontal position and small electrode diameters in all positions. The process is used to a lesser degree for welding stainless steel and for overlay work.

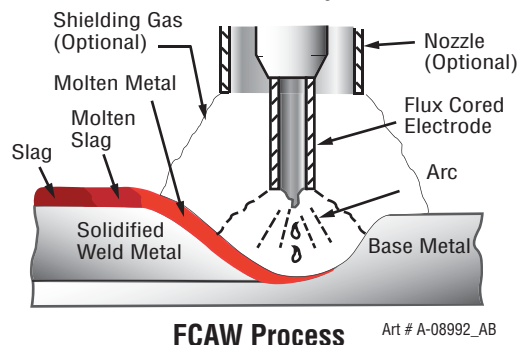


Figure 5-41

### Position of MIG Torch

The angle of MIG torch to the weld has an effect on the width of the weld.

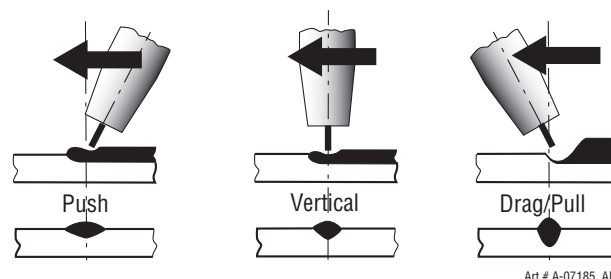


Figure 5-42

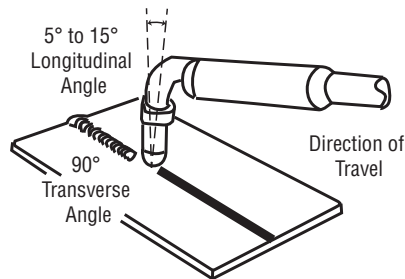
The welding gun should be held at an angle to the weld joint. (see Secondary Adjustment Variables below)

Hold the gun so that the welding seam is viewed at all times. Always wear the welding helmet with proper filter lenses and use the proper safety equipment.

**CAUTION**

Do not pull the welding gun back when the arc is established. This will create excessive wire extension (stick-out) and make a very poor weld.

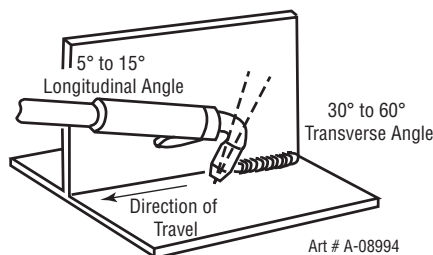
The electrode wire is not energized until the gun trigger switch is depressed. The wire may therefore be placed on the seam or joint prior to lowering the helmet.



Art # A-08993

Butt &amp; Horizontal Welds

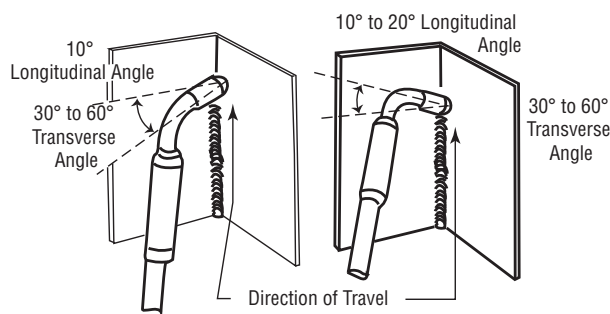
Figure 5-43



Art # A-08994

Horizontal Fillet Weld

Figure 5-44



Art # A-08995

Vertical Fillet Welds

Figure 5-45

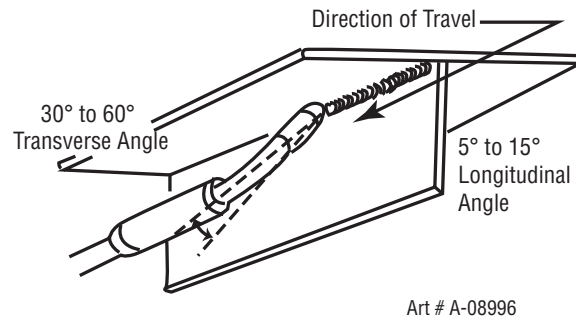


Figure 5-46

### Distance from the MIG Torch Nozzle to the Work Piece

The electrode wire stick out from the MIG Torch nozzle should be between 10mm to 20.0mm. This distance may vary depending on the type of joint that is being welded.

### Travel Speed

The speed at which the molten pool travels influences the width of the weld and penetration of the welding run.

### MIG Welding (GMAW) Variables

Most of the welding done by all processes is on carbon steel. The items below describe the welding variables in short-arc welding of 24gauge (0.024", 0.6mm) to 1/4" (6.4mm) mild sheet or plate. The applied techniques and end results in the GMAW process are controlled by these variables.

#### Preselected Variables

Preselected variables depend upon the type of material being welded, the thickness of the material, the welding position, the deposition rate and the mechanical properties. These variables are:

- Type of electrode wire
- Size of electrode wire
- Type of gas (not applicable to self shielding wires FCAW)
- Gas flow rate (not applicable to self shielding wires FCAW)

#### Primary Adjustable Variables

These control the process after preselected variables have been found. They control the penetration, bead width, bead height, arc stability, deposition rate and weld soundness. They are:

- Arc Voltage
- Welding current (wire feed speed)
- Travel speed

## Secondary Adjustable Variables

These variables cause changes in primary adjustable variables which in turn cause the desired change in the bead formation. They are:

1. Stick-out (distance between the end of the contact tube (tip) and the end of the electrode wire). Maintain at about 10mm stick-out.
2. Wire Feed Speed. Increase in wire feed speed increases weld current, Decrease in wire feed speed decreases weld current.

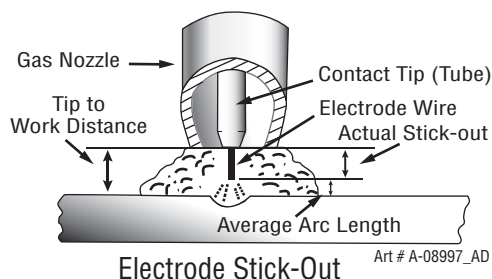


Figure 5-47

3. Nozzle Angle. This refers to the position of the welding gun in relation to the joint. The transverse angle is usually one half the included angle between plates forming the joint. The longitudinal angle is the angle between the centre line of the welding gun and a line perpendicular to the axis of the weld. The longitudinal angle is generally called the Nozzle Angle and can be either trailing (pulling) or leading (pushing). Whether the operator is left handed or right handed has to be considered to realize the effects of each angle in relation to the direction of travel.

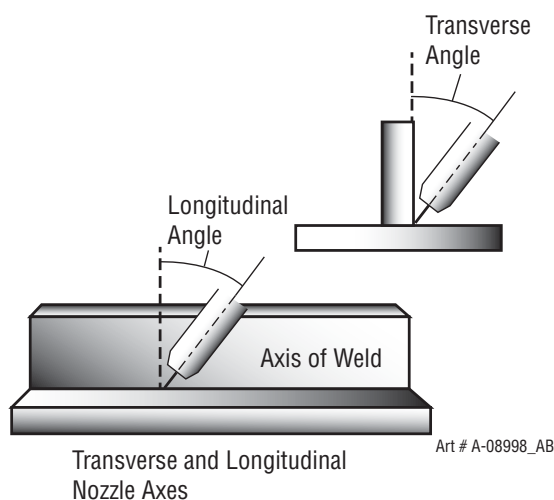


Figure 5-48

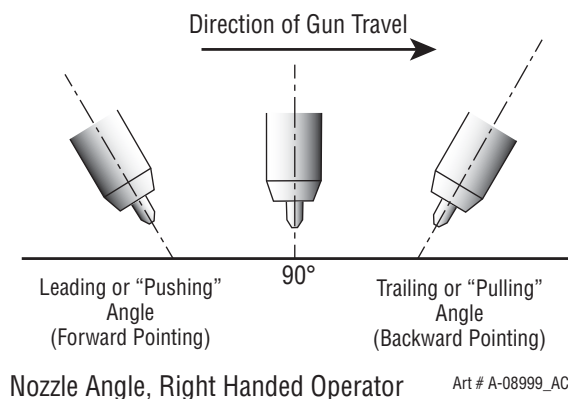


Figure 5-49



### Establishing the Arc and Making Weld Beads

Before attempting to weld on a finished piece of work, it is recommended that practice welds be made on a sample metal of the same material as that of the finished piece.

The easiest welding procedure for the beginner to experiment with MIG welding is the flat position. The equipment is capable of flat, vertical and overhead positions.

For practicing MIG welding, secure some pieces of 16 or 18 gauge (0.06" 1.5mm or 0.08" 2.0mm) mild steel plate 6" x 6" (150 x 150mm). Use 0.030" (0.8mm) flux cored gasless wire or a solid wire with shielding gas.

### Setting of the Power Source

Power source and Wirefeeder setting requires some practice by the operator, as the welding plant has two control settings that have to balance. These are the Wirespeed control (refer to Section 4.02.2) and the welding Voltage Control (refer to Section 4.02.3). The welding current is determined by the Wirespeed control, the current will increase with increased Wirespeed, resulting in a shorter arc. Less wire speed will reduce the current and lengthen the arc. Increasing the welding voltage hardly alters the current level, but lengthens the arc. By decreasing the voltage, a shorter arc is obtained with a little change in current level.

When changing to a different electrode wire diameter, different control settings are required. A thinner electrode wire needs more Wirespeed to achieve the same current level.

A satisfactory weld cannot be obtained if the Wirespeed and Voltage settings are not adjusted to suit the electrode wire diameter and the dimensions of the work piece.

If the Wirespeed is too high for the welding voltage, "stubbing" will occur as the wire dips into the molten pool and does not melt. Welding in these conditions normally produces a poor weld due to lack of fusion. If, however, the welding voltage is too high, large drops will form on the end of the wire, causing spatter. The correct setting of voltage and Wirespeed can be seen in the shape of the weld deposit and heard by a smooth regular arc sound. Refer to the Weld Guide located on the inside of the wirefeed compartment door for setup information.

### Electrode Wire Size Selection

The choice of Electrode wire size and shielding gas used depends on the following

- Thickness of the metal to be welded
- Type of joint
- Capacity of the wire feed unit and Power Source
- The amount of penetration required
- The deposition rate required
- The bead profile desired
- The position of welding
- Cost of the wire

## 5.15 Cigweld MIG Wire Selection Chart

Transmig 185 ULTRA

## WELDING WIRE SELECTION CHART

DESCRIPTION	DIAMETER	PACK	PART NUMBER	APPLICATION
AUTOCRAFT LW1-6	0.6mm	Minispool 0.8kg	721104	General purpose welding wire suitable for the all positional Gas Metal Arc Welding (GMAW) of mild and low alloy steels, used in general fabrication and for welding of light to medium gauge sheet and tubular steel sections. Note that a suitable shielding gas is required.
	0.6mm	Handispool 5kg	721108	
	0.8mm	Minispool 0.8kg	721105	
	0.8mm	Handispool 5kg	721109	
	0.9mm	Handispool 5kg	720161	
SHIELD-COR 15	0.8mm	Minispool 0.45kg	721956	Shield-Cor 15 is an all positional self-shielded flux cored wire recommended for single pass welding applications only. It is excellent for single-pass lap, fillet and butt welding of thin gauged galvanised and mild steels.
	0.8mm	Handispool 4.5kg	721923	
	0.9mm	Minispool 0.45kg	721976	
	0.9mm	Handispool 4.5kg	721924	
AUTOCRAFT 316LSI SOLID STAINLESS STEEL MIG WIRE	0.8mm	Minispool 1kg	721285	General purpose all positional stainless steel wire providing excellent results when used with correct shielding gas. Suitable for the general welding of a wide range of stainless steels (300 & 400 series).
	0.9mm	Handispool 5kg	720283	
AUTOCRAFT AL5356 SOLID ALUMINIUM MIG WIRE	0.9mm	Minispool 0.5kg	721223	Excellent general purpose Aluminium MIG wire suitable for the welding of a wide range of wrought and cast Aluminium alloys containing Magnesium. Note that a suitable shielding gas is required.
	1.0mm	Minispool 0.5kg	721224	
	1.0mm	Handispool 2kg	723224	
AUTOCRAFT SILICON BRONZE MIG WIRE	0.8mm	Handispool 5kg	720159	Used for lower strength welding of steels in automotive applications. It can also be used for welding copper-silicon alloys in hot water systems, heat exchangers and marine components.

NOTE: MINISPOOL = 100MM DIAMETER, HANDISPOOL = 200MM DIAMETER

Table 5-1: Cigweld MIG Wire Selection Chart

## 5.16 MIG (GMAW/FCAW) Welding Troubleshooting

### Solving Problems Beyond the Welding Terminals

The general approach to fix Gas Metal Arc Welding (GMAW) problems is to start at the wire spool then work through to the MIG torch. There are two main areas where problems occur with GMAW, Porosity and Inconsistent wire feed

### Solving Problems Beyond the Welding Terminals - Porosity

When there is a gas problem the result is usually porosity within the weld metal. Porosity always stems from some contaminant within the molten weld pool which is in the process of escaping during solidification of the molten metal. Contaminants range from no gas around the welding arc to dirt on the work piece surface. Porosity can be reduced by checking the following points.

FAULT	CAUSE
1 Shielding gas cylinder contents and flow meter.	Ensure that the shielding gas cylinder is not empty and the flow meter is correctly adjusted to 15 litres per minute.
2 Gas leaks.	Check for gas leaks between the regulator/cylinder connection and in the gas hose to the Power Source.
3 Internal gas hose in the Power Source.	Ensure the hose from the solenoid valve to the torch adaptor has not fractured and that it is connected to the torch adaptor.
4 Welding in a windy environment.	Shield the weld area from the wind or increase the gas flow.
5 Welding dirty, oily, painted, oxidised or greasy plate.	Clean contaminates off the work piece.
6 Distance between the MIG torch nozzle and the work piece.	Keep the distance between the MIG torch nozzle and the work piece to a minimum. Refer to Section 5.14.
7 Maintain the MIG torch in good working order.	A Ensure that the gas holes are not blocked and gas is exiting out of the torch nozzle. B Do not restrict gas flow by allowing spatter to build up inside the torch nozzle. C Check that the MIG torch O-rings are not damaged.

Table 5-2: Solving Problems beyond the Welding Terminals-Porosity



#### WARNING

Disengage the feed roll when testing for gas flow by ear.

**Solving Problems Beyond the Welding Terminals - Inconsistent Wire Feed**

Wire feeding problems can be reduced by checking the following points.

FAULT	CAUSE
1 Feed roller driven by motor in the cabinet slipped.	Wire spool brake is too tight.
2 Wire spool unwinded and tangled.	Wire spool brake is too loose.
3 Worn or incorrect feed roller size	A Use a feed roller matched to the size you are welding. B Replace feed roller if worn.
4 Wire rubbed against the mis-aligned guides and reduced wire feedability.	Mis-alignment of inlet/outlet guides
5 Liner blocked with swarf	A Increased amounts of swarf are produced by the wire passing through the feed roller when excessive pressure is applied to the pressure roller adjuster. B Swarf can also be produced by the wire passing through an incorrect feed roller groove shape or size. C Swarf is fed into the conduit liner where it accumulates thus reducing wire feedability.
6 Incorrect or worn contact tip	A The contact tip transfers the weld current to the electrode wire. If the hole in the contact tip is too large then arcing may occur inside the contact tip resulting in the wire jamming in the contact tip B When using soft wire such as aluminium it may become jammed in the contact tip due to expansion of the wire when heated. A contact tip designed for soft wires should be used.
7 Poor work lead contact to work piece	If the work lead has a poor electrical contact to the work piece then the connection point will heat up and result in a reduction of power at the arc.
8 Bent liner	This will cause friction between the wire and the liner thus reducing wire feedability

Table 5-3: Wire Feeding Problems

**Basic GMAW (MIG) Welding Troubleshooting**

FAULT	CAUSE	REMEDY
1 Undercut	A Welding arc voltage too high. B Incorrect torch angle C Excessive heat input	A Decrease voltage or increase the wire feed speed. B Adjust angle. C Increase the torch travel speed and/or decrease welding current by decreasing the voltage or decreasing the wire feed speed.
2 Lack of penetration	A Welding current too low B Joint preparation too narrow or gap too tight C Shielding gas incorrect	A Increase welding current by increasing wire feed speed and increasing voltage. B Increase joint angle or gap. C Change to a gas which gives higher penetration.

FAULT	CAUSE	REMEDY
3 Lack of fusion	Voltage too low	Increase voltage.
4 Excessive spatter	A Voltage too high	A Decrease voltage or increase the wirespeed control.
	B Voltage too low	B Increase the voltage or decrease wirespeed.
5 Irregular weld shape	A Incorrect voltage and current settings. Convex, voltage too low. Concave, voltage too high.	A Adjust voltage and current by adjusting the voltage control and the wirespeed control.
	B Wire is wandering.	B Replace contact tip.
	C Incorrect shielding gas	C Check shielding gas.
	D Insufficient or excessive heat input	D Adjust the wirespeed control or the voltage control.
6 Weld cracking	A Weld beads too small	A Decrease travel speed
	B Weld penetration narrow and deep	B Reduce current and voltage and increase Mig torch travel speed or select a lower penetration shielding gas.
	C Excessive weld stresses	C Increase weld metal strength or revise design
	D Excessive voltage	D Decrease voltage.
	E Cooling rate too fast	E Slow the cooling rate by preheating part to be welded or cool slowly.
7 Cold weld puddle	A Loose welding cable connection.	A Check all welding cable connections.
	B Low primary voltage	B Contact supply authority.
	C Fault in power source	C Have an Accredited CIGWELD Service Provider to test then replace the faulty component.
8 Arc does not have a crisp sound that short arc exhibits when the wirefeed speed and voltage are adjusted correctly.	The MIG torch has been connected to the wrong voltage polarity on the front panel.	Connect the MIG torch to the positive (+) welding terminal for solid wires and gas shielded flux cored wires. Refer to the electrode wire manufacturer for the correct polarity.

Table 5-4: GMAW (MIG) Welding Problems

## SECTION 6: TIG (GTAW) WELDING

### 6.01 Shielding Gas Regulator/Flowmeter Operating Instructions

**WARNING**

This equipment is designed for use with welding grade (Inert) shielding gases only.

**Shielding Gas Regulator/Flowmeter Safety**

This regulator/flowmeter is designed to reduce and control high pressure gas from a cylinder or pipeline to the working pressure required for the equipment using it.

If the equipment is improperly used, hazardous conditions are created that may cause accidents. It is the users responsibility to prevent such conditions. Before handling or using the equipment, understand and comply at all times with the safe practices prescribed in this instruction.

SPECIFIC PROCEDURES for the use of regulators/flowmeters are listed below.

1. NEVER subject the regulator/flowmeter to inlet pressure greater than its rated inlet pressure.
2. NEVER pressurize a regulator/flowmeter that has loose or damaged parts or is in a questionable condition. NEVER loosen a connection or attempt to remove any part of a regulator/flowmeter until the gas pressure has been relieved. Under pressure, gas can dangerously propel a loose part.
3. DO NOT remove the regulator/flowmeter from a cylinder without first closing the cylinder valve and releasing gas in the regulator/flowmeter high and low pressure chambers.
4. DO NOT use the regulator/flowmeter as a control valve. When downstream equipment is not in use for extended periods of time, shut off the gas at the cylinder valve and release the gas from the equipment.
5. OPEN the cylinder valve SLOWLY. Close after use.

## User Responsibilities

This equipment will perform safely and reliably only when installed, operated and maintained, and repaired in accordance with the instructions provided. Equipment must be checked periodically and repaired, replaced, or reset as necessary for continued safe and reliable performance. Defective equipment should not be used. Parts that are broken, missing, obviously worn, distorted, or contaminated should be replaced immediately.

The user of this equipment will generally have the sole responsibility for any malfunction, which results from improper use, faulty maintenance, or by repair by anyone other than an accredited repairer.



### CAUTION

Match regulator/flowmeter to cylinder. NEVER CONNECT a regulator/flowmeter designed for a particular gas or gases to a cylinder containing any other gas.

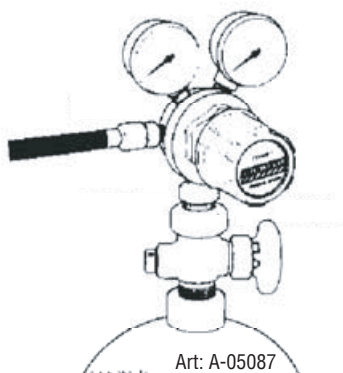


Figure 6-1: Fit Regulator/flowmeter to Cylinder

## Installation

1. Remove cylinder valve plastic dust seal. Clean the cylinder valve outlet of impurities that may clog orifices and damage seats before connecting the regulator/flowmeter.

Crack the valve (open then close) momentarily, pointing the outlet away from people and sources of ignition. Wipe with a clean lint free cloth.

2. Match regulator/flowmeter to cylinder. Before connecting, check that the regulator/flowmeter label and cylinder marking agree and that the regulator/flowmeter inlet and cylinder outlet match. NEVER CONNECT a regulator/flowmeter designed for a particular gas or gases to a cylinder containing any other gas.
3. Connect the regulator/flowmeter inlet connection to cylinder or pipeline and tighten it firmly but not excessively, with a suitable spanner.
4. Connect and tighten the outlet hose firmly and attach down-stream equipment.
5. To protect sensitive down-stream equipment a separate safety device may be necessary if the regulator/flowmeter is not fitted with a pressure relief device.



## Operation

With the regulator/flowmeter connected to cylinder or pipeline, and the adjustment screw/knob fully disengaged, pressurize as follows:

1. Stand to one side of regulator/flowmeter and slowly open the cylinder valve. If opened quickly, a sudden pressure surge may damage internal regulator/flowmeter parts.
2. With valves on downstream equipment closed, adjust regulator/flowmeter to approximate working pressure. It is recommended that testing for leaks at the regulator/flowmeter connection points be carried out using a suitable leak detection solution or soapy water.
3. Purge air or other unwanted welding grade shielding gas from equipment connected to the regulator/flowmeter by individually opening then closing the equipment control valves. Complete purging may take up to ten seconds or more, depending upon the length and size of the hose being purged.

## Adjusting Flow Rate

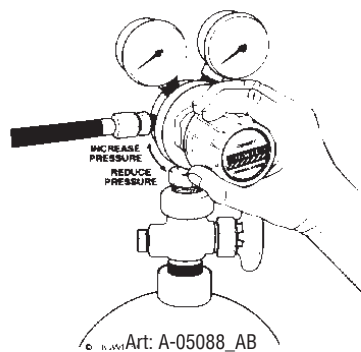


Figure 6-2: Adjust Flow Rate

With the regulator/flowmeter ready for operation, adjust working flow rate as follows:

1. Slowly turn adjusting screw/knob in (clockwise) direction until the outlet gauge indicates the required flow rate.



### NOTE!

It may be necessary to re-check the shielding gas regulator/flowmeter flow rate following the first weld sequence due to back pressure present within shielding gas hose assembly.

2. To reduce flow rate, allow the welding grade shielding gas to discharge from regulator/flowmeter by opening the downstream valve. Bleed welding grade shielding gas into a well ventilated area and away from any ignition source. Turn adjusting screw counterclockwise, until the required flow rate is indicated on the gauge. Close downstream valve.

## Shutdown

Close cylinder valve whenever the regulator/flowmeter is not in use. To shut down for extended periods (more than 30 minutes).

1. Close cylinder or upstream valve tightly.
2. Open downstream equipment valves to drain the lines. Bleed gas into a well ventilated area and away from any ignition source.
3. After gas is drained completely, disengage adjusting screw and close downstream equipment valves.
4. Before transporting cylinders that are not secured on a cart designed for such purposes, remove regulators/flowmeters.

## 6.02 Setup for TIG (GTAW) Auto Set Welding

- A. Switch the Power Source On/Off switch located on the rear of the Power Source to the OFF position.
- B. Connect the TIG Torch to the negative welding terminal (-). Welding current flows from the power source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.
- C. Connect the TIG torch trigger switch via the 8 pin socket located on the front of the power source as shown below. The TIG torch will require a trigger switch to operate in Lift TIG Mode. Note that the TIG Torch Remote Current Control feature is not available for 185 Ultra. 8 pin socket connection for for TIG Torch Trigger Switch only.
- D. Connect the work lead to the positive welding terminal (+). Welding current flows from the Power Source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.



### CAUTION

Loose welding terminal connections can cause overheating and result in the male plug being fused in the terminal. Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.



### WARNING

Before connecting the work clamp to the work make sure the mains power supply is switched off.

- E. Fit the welding grade shielding gas regulator/flowmeter to the shielding gas cylinder (refer to Section 6.01) then connect the shielding gas hose from the TIG torch to the regulator/flowmeter outlet. Note that the TIG torch shielding gas hose is connected directly to the regulator/flowmeter. Before turning on shielding gas check that all fittings are tight and the gas valve on the TIG torch is turned off. The power source is not fitted with a shielding gas solenoid to control the gas flow in TIG mode therefore the TIG torch will require a gas valve. (Refer to Section 2.11 for optional TIG Torches). Before commencing to TIG weld open TIG torch gas valve to allow sufficient shielding gas flow when welding. Refer to Section 6.04 for recommended Shielding Gas flow rates and other TIG Welding information.



### WARNING

Secure the welding grade shielding gas cylinder in an upright position by chaining it to a suitable stationary support to prevent falling or tipping.

- F. Switch the Power Source On/Off switch located on the rear of the Power Source to the On position and ensure the LCD Screen on the Front Panel is illuminated.
- G. Select TIG mode and AUTO SET.



Figure 6-3: Home Screen



Figure 6-4: TIG Mode Menu

- H. The 'TIG Setup Guide screen' will be displayed for 10 seconds. To move on to the next screen immediately - press the Control Knob.



Figure 6-5: TIG Setup Guide Screen

- I. Select welding material type and tungsten electrode diameter.



Figure 6-6: Welding Material Menu

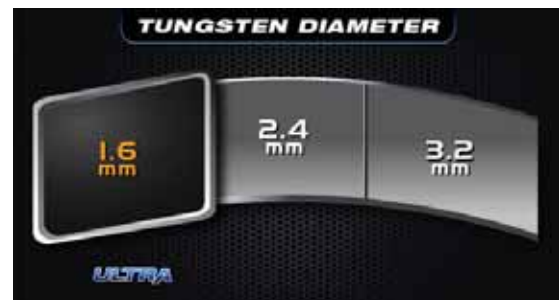


Figure 6-7: Tungsten Electrode Menu

- J. Select material/plate thickness.



Figure 6-8: Plate Thickness Screen

- K. Welding summary screen displays preset welding parameter. Advanced setting of trigger mode 2T / 4T, upslope time and downslope time can be adjusted by selecting ADVANCED SETTINGS. Refer to Section 4.03.4 for detailed explanation of advanced features.

**NOTE!**

Welding current values in Auto TIG are able to be adjusted if desired by using the Amps Control Knob.



Figure 6-9: TIG Welding Summary Screen



Figure 6-10: TIG Advanced Settings Menu

- L. Welding current and value will be displayed during welding and held for 10 seconds after welding is finished.



Figure 6-11: Welding Screen

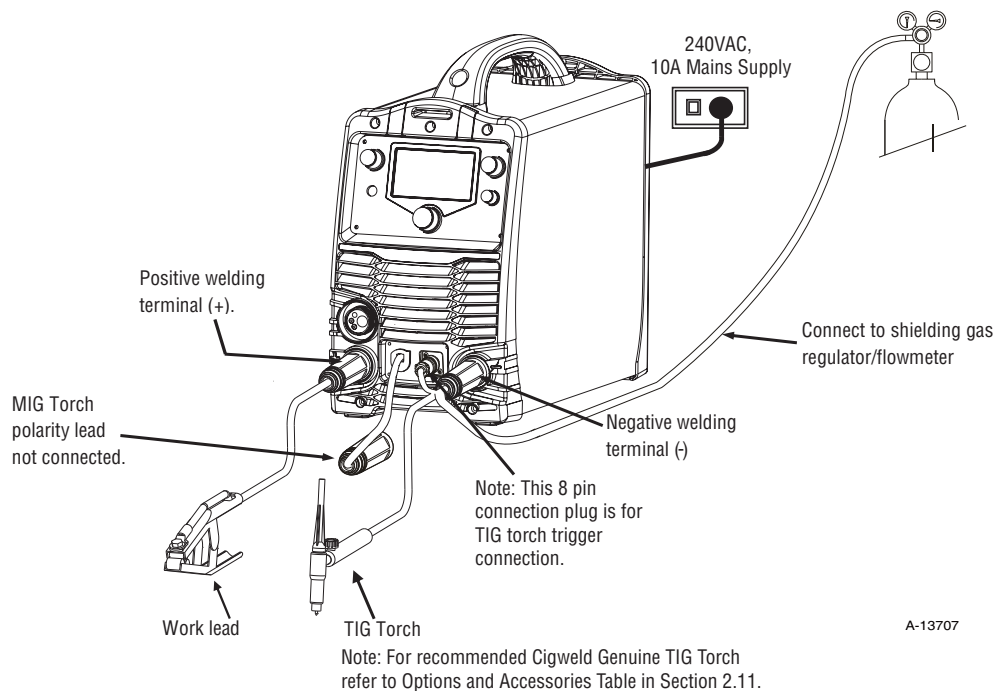


Figure 6-12: Setup for Lift TIG (GTAW) Welding

### 6.03 Setup for TIG (GTAW) Manual Set Welding

- Switch the Power Source On/Off switch located on the rear of the Power Source to the OFF position.
- Connect the TIG Torch to the negative welding terminal (-). Welding current flows from the power source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.
- Connect the work lead to the positive welding terminal (+). Welding current flows from the Power Source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.



#### CAUTION

Loose welding terminal connections can cause overheating and result in the male plug being fused in the terminal. Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.



#### WARNING

Before connecting the work clamp to the work make sure the mains power supply is switched off.

- D. Connect the TIG torch trigger switch via the 8 pin socket located on the front of the power source as shown below. The TIG torch will require a trigger switch to operate in Lift TIG Mode. Note that Remote Current Control feature is not available for 185 Ultra. 8 pin socket connection for Trigger Switch only.
- E. Fit the welding grade shielding gas regulator/flowmeter to the shielding gas cylinder (refer to Section 6.01) then connect the shielding gas hose from the TIG torch to the regulator/flowmeter outlet. Note that the TIG torch shielding gas hose is connected directly to the regulator/flowmeter. Before turning on shielding gas check that all fittings are tight and the gas valve on the TIG torch is turned off. The power source is not fitted with a shielding gas solenoid to control the gas flow in TIG mode therefore the TIG torch will require a gas valve (refer to Section 2.11 for optional TIG torches). Before commencing to TIG weld open TIG torch gas valve to allow sufficient shielding gas flow when welding. Refer to Section 6.04 for recommended Shielding Gas flow rates and other TIG Welding information.

				<p><b>WARNING</b> Secure the welding grade shielding gas cylinder in an upright position by chaining it to a suitable stationary support to prevent falling or tipping.</p>
--	--	--	--	---

- F. Switch the Power Source On/Off switch located on the rear of the Power Source to the On position and ensure the LCD Screen on the Front Panel is illuminated.
- G. Select TIG mode and MANUAL SET mode.



Figure 6-13: Home Screen



Figure 6-14: TIG Mode Menu

- H. The 'TIG Setup Guide' screen will be displayed for 10 seconds. To move on to the next screen immediately - press the Control Knob.



Figure 6-15: TIG Setup Guide Screen



- I. Welding summary screen displays preset welding current and voltage. Advanced settings of trigger mode 2T / 4T, upslope time and downslope time can be adjusted by selecting ADVANCED SETTINGS button. Refer to Section 4.03.4 for detailed explanation of advanced features.



Figure 6-16: TIG Mode Welding Summary Screen    Figure 6-17: TIG Mode Advanced Settings Menu

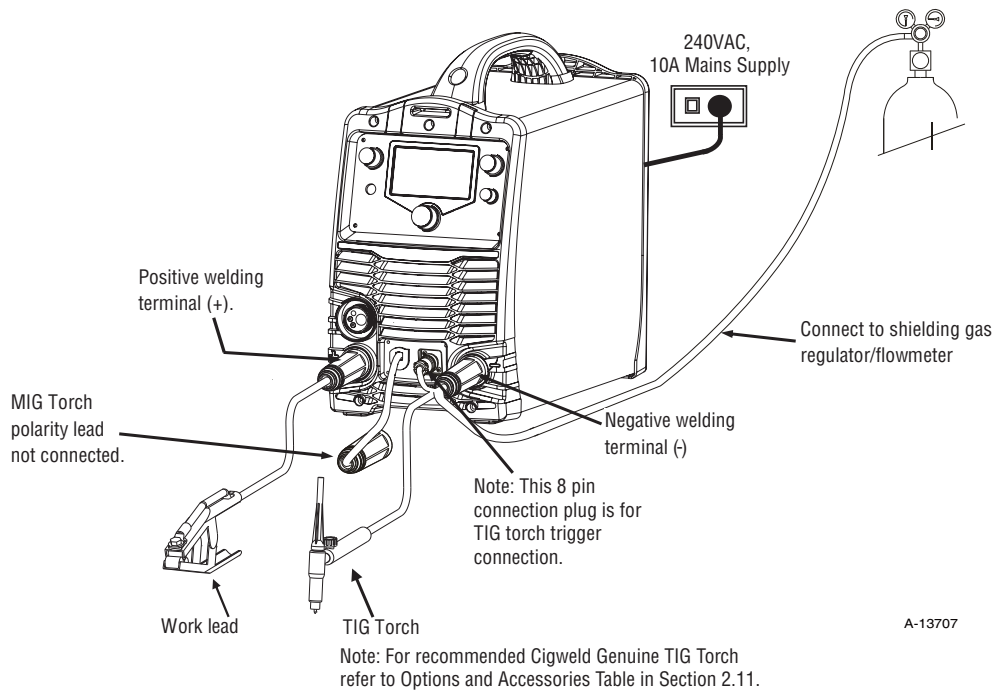


Figure 6-18: Setup for Lift TIG (GTAW) Welding

## 6.04 TIG (GTAW) Basic Welding Technique

Gas Tungsten Arc Welding (GTAW) or TIG (Tungsten Inert Gas) as it is commonly referred to, is a welding process in which fusion is produced by an electric arc that is established between a single tungsten (non-consumable) electrode and the work piece. Shielding is obtained from a welding grade shielding gas or welding grade shielding gas mixture which is generally Argon based. A filler metal may also be added manually in some circumstances depending on the welding application.

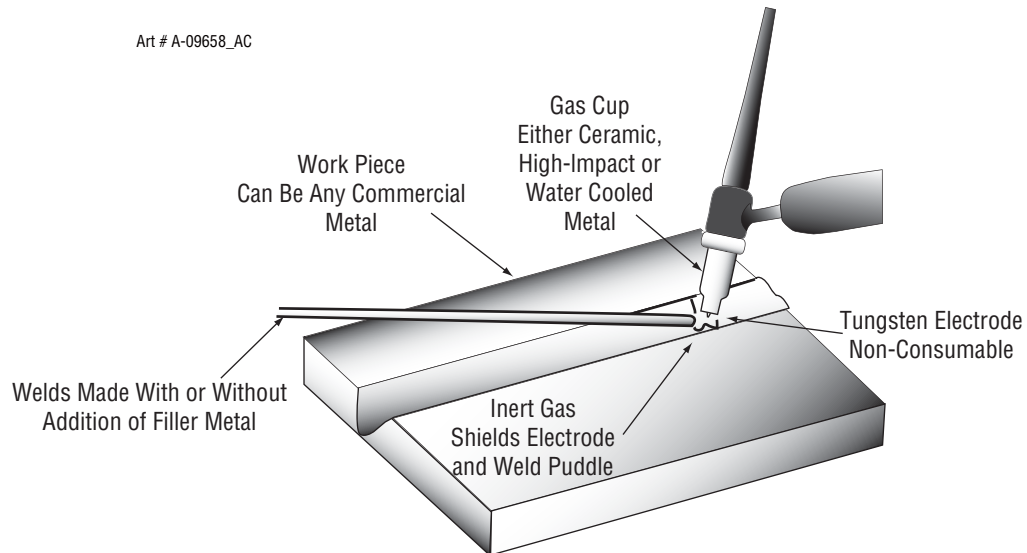


Figure 6-19: TIG Welding Application Shot

### Tungsten Electrode Current Ranges

Electrode Diameter	DC Current (Amps)
0.040" (1.0mm)	30-60
1/16" (1.6mm)	60-115
3/32" (2.4mm)	100-165
1/8" (3.2mm)	135-200
5/32" (4.0mm)	190-280
3/16" (4.8mm)	250-340

Table 6-1: Current Ranges for Various Tungsten Electrode Sizes

### Guide for Selecting Filler Wire Diameter

Filler Wire Diameter	DC Current Range (Amps)
1/16" (1.6mm)	20-90
3/32" (2.4mm)	65-115
1/8" (3.2mm)	100-165
3/16" (4.8mm)	200-350

Table 6-2: Filler Wire Selection Guide



### Tungsten Electrode Types

Electrode Type (Ground Finish)	Welding Application	Features	Colour Code
Ceriated 2%	DC welding of mild steel, stainless steel, copper, aluminium, magnesium and their alloys	Longer life, More stable arc, Easier starting, Wider current range, Narrower more concentrated arc.	Grey

Table 6-3



#### NOTE!

The Transmig 185 Ultra Inverter is not suited for AC Tig welding.

### TIG Welding Filler Rods

Comweld Rod	Aust Std	AWS Std	Part No. 1.6mm	Part No. 2.4mm	Part No. 3.2mm	Type/Application
LW1 LW1-6 Supersteel	R4 R6 R2	ER70S-4 ER70S-6 ER70S-2	321411 321417 321370	— — —	— — —	For mild-medium strength steels. Pipes, tubing, roll cages, etc.
CrMo1 CrMo2	RB2 RB3	ER80S-B2 ER90S-B3	— —	321379 321383	— —	For welding of high strength Cr-Mo steels used at elevated temperatures.
308L 309L 316L	R308L R309L R316L	ER308L ER309L ER316L	321406 321403 321400	321407 321404 321401	— — —	For stainless steels. Stainless pipes, tubing, architectural uses, etc.

Table 6-4

Base Metal Thickness	DC Current for Mild Steel	DC Current for Stainless Steel	Tungsten Electrode Diameter	Filler Rod Diameter (if required)	Argon Gas Flow Rate Litres/min	Joint Type
0.040" 1.0mm	35-45 40-50	20-30 25-35	0.040" 1.0mm	1/16" 1.6mm	5-7	Butt/Corner Lap/Fillet
0.045" 1.2mm	45-55 50-60	30-45 35-50	0.040" 1.0mm	1/16" 1.6mm	5-7	Butt/Corner Lap/Fillet
1/16" 1.6mm	60-70 70-90	40-60 50-70	1/16" 1.6mm	1/16" 1.6mm	7	Butt/Corner Lap/Fillet
1/8" 3.2mm	80-100 90-115	65-85 90-110	1/16" 1.6mm	3/32" 2.4mm	7	Butt/Corner Lap/Fillet
3/16" 4.8mm	115-135 140-165	100-125 125-150	3/32" 2.4mm	1/8" 3.2mm	10	Butt/Corner Lap/Fillet
1/4" 6.4mm	160-175 170-200	135-160 160-180	1/8" 3.2mm	5/32" 4.0mm	10	Butt/Corner Lap/Fillet

Table 6-5

TIG Welding is generally regarded as a specialised process that requires operator competency. While many of the principles outlined in the previous Arc Welding section are applicable a comprehensive outline of the TIG Welding process is outside the scope of this Operating Manual. For further information please refer to [www.cigweld.com.au](http://www.cigweld.com.au) or contact Cigweld.

For Tig Torch parts and Accessories refer to Options and Accessories on Page 2-7.

## 6.05 TIG (GTAW) Welding Problems

FAULT	CAUSE	REMEDY
1 Excessive beard build up or poor penetration or poor fusion at edges of weld.	Welding current is too low	Increase weld current and/or faulty joint preparation.
2 Weld bead too wide and flat or undercut at edges of weld or excessive burn through.	Welding current is too high	Decrease weld current.
3 Weld bead too small or insufficient penetration or ripples in bead are widely spaced apart.	Travel speed too fast	Reduce travel speed.
4 Weld bead too wide or excessive bead build up or excessive penetration in butt joint.	Travel speed too slow	Increase travel speed.
5 Uneven leg length in fillet joint	Wrong placement of filler rod	Re-position filler rod.
6 Electrode melts or oxidises when an arc is struck.	A TIG Torch lead connected to positive welding terminal. B No shielding gas flowing to welding region. C Torch is clogged with dust or dirt. D Shielding Gas hose is cut. E Shielding gas regulator turned off. F TIG Torch Shield Gas valve is turned off. G The electrode is too small for the welding current. H Power source is set for MIG welding.	A Connect TIG Torch lead to negative welding terminal. B Check the shielding gas lines for kinks or breaks and shielding gas cylinder contents. C Clean torch. D Replace shielding gas hose. E Turn On Shielding Gas and adjust Shielding Gas flow rate for the welding job. Refer to Table 6-5 on Page 6-10. F Turn ON the TIG Torch Shielding Gas valve. G Increase electrode diameter or reduce the welding current. H Set Power Source to Lift TIG mode.

FAULT	CAUSE	REMEDY
7 Dirty weld pool	<p>A Electrode contaminated by contact with work piece or filler rod material.</p> <p>B Work piece surface has foreign material on it.</p> <p>C Shielding Gas contaminated with air.</p>	<p>A Clean the electrode by grinding off the contaminates.</p> <p>B Clean surface.</p> <p>C Check shielding gas lines for cuts and loose fitting or change shielding gas cylinder.</p>
8 Poor weld finish	Inadequate shielding gas.	Increase shielding gas flow or check shielding gas line for shielding gas flow problems.
9 Arc start is not smooth.	<p>A Tungsten electrode is too large for the welding current.</p> <p>B The wrong electrode is being used for the welding job.</p> <p>C Gas flow rate is too high.</p> <p>D Incorrect shielding gas is being used.</p> <p>E Poor work clamp connection to work piece.</p>	<p>A Select the right size electrode. Refer to Table 6-1 Cigweld Electrode Selection Chart.</p> <p>B Select the right electrode type. Refer to Table 6-3 Cigweld Electrode Selection Chart.</p> <p>C Select the right rate for the welding job. Refer to Table 6-5.</p> <p>D Select the right shielding gas.</p> <p>E Improve connection to work piece.</p>
10 Arc flutters during TIG welding.	Tungsten electrode is too large for the welding current.	Select the right size electrode. Refer to Table 6-1 Cigweld Electrode Selection Chart.

Table 6-6: GTAW (TIG) Welding Problems

## SECTION 7: STICK (MMAW) WELDING

### 7.01 Setup for STICK Auto Set (MMAW) Welding

- A. Switch the Power Source On/Off switch located on the rear of the Power Source to the OFF position.
- B. Connect the Electrode Holder lead to the positive welding terminal (+). If in doubt, consult the electrode manufacturer. Welding current flows from the Power Source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.



#### CAUTION

Loose welding terminal connections can cause overheating and result in the male plug being fused in the terminal. Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.

- C. Connect the work lead to the negative welding terminal (-). If in doubt, consult the electrode manufacturer. Welding current flows from the power source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.



#### WARNING

Before connecting the work clamp to the work make sure the mains power supply is switched off.



#### NOTE!

Consult the electrode manufacturer's information for the correct polarity.

- D. Switch the Power Source On/Off switch located on the rear of the Power Source to the On position and ensure the LCD screen is illuminated.
- E. Select Stick mode and then Auto Set mode.



Figure 7-1: Home Screen



Figure 7-2: STICK Mode Menu

- F. Select welding material type.



Figure 7-3: Welding Material Menu

G. Select electrode type and diameter.



Figure 7-4: STICK Electrode Menu



Figure 7-5: STICK Electrode Diameter Menu

H. Preset welding conditions will be displayed on welding summary screen. If necessary adjust arc force in Advanced Settings. Refer to Section 4.03.4 for detailed explanation of advanced features.



Figure 7-6: STICK Welding Summary Screen



Figure 7-7: STICK Advanced Settings Screen

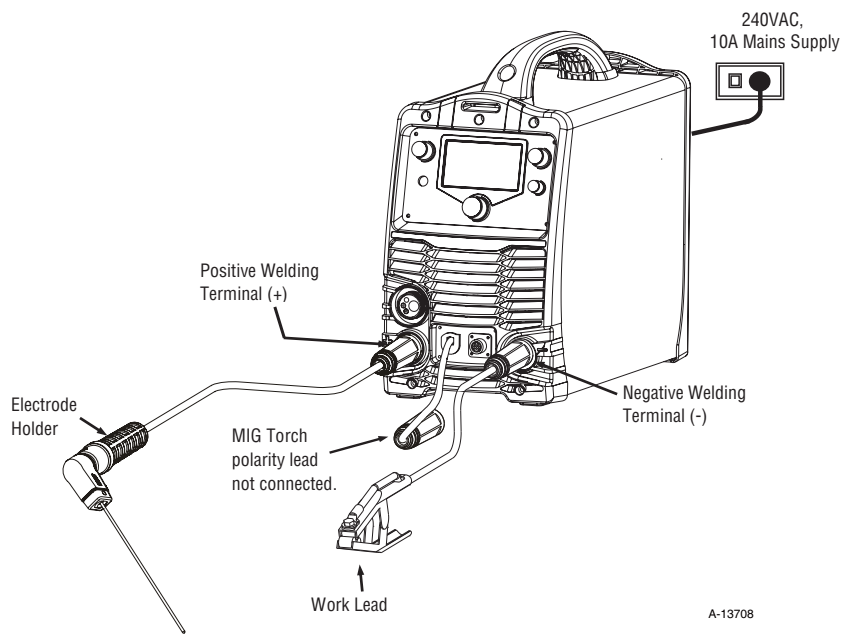


Figure 7-8: Setup for Stick (Manual Arc) Welding

## 7.02 Setup for STICK (MMAW) Manual Set Welding

- A. Switch the Power Source On/Off switch located on the rear of the Power Source to the OFF position.
- B. Connect the Electrode Holder lead to the positive welding terminal (+). If in doubt, consult the electrode manufacturer. Welding current flows from the Power Source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.
- C. Connect the work lead to the negative welding terminal (-). If in doubt, consult the electrode manufacturer. Welding current flows from the power source via Dinse terminals. It is essential, however, that the male plug is inserted and turned securely to achieve a sound electrical connection.



### WARNING

Before connecting the work clamp to the work make sure the mains power supply is switched off.



### CAUTION

Loose welding terminal connections can cause overheating and result in the male plug being fused in the terminal. Remove any packaging material prior to use. Do not block the air vents at the front or rear of the Welding Power Source.



### NOTE!

Consult the electrode manufacturer's information for the correct polarity.

- D. Switch the Power Source On/Off switch located on the rear of the Power Source to the On position and ensure the LCD screen is illuminated.
- E. Select Stick mode and then Manual Set with the process selection control.



Figure 7-9: Home Screen



Figure 7-10: STICK Mode Menu

- F. Welding summary screen displays current and voltage preset value. If necessary adjust arc force in Advanced Settings. Refer to Section 4.03.4 for detailed explanation of advanced features.



Figure 7-11: STICK Manual Mode Welding Summary Screen

See overpage for STICK welding setup diagram.



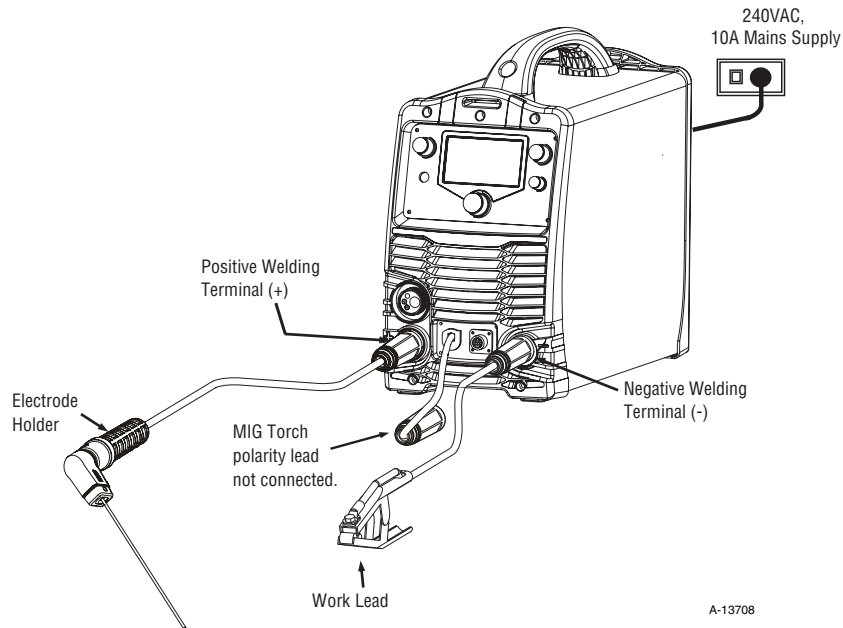


Figure 7-12: Setup for Stick (Manual Arc) Welding

## 7.03 Stick (MMAW) Basic Welding Technique

### Size of Electrode

The electrode size is determined by the thickness of metals being joined and can also be governed by the type of welding machine available. Small welding machines will only provide sufficient current (amperage) to run the smaller size electrodes.

For thin sections, it is necessary to use smaller electrodes otherwise the arc may burn holes through the job. A little practice will soon establish the most suitable electrode for a given application.

### Storage of Electrodes

Always store electrodes in a dry place and in their original containers.

### Electrode Polarity

Electrodes are generally connected to the ELECTRODE HOLDER with the Electrode Holder connected positive polarity. The WORK LEAD is connected negative polarity and is connected to the work piece. If in doubt consult the electrode data sheet or your nearest Accredited CIGWELD Distributor.

### Effects of Arc Welding Various Materials

#### A. High tensile and alloy steels

The two most prominent effects of welding these steels are the formation of a hardened zone in the weld area, and, if suitable precautions are not taken, the occurrence in this zone of under-bead cracks may result. Hardened zone and under-bead cracks in the weld area may be reduced by using the correct electrodes, preheating, using higher current settings, using larger electrodes sizes, short runs for larger electrode deposits or tempering in a furnace.

Hydrogen controlled Electrodes must be used for this application. Use Ferrocrafter 61 or 16TXP for normal strength (500 MPa) steels, and Alloycraft range for higher strength steels.

#### B. Austenitic manganese steels

The effect on manganese steel of slow cooling from high temperatures is to embrittle it. For this reason it is absolutely essential to keep manganese steel cool during welding by quenching after each weld or skip welding to distribute the heat. Suitable Electrode types are Cobalarc Austex or Cobalarc Mangcraft.

### C. Cast Iron

Most types of cast iron, except white iron, are weldable. White iron, because of its extreme brittleness, generally cracks when attempts are made to weld it. Trouble may also be experienced when welding white-heart malleable, due to the porosity caused by gas held in this type of iron. Suitable Electrode types are Castcraft 55 or Castcraft 100.

### D. Copper and alloys

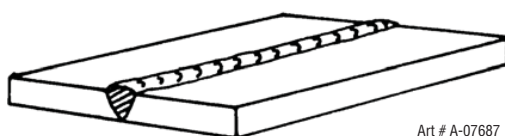
The most important factor is the high rate of heat conductivity of copper, making preheating of heavy sections necessary to give proper fusion of weld and base metal. Suitable Electrode types are Bronzecraft AC-DC electrodes.

## Arc Welding Practice

The techniques used for arc welding are almost identical regardless of what types of metals are being joined. Naturally enough, different types of electrodes would be used for different metals as described in the preceding section.

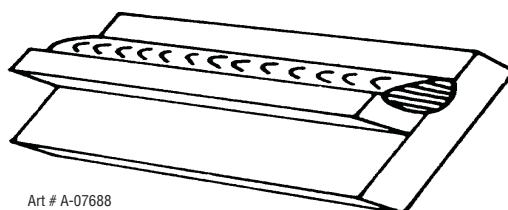
### Welding Position

The electrodes dealt with in this publication can be used in most positions, i.e. they are suitable for welding in flat, horizontal, vertical and overhead positions. Numerous applications call for welds to be made in positions intermediate between these. Some of the common types of welds are shown in Figures 7-13 through 7-20.



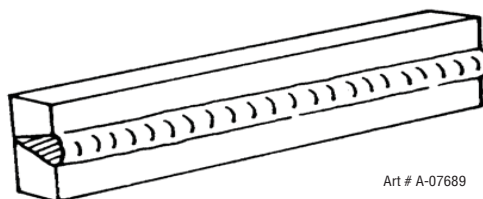
Art # A-07687

Figure 7-13: Flat Position, Down Hand Butt Weld



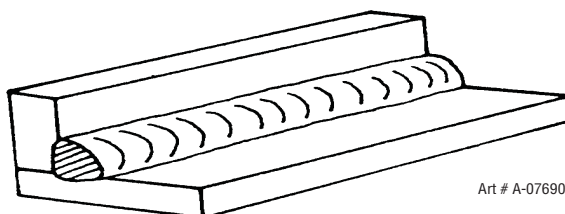
Art # A-07688

Figure 7-14: Flat Position, Gravity Fillet Weld



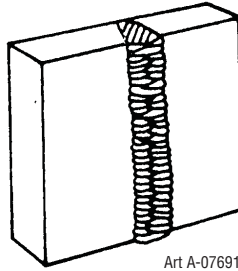
Art # A-07689

Figure 7-15: Horizontal Position, Butt Weld



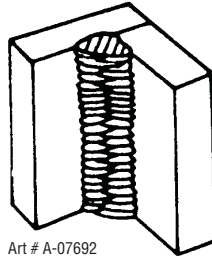
Art # A-07690

Figure 7-16: Horizontal-Vertical (HV) Position



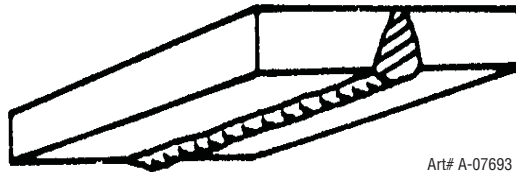
Art A-07691

Figure 7-17: Vertical Position, Butt Weld



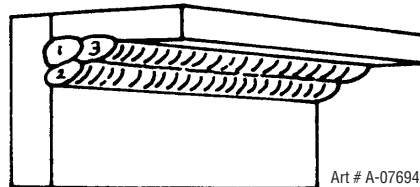
Art # A-07692

Figure 7-18: Vertical Position, Fillet Weld



Art# A-07693

Figure 7-19: Overhead Position, Butt Weld



Art # A-07694

Figure 7-20: Overhead Position, Fillet Weld

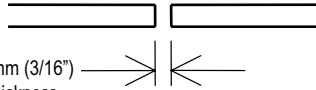
## Joint Preparations

In many cases, it will be possible to weld steel sections without any special preparation. For heavier sections and for repair work on castings, etc., it will be necessary to cut or grind an angle between the pieces being joined to ensure proper penetration of the weld metal and to produce sound joints.

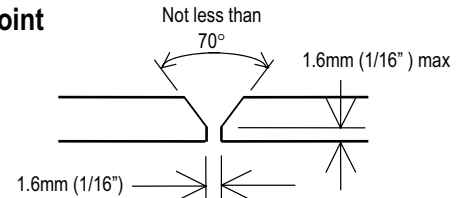
In general, surfaces being welded should be clean and free of rust, scale, dirt, grease, etc. Slag should be removed from oxy-cut surfaces. Typical joint designs are shown in Figure 7-21.

### Open Square Butt Joint

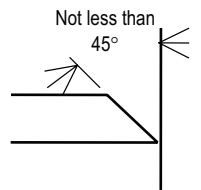
Gap varies from  
1.6mm (1/16") to 4.8mm (3/16")  
depending on plate thickness



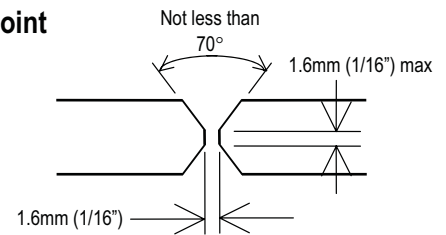
### Single Vee Butt Joint



### Single Vee Butt Joint



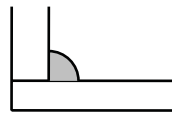
### Double Vee Butt Joint



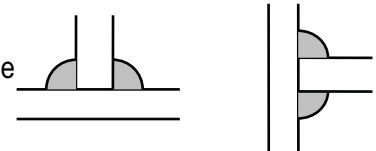
### Lap Joint



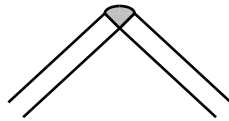
### Fillet Joint



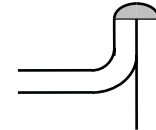
### Tee Joints (Fillet both sides of the joint)



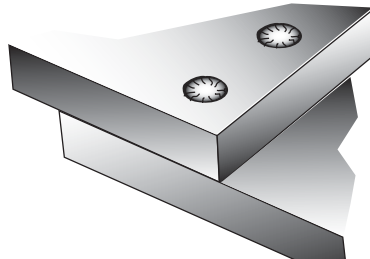
### Corner Weld



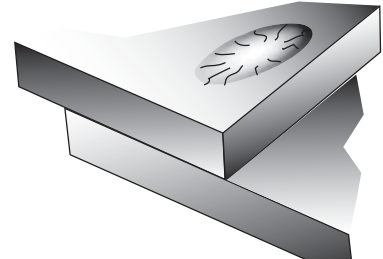
### Edge Joint



### Plug Weld



### Plug Weld



Art # A-07695\_AE

Figure 7-21: Typical Joint Designs for Arc Welding

## Arc Welding Technique - A Word to Beginners

For those who have not yet done any welding, the simplest way to commence is to run beads on a piece of scrap plate. Use mild steel plate about 6.0mm thick and a 3.2mm electrode. Clean any paint, loose scale or grease off the plate and set it firmly on the work bench so that welding can be carried out in the downhand position. Make sure that the work clamp is making good electrical contact with the work, either directly or through the work table. For light gauge material, always clamp the work lead directly to the job, otherwise a poor circuit will probably result.

## The Welder

Place yourself in a comfortable position before beginning to weld. Get a seat of suitable height and do as much work as possible sitting down. Don't hold your body tense. A taut attitude of mind and a tensed body will soon make you feel tired. Relax and you will find that the job becomes much easier. You can add much to your peace of mind by wearing a leather apron and gauntlets. You won't be worrying then about being burnt or sparks setting alight to your clothes.

Place the work so that the direction of welding is across, rather than to or from, your body. The electrode holder lead should be clear of any obstruction so that you can move your arm freely along as the electrode burns down. If the lead is slung over your shoulder, it allows greater freedom of movement and takes a lot of weight off your hand. Be sure the insulation on your cable and electrode holder is not faulty, otherwise you are risking an electric shock.

### Striking the Arc

Practice this on a piece of scrap plate before going on to more exacting work. You may at first experience difficulty due to the tip of the electrode "sticking" to the work piece. This is caused by making too heavy a contact with the work and failing to withdraw the electrode quickly enough. A low amperage will accentuate it. This freezing-on of the tip may be overcome by scratching the electrode along the plate surface in the same way as a match is struck. As soon as the arc is established, maintain a 1.6mm to 3.2mm gap between the burning electrode end and the parent metal. Draw the electrode slowly along as it melts down.

Another difficulty you may meet is the tendency, after the arc is struck, to withdraw the electrode so far that the arc is broken again. A little practice will soon remedy both of these faults.

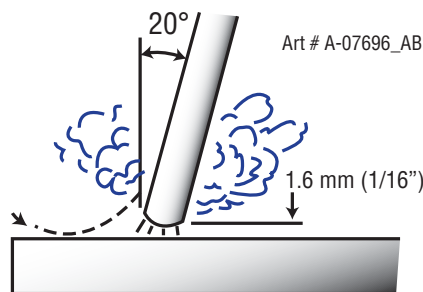


Figure 7-22: Striking an Arc

### Arc Length

The securing of an arc length necessary to produce a neat weld soon becomes almost automatic. You will find that a long arc produces more heat. A very long arc produces a crackling or spluttering noise and the weld metal comes across in large, irregular blobs. The weld bead is flattened and spatter increases. A short arc is essential if a high quality weld is to be obtained although if it is too short there is the danger of it being blanketed by slag and the electrode tip being solidified in. If this should happen, give the electrode a quick twist back over the weld to detach it. Contact or "touch-weld" electrodes such as Ferrocrafter 21 do not stick in this way, and make welding much easier.

### Rate of Travel

After the arc is struck, your next concern is to maintain it, and this requires moving the electrode tip towards the molten pool at the same rate as it is melting away. At the same time, the electrode has to move along the plate to form a bead. The electrode is directed at the weld pool at about 20° from the vertical. The rate of travel has to be adjusted so that a well-formed bead is produced.

If the travel is too fast, the bead will be narrow and strung out and may even be broken up into individual globules. If the travel is too slow, the weld metal piles up and the bead will be too large.

### Making Welded Joints

Having attained some skill in the handling of an electrode, you will be ready to go on to make up welded joints.

### A. Butt Welds

Set up two plates with their edges parallel, as shown in Figure 7-23, allowing 1.6mm to 2.4mm gap between them and tack weld at both ends. This is to prevent contraction stresses from the cooling weld metal pulling the plates out of alignment. Plates thicker than 6.0mm should have their mating edges bevelled to form a 70° to 90° included angle. This allows full penetration of the weld metal to the root. Using a 3.2mm Ferrocrafter 21 electrode at 100 amps, deposit a run of weld metal on the bottom of the joint.

Do not weave the electrode, but maintain a steady rate of travel along the joint sufficient to produce a well-formed bead. At first you may notice a tendency for undercut to form, but keeping the arc length short, the angle of the electrode at about 20° from vertical, and the rate of travel not too fast, will help eliminate this. The electrode needs to be moved along fast enough to prevent the slag pool from getting ahead of the arc. To complete the joint in thin plate, turn the job over, clean the slag out of the back and deposit a similar weld.

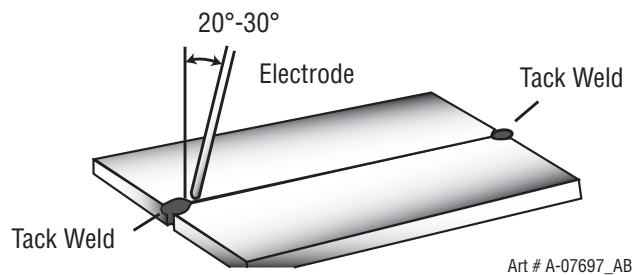


Figure 7-23: Butt Weld

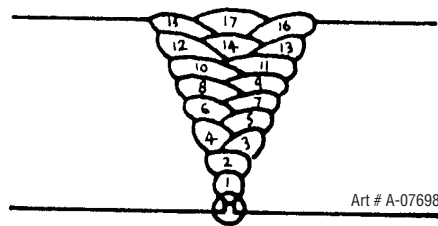


Figure 7-24: Weld Build up Sequence

Heavy plate will require several runs to complete the joint. After completing the first run, chip the slag out and clean the weld with a wire brush. It is important to do this to prevent slag being trapped by the second run. Subsequent runs are then deposited using either a weave technique or single beads laid down in the sequence shown in Figure 7-24. The width of weave should not be more than three times the core wire diameter of the electrode. When the joint is completely filled, the back is either machined, ground or gouged out to remove slag which may be trapped in the root, and to prepare a suitable joint for depositing the backing run. If a backing bar is used, it is not usually necessary to remove this, since it serves a similar purpose to the backing run in securing proper fusion at the root of the weld.

### B. Fillet Welds

These are welds of approximately triangular cross-section made by depositing metal in the corner of two faces meeting at right angles. Refer to Figure 7-25.

A piece of angle iron is a suitable specimen with which to begin, or two lengths of strip steel may be tacked together at right angles. Using a 3.2mm Ferrocrafter 21 electrode at 100 amps, position angle iron with one leg horizontal and the other vertical. This is known as a horizontal-vertical (HV) fillet. Strike the arc and immediately bring the electrode to a position perpendicular to the line of the fillet and about 45° from the vertical. Some electrodes require to be sloped about 20° away from the perpendicular position to prevent slag from running ahead of the weld. Refer to Figure 7-23. Do not attempt to build up much larger than 6.4mm width with a 3.2mm electrode, otherwise the weld metal tends to sag towards the base, and undercut forms on the vertical leg. Multi-runs can be made as shown in Figure 7-26. Weaving in HV fillet welds is undesirable.



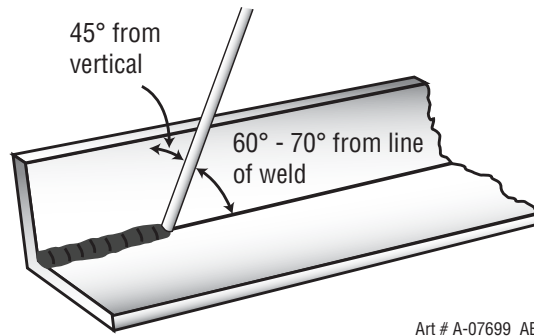


Figure 7-25: Electrode Position for HV Fillet Weld

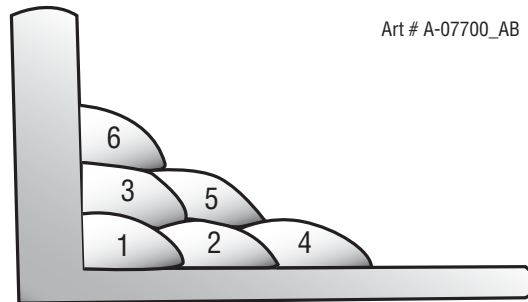


Figure 7-26: Multi-runs in HV Fillet Weld

### C. Vertical Welds

#### 1. Vertical Up

Tack weld a three feet length of angle iron to your work bench in an upright position. Use a 3.2mm Ferrocrafter 21 electrode and set the current at 100 amps. Make yourself comfortable on a seat in front of the job and strike the arc in the corner of the fillet. The electrode needs to be about 10° from the horizontal to enable a good bead to be deposited. Refer Figure 7-27. Use a short arc, and do not attempt to weave on the first run. When the first run has been completed de-slag the weld deposit and begin the second run at the bottom. This time a slight weaving motion is necessary to cover the first run and obtain good fusion at the edges. At the completion of each side motion, pause for a moment to allow weld metal to build up at the edges, otherwise undercut will form and too much metal will accumulate in the centre of the weld. Figure 7-28 illustrates multi-run technique and Figure 7-29 shows the effects of pausing at the edge of weave and of weaving too rapidly.

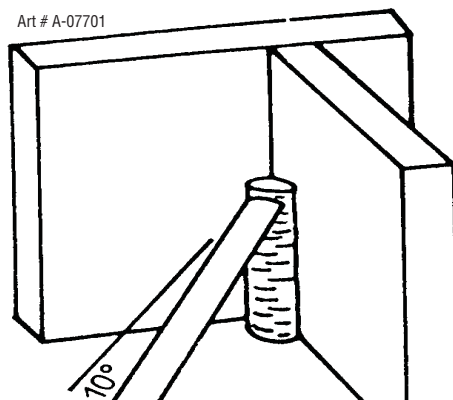


Figure 7-27: Single Run Vertical Fillet Weld

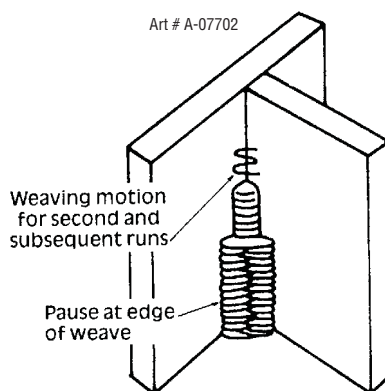


Figure 7-28: Multi Run Vertical Fillet Weld

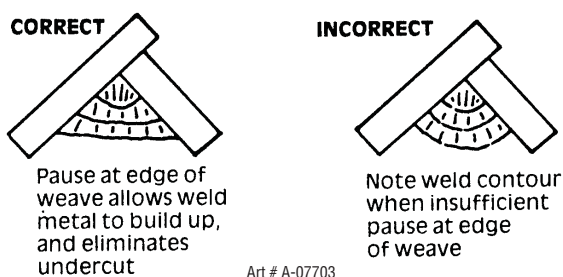


Figure 7-29: Examples of Vertical Fillet Welds

## 2. Vertical Down

The Ferrocraft 21 electrode makes welding in this position particularly easy. Use a 3.2mm electrode at 100 amps. The tip of the electrode is held in light contact with the work and the speed of downward travel is regulated so that the tip of the electrode just keeps ahead of the slag. The electrode should point upwards at an angle of about 45°.

## 3. Overhead Welds

Apart from the rather awkward position necessary, overhead welding is not much more difficult than downhand welding. Set up a specimen for overhead welding by first tacking a length of angle iron at right angles to another piece of angle iron or a length of waste pipe. Then tack this to the work bench or hold in a vice so that the specimen is positioned in the overhead position as shown in the sketch. The electrode is held at 45° to the horizontal and tilted 10° in the line of travel (Figure 7-30). The tip of the electrode may be touched lightly on the metal, which helps to give a steady run. A weave technique is not advisable for overhead fillet welds. Use a 3.2mm Ferrocraft 12XP electrode at 100 amps, and deposit the first run by simply drawing the electrode along at a steady rate. You will notice that the weld deposit is rather convex, due to the effect of gravity before the metal freezes.

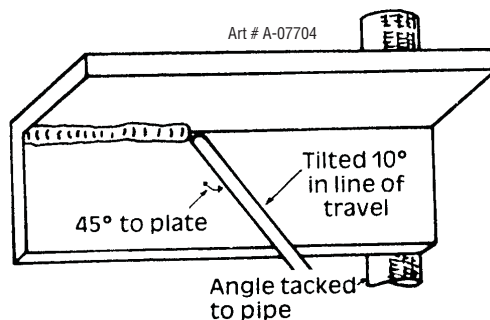


Figure 7-30: Overhead Fillet Weld

## Distortion

Distortion in some degree is present in all forms of welding. In many cases it is so small that it is barely perceptible, but in other cases allowance has to be made before welding commences for the distortion that will subsequently occur. The study of distortion is so complex that only a brief outline can be attempted here.

### The Cause of Distortion

Distortion is caused by:

#### A. Contraction of Weld Metal:

Molten steel shrinks approximately 11 per cent in volume on cooling to room temperature. This means that a cube of molten metal would contract approximately 2.2 per cent in each of its three dimensions. In a welded joint, the metal becomes attached to the side of the joint and cannot contract freely. Therefore, cooling causes the weld metal to flow plastically, that is, the weld itself has to stretch if it is to overcome the effect of shrinking volume and still be attached to the edge of the joint. If the restraint is very great, as, for example, in a heavy section of plate, the weld metal may crack. Even in cases where the weld metal does not crack, there will still remain stresses "Locked-up" in the structure. If the joint material is relatively weak, for example, a butt joint in 2.0mm sheet, the contracting weld metal may cause the sheet to become distorted.

#### B. Expansion and Contraction of Parent Metal in the Fusion Zone:

While welding is proceeding, a relatively small volume of the adjacent plate material is heated to a very high temperature and attempts to expand in all directions. It is able to do this freely at right angles to the surface of the plate (i.e., "through the weld", but when it attempts to expand "across the weld" or "along the weld", it meets considerable resistance, and to fulfil the desire for continued expansion, it has to deform plastically, that is, the metal adjacent to the weld is at a high temperature and hence rather soft, and, by expanding, pushes against the cooler, harder metal further away, and tends to bulge (or is "upset"). When the weld area begins to cool, the "upset" metal attempts to contract as much as it expanded, but, because it has been "upset" it does not resume its former shape, and the contraction of the new shape exerts a strong pull on adjacent metal. Several things can then happen.

The metal in the weld area is stretched (plastic deformation), the job may be pulled out of shape by the powerful contraction stresses (distortion), or the weld may crack, in any case, there will remain "locked-up" stresses in the job. Figures 7-31 and 7-32 illustrate how distortion is created.

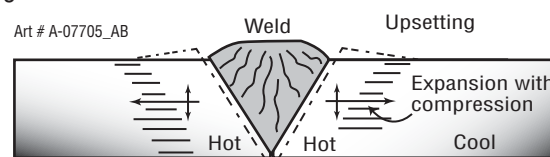


Figure 7-31: Parent Metal Expansion

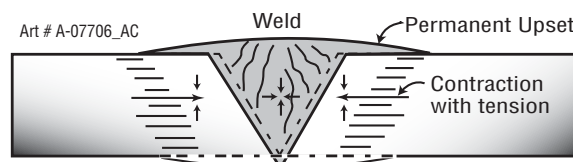


Figure 7-32 Parent Metal Contraction

## Overcoming Distortion Effects

There are several methods of minimizing distortion effects.

### A. Peening

This is done by hammering the weld while it is still hot. The weld metal is flattened slightly and because of this the tensile stresses are reduced a little. The effect of peening is relatively shallow, and is not advisable on the last layer.

### B. Distribution of Stresses

Distortion may be reduced by selecting a welding sequence which will distribute the stresses suitably so that they tend to cancel each other out. See Figures 7-36 through 7-39 for various weld sequences. Choice of a suitable weld sequence is probably the most effective method of overcoming distortion, although an unsuitable sequence may exaggerate it. Simultaneous welding of both sides of a joint by two welders is often successful in eliminating distortion.

### C. Restraint of Parts

Forcible restraint of the components being welded is often used to prevent distortion. Jigs, positions, and tack welds are methods employed with this in view.

### D. Presetting

It is possible in some cases to tell from past experience or to find by trial and error (or less frequently, to calculate) how much distortion will take place in a given welded structure. By correct pre-setting of the components to be welded, constructional stresses can be made to pull the parts into correct alignment. A simple example is shown in Figure 7-33.

### E. Preheating

Suitable preheating of parts of the structure other than the area to be welded can be sometimes used to reduce distortion. Figure 7-34 shows a simple application. By removing the heating source from b and c as soon as welding is completed, the sections b and c will contract at a similar rate, thus reducing distortion.

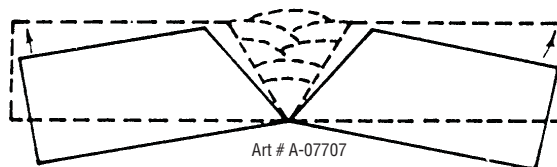
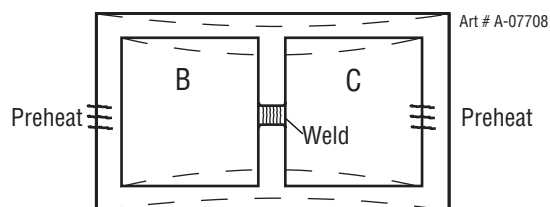


Figure 7-33: Principle of Presetting



Dotted lines show effect if no preheat is used

Figure 7-34: Reduction of Distortion by Preheating

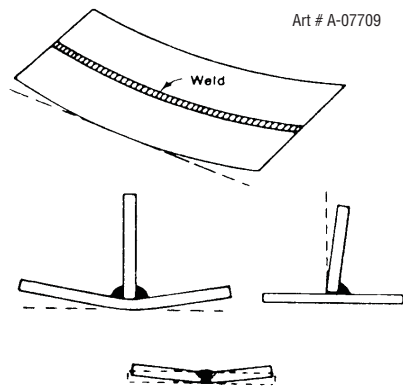


Figure 7-35: Examples of Distortion

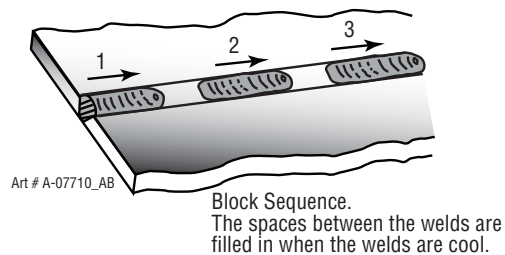


Figure 7-36: Welding Sequence

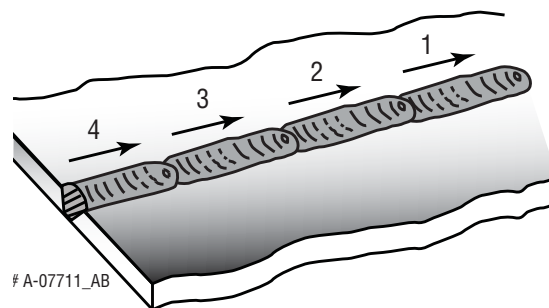


Figure 7-37: Step back Sequence

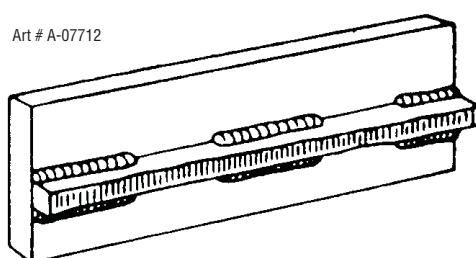


Figure 7-38: Chain Intermittent Welding

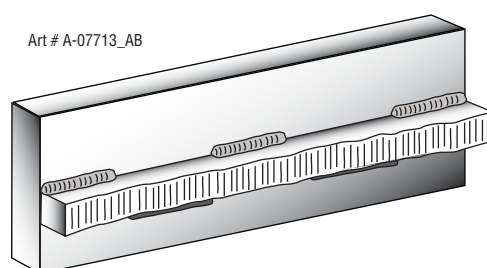


Figure 7-39: Staggered Intermittent Welding

## 7.04 Electrode Selection Chart

CIGWELD Electrode Selection Chart				
Description	Diameter	Pack	Part No.	Application
Satincraft 13	2.5mm	1kg	322135	General purpose electrode suitable for all positional welding and galvanised steel.
	2.5mm	2.5kg	612182	
	3.2mm	1kg	322136	
	3.2mm	2.5kg	612183	
	4.0mm	5kg	611184	
Ferrocraft 12XP	2.0mm	1kg	322128	General purpose, Xtra performance electrode recommended for all positional (inc. Vertical down) welding of mild and galvanised steel.
	2.0mm	2.5kg	612231	
	2.5mm	1kg	322129	
	2.5mm	2.5kg	612232	
	3.2mm	1kg	322138	
	3.2mm	2.5kg	612233	
WeldSkill GP	4.0mm	5kg	611234	
	2.0mm	1 kg	WEG1020	User-friendly GP electrode for welding thin section mild and galvanised steels. Excellent for vertical down fillet welding applications.
	2.0mm	2.5 kg	WEG2520	
	2.5mm	1 kg	WEG1025	
	2.5mm	2.5 kg	WEG2525	
	2.5mm	5 kg	WEG5025	
	3.2mm	1 kg	WEG1032	
	3.2mm	2.5 kg	WEG2532	
	3.2mm	5 kg	WEG5032	
Satinchrome 308L-17	4.0mm	5 kg	WEG5040	
Satinchrome 308L-17	2.5mm	2.5 kg	611602	Stainless Steel type for 19Cr/10Ni stainless grades including 201, 202, 301, 302, 303, 304, 304L, 305, 308, etc
	3.2mm	2.5 kg	611603	
Satinchrome 309Mo-17	2.5mm	2.5 kg	611692	Stainless Steel type for 309 and 309L grades. It is also suitable for welding of dissimilar welding of other 300 series stainless steels.
	3.2mm	2.5 kg	611693	
	4.0mm	2.5 kg	611694	
Satinchrome 316L-17	2.0mm	2.5 kg	611661	Stainless Steel type for welding of matching Mo bearing grades, 316 and 316L.
	2.5mm	2.5 kg	611662	
	3.2mm	2.5 kg	611663	
	2.5/3.2mm	Blisterpack	322215	
	4.0mm	2.5 kg	611664	

Table 7-1: Cigweld Electrode Selection Chart continued over page



CIGWELD Electrode Selection Chart cont'd				
Description	Diameter	Pack	Part No.	Application
Weldall	2.5mm	2.5 kg	611702	High alloy stainless steel type for welding of unknown steels, repair of die or tool steels and for joining dissimilar steels. (Not recommended for cast iron).
	3.2mm	2.5 kg	611703	
	2.5/3.2mm	Blisterpack	322216	
	4.0mm	2.5 kg	611704	
Castcraft 55	3.2mm	2.5 kg	611723	For repair and maintenance welding of S.G. cast iron, meehanite and other cast irons. It produces high strength weld than Castcraft 100.
	4.0mm	2.5 kg	611724	
Castcraft 100	2.5mm	2.5 kg	611732	Soft, Ductile Nickel type electrode for repair and maintenance welding of a wide range of cast irons. It has better "wetting" action than Castcraft 55.
	3.2mm	2.5 kg	611733	
	Blisterpack	Blisterpack	322217	
	4.0mm	2.5 kg	611734	

Table 7-2: Cigweld Electrode Selection Chart

Further information on CIGWELD electrodes can be found at the website [www.cigweld.com.au](http://www.cigweld.com.au)

## 7.05 Stick (MMAW) Welding Troubleshooting

FAULT	CAUSE	REMEDY
1 Welding current varying	ARC FORCE control knob is set at a value that causes the welding current to vary excessively with the arc length.	Adjust the ARC FORCE control knob (refer to Section 4.03.4) until welding current is reasonably constant while prohibiting the electrode from sticking to the work piece when you "dig" the electrode into the workpiece.
2 A gap is left by failure of the weld metal to fill the root of the weld.	A Welding current too low B Electrode too large for joint. C Insufficient gap.	A Increase welding current. B Use smaller diameter electrode. C Allow wider gap.
3 Non-metallic particles are trapped in the weld metal.	A Non-metallic particles may be trapped in undercut from previous run. B Joint preparation too restricted. C Irregular deposits allow slag to be trapped. D Lack of penetration with slag trapped beneath weld bead. E Rust or mill scale is preventing full fusion. F Wrong electrode for position in which welding is done.	A If a bad undercut is present clean slag bout and cover with a run from a smaller gauge electrode. B Allow for adequate penetration and room for cleaning out the slag. C If very bad, chip or grind out irregularities. D Use smaller electrode with sufficient current to give adequate penetration. Use suitable tools to remove all slag from comers. E Clean joint before welding. F Use electrodes designed for position in which welding is done, otherwise proper control of slag is difficult.

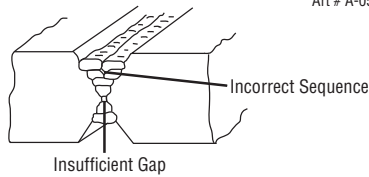


Figure 40: Example of insufficient gap or incorrect sequence

FAULT	CAUSE	REMEDY
4 A groove has been formed in the base metal adjacent to the toe of a weld and has not been filled by the weld metal (undercut).	A Welding current is too high. B Welding arc is too long. C Angle of the electrode is incorrect. D Joint preparation does not allow correct electrode angle. E Electrode too large for joint. F Insufficient deposit time at edge of weave. G Power source is set for MIG (GMAW) welding.	A Reduce welding current. B Reduce the length of the welding arc. C Electrode should not be inclined less than 45° to the vertical face. D Allow more room in joint for manipulation of the electrode. E Use smaller gauge electrode. F Pause for a moment at edge of weave to allow weld metal buildup. G Set power source to STICK (MMAW) mode.
5 Portions of the weld run do not fuse to the surface of the metal or edge of the joint.	A Small electrodes used on heavy cold plate. B Welding current is too low. C Wrong electrode angle. D Travel speed of electrode is too high. E Scale or dirt on joint surface.	A Use larger electrodes and preheat the plate. B Increase welding current. C Adjust angle so the welding arc is directed more into the base metal. D Reduce travel speed of electrode. E Clean surface before welding.

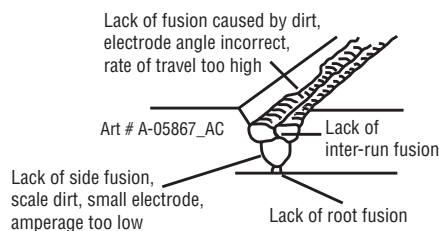


Figure 41: Example of Lack of Fusion

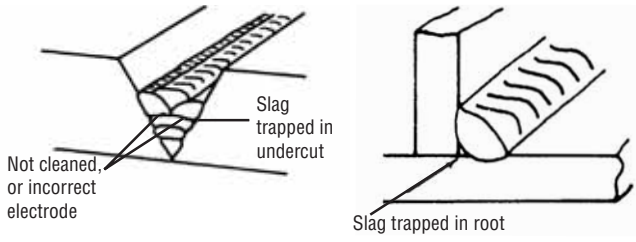
FAULT	CAUSE	REMEDY
6 Gas pockets or voids in weld metal (porosity)	A High levels of sulphur in steel. B Electrodes are damp. C Welding current is too high. D Surface impurities such as oil, grease, paint, etc. E Welding in a windy environment. F Electrode damaged ie flux coating incomplete.	A Use an electrode that is designed for high sulphur steels. B Dry electrodes before use. C Reduce welding current. D Clean joint before welding. E Shield the weld area from the wind. F Discard damaged electrodes and only use electrodes with a complete flux coating.
7 Crack occurring in weld metal soon after solidification commences	A Rigidity of joint. B Insufficient throat thickness. C Weld current is too high.	A Redesign to relieve weld joint of severe stresses or use crack resistance electrodes. B Travel slightly slower to allow greater build up in throat. C Decrease welding current.
 <p>Art # A-05868_AC</p> <p>Figure 42: Example of Slag Inclusion</p>		

Table 7-3: Welding Problems MMAW (Stick)

## SECTION 8: ROUTINE SERVICE REQUIREMENTS AND POWER SOURCE PROBLEMS

### 8.01 Routine Service and Calibration Requirements



#### WARNING

There are extremely dangerous voltage and power levels present inside this Inverter Power Source. Do not attempt to open or repair unless you are an accredited CIGWELD Service Provider. Disconnect the Welding Power Source from the Mains Supply Voltage before disassembling.

#### Routine Inspection, Testing & Maintenance

The inspection and testing of the power source and associated accessories shall be carried out in accordance with Section 5 of AS 1674.2 - 2007: Safety in Welding and Allied Processes-Part 2 Electrical. This includes an insulation resistance test and an earthing test to ensure the integrity of the unit is compliant with Cigweld's original specifications.

If equipment is to be used in a hazardous location or environments with a high risk of electrocution as outlined in AS 1674.2 - 2007, then the above tests should be carried out prior to entering this location.

#### A. Testing Schedule

1. For transportable equipment, at least once every 3 months; and
2. For fixed equipment, at least once every 12 months.

The owners of the equipment shall keep a suitable record of the periodic tests and a system of tagging, including the date of the most recent inspection.

A transportable power source is deemed to be any equipment that is not permanently connected and fixed in the position in which it is operated.

#### B. Insulation Resistance

Minimum insulation resistance for in-service Cigweld Inverter Power Sources shall be measured at a voltage of 500V between the parts referred to in Table 8-1 below. Power sources that do not meet the insulation resistance requirements set out below shall be withdrawn from service and not returned until repairs have been performed such that the requirements outlined below are met.

Components to be Tested	Minimum Insulation Resistance (M $\Omega$ )
Input circuit (including any connected control circuits) to welding circuit (including any connected control circuits)	5
All circuits to exposed conductive parts	2.5
Welding circuit (including any connected control circuits) to any auxiliary circuit which operates at a voltage exceeding extra low voltage	10
Welding circuit (including any connected control circuits) to any auxiliary circuit which operates at a voltage not exceeding extra low voltage	1
Separate welding circuit to separate welding circuit	1

Table 8-1: Minimum Insulation Resistance Requirements: Cigweld Inverter Power Sources

### C. Earthing

The resistance shall not exceed  $1\Omega$  between any metal of a power source where such metal is required to be earthed, and -

1. The earth terminal of a fixed power source; or
2. The earth terminal of the associated plug of a transportable power source

Note that due to the dangers of stray output currents damaging fixed wiring, the integrity of fixed wiring supplying Cigweld welding power sources should be inspected by a licensed electrical worker in accordance with the requirements below -

1. For outlets/wiring and associated accessories supplying transportable equipment - at least once every 3 months; and
2. For outlets/wiring and associated accessories supplying fixed equipment - at least once every 12 months.

### D. Voltage Reduction Device (VRD)

Units fitted with VRD's, shall have the periodic tests outlined in Table 8-2 below conducted by an accredited CIGWELD service provider. Testing shall be conducted at intervals as outlined below -

1. For transportable equipment, at least once every 3 months; and
2. For fixed equipment, at least once every 12 months.

Description	Required Parameters
VRD Open Circuit Voltage	Less than 26V; at nominal input voltage
VRD Turn ON Resistance	Less than 200 ohms
VRD Turn OFF Time	Less than 0.3 seconds

Table 8-2: VRD Periodic Tests

### E. General Maintenance Checks

Welding equipment should be regularly checked by an accredited Cigweld Service Provider to ensure that:

1. Flexible cord is of the multi-core tough rubber or plastic sheathed type of adequate rating, correctly connected and in good condition.
2. Welding terminals are in suitable condition and are shrouded to prevent inadvertent contact or short circuit.
3. The Welding System is clean internally, especially from metal filing, slag, and loose material.

### F. Accessories

Accessory equipment, including output leads, electrode holders, torches, wire feeders and the like shall be inspected at least monthly by a competent person to ensure that the equipment is in a safe and serviceable condition. All unsafe accessories shall not be used.

### G. Repairs

If any parts are damaged for any reason, it is recommended that replacement be performed by an accredited Cigweld Service Provider.

**Power Source Calibration****A. Schedule**

Output testing of all Cigweld Inverter Power Sources and applicable accessories shall be conducted at regular intervals to ensure they fall within specified levels. Calibration intervals shall be as outlined below -

1. For transportable equipment, at least once every 3 months; and
2. For fixed equipment, at least once every 12 months.

If equipment is to be used in a hazardous location or environments with a high risk of electrocution as outlined in AS 1674.2 - 2007, then the above tests should be carried out prior to entering this location.

**B. Calibration Requirements**

Where applicable, the tests outlined in Table 8-3 below shall be conducted by an accredited CIGWELD service agent.

Testing Requirements
Output current (A) to be checked to ensure it falls within applicable Cigweld power source specifications
Output Voltage (V) to be checked to ensure it falls within applicable Cigweld power source specifications
Motor Speed (RPM) of wire drive motors to be checked to ensure it falls within required Cigweld power source / wire feeder specifications
Accuracy of digital meters to be checked to ensure it falls within applicable Cigweld power source specifications

Table 8-3: Calibration Parameters

Periodic calibration of other parameters such as timing functions are not required unless a specific fault has been identified.

**C. Calibration Equipment**

All equipment used for Power Source calibration shall be in proper working condition and be suitable for conducting the measurement in question. Only test equipment with valid calibration certificates (NATA certified laboratories) shall be utilized.



## 8.02 Cleaning the Welding Power Source



### WARNING

There are extremely dangerous voltage and power levels present inside this Inverter Power Source. Do not attempt to open or repair unless you are an accredited CIGWELD Service Provider. Disconnect the Welding Power Source from the Mains Supply Voltage before disassembling.

To clean the Welding Power Source, open the enclosure and use a vacuum cleaner to remove any accumulated dirt, metal filings, slag and loose material. Keep the shunt and lead screw surfaces clean as accumulated foreign material may reduce the welders output welding current.

## 8.03 Cleaning the Feed Rolls

Clean the grooves in the drive rolls frequently. This can be done by using a small wire brush. Also wipe off, or clean the grooves on the upper feed roll. After cleaning, tighten the feed roll retaining knobs.



### CAUTION

Do not use compressed air to clean the Welding Power Source. Compressed air can force metal particles to lodge between live electrical parts and earthed metal parts within the Welding Power Source. This may result in arcing between this parts and their eventual failure.

## 8.04 Power Source Problems

FAULT	CAUSE	REMEDY
1 Mains Supply Voltage is On, the On/Off switch on the rear panel is in the On position and the LCD screen on the front panel is illuminated however the power source will not MIG weld.	A Power source is not in the correct mode of operation.	A In the Home Screen (Welding Mode) Set to either Auto MIG or Manual MIG mode. Refer to Section 4.02.5.
	B MIG Torch Polarity Lead is not connected.	B Connect the MIG Torch Polarity Lead to the positive or negative output terminal. Refer to Section 4.02.9.
	C Work Lead is not connected to the work piece.	C Ensure that the Work Lead is connected to the work piece and has a good connection to the work piece. Refer to MIG Gas Shielded Set Up in Section 5.09 or 5.11, or MIG Gasless Set Up in Section 5.10 or 5.12.
	D MIG torch is not correctly connected to the Euro Style MIG Torch Adaptor.	D Ensure that the MIG torch is correctly connected to the Euro Style MIG Torch Adaptor. Refer to Section 4.02.7.
2 Mains Supply Voltage is On, the On/Off switch on the rear panel is in the On position and the LCD screen on the front panel is illuminated however the power source will not STICK weld.	A Power source is not in the correct mode of operation.	A Set the power source to STICK mode. Refer to Section 4.02.5.
	B Work Lead is not connected to the work piece.	B Ensure that the Work Lead is connected to the work piece and has a good connection to the work piece.

FAULT	CAUSE	REMEDY
<p>3 Mains Supply Voltage is On, the On/Off switch on the rear panel is in the On position and the LCD screen on the front panel is illuminated however the power source will not TIG weld.</p>	<p>A Power source is not in the correct mode of operation.</p> <p>B Work Lead is not connected to the work piece.</p> <p>C TIG Torch 8 Pin Control Plug not connected correctly or loose/faulty connection in plug.</p> <p>D Faulty TIG Torch Trigger.</p>	<p>A Set the power source to either Auto TIG or Manual TIG mode. Refer to Section 4.02.5.</p> <p>B Ensure that the Work Lead is connected to the work piece and has a good connection to the work piece.</p> <p>C Connect 8 Pin TIG Torch control plug securely and correctly to the 8 Pin control socket of the front of the Transmig 185 Ultra Power Source. Note that Remote Current Control feature is not available for 185 Ultra. 8 pin socket connection for Trigger Switch only. Repair or replace if faulty.</p> <p>D Repair or replace TIG Torch Trigger switch/lead.</p>
<p>4 Over Temp Error, unit will not commence welding when the torch trigger switch is depressed.</p>	<p>Duty cycle of power source has been exceeded.</p>	<p>Leave the power source switched ON and allow it to cool. Note that Over Temp indicator must be extinguished prior to commencement of welding.</p>
<p>5 Unit will not feed wire in MIG mode.</p>	<p>A Incorrect Feed Roll fitted for wire type being used.</p> <p>B Pressure Roller Arm is not secured in the down position or not correctly adjusted.</p> <p>C Electrode wire stuck in conduit liner or contact tip (burn-back jam).</p> <p>D Internal fault in power source</p>	<p>A Fit the correct feed roll for MIG wire type being used. Refer to Section 2.11 for optional feed rolls available and Section 5.07 for feed roll fitting details.</p> <p>B Secure Pressure Roller in the down position and ensure that it is correctly adjusted. Refer to Section 5.05 and 5.06.</p> <p>C Check for clogged / kinked MIG torch conduit liner or worn contact tip. Replace faulty components.</p> <p>D Have an Accredited CIGWELD Service Provider investigate the fault.</p>
<p>6 Welding wire continues to feed when torch trigger is released.</p>	<p>A Trigger mode selection switch is in 4T latch mode.</p> <p>B Torch trigger lead or switch shorted.</p>	<p>A In the Advanced Settings change the trigger mode selection switch from 4T latch mode to 2T normal mode. Refer to Section 4.03.4.</p> <p>B Repair or replace torch trigger switch/lead.</p>

FAULT	CAUSE	REMEDY
7 Welding arc cannot be established in MIG mode.	<p>A MIG torch polarity lead is not connected into a welding output terminal.</p> <p>B Poor or no work lead contact.</p>	<p>A Connect the MIG torch polarity lead to either the positive welding output terminal or the negative welding output terminal as required.</p> <p>B Clean work clamp area and ensure good electrical contact.</p>
8 Inconsistent wire feed.	<p>A Worn or dirty contact tip.</p> <p>B Worn feed roll.</p> <p>C Excessive brake tension on wire reel hub.</p> <p>D Worn, kinked or dirty conduit liner</p>	<p>A Replace if necessary.</p> <p>B Replace.</p> <p>C Reduce brake tension on spool hub</p> <p>D Clean or replace conduit liner</p>
9 No gas flow in MIG mode.	<p>A Gas hose is damaged.</p> <p>B Gas passage contains impurities.</p> <p>C Gas regulator turned off.</p> <p>D Empty gas cylinder.</p>	<p>A Replace or repair.</p> <p>B Disconnect gas hose from the rear of power source or wirefeeder and blow out impurities.</p> <p>C Turn on regulator.</p> <p>D Replace gas cylinder.</p>
10 Gas flow continues after the torch trigger switch has been released (MIG mode).	Gas valve has jammed open due to impurities in the gas or the gas line.	Have an accredited CIGWELD service provider repair or replace gas valve.
11 The LCD Display will not illuminate and the power source is not responding.	The mains supply voltage has exceeded voltage limits of the power source.	Ensure that the mains supply is within 240VAC +/- 15% then turn the power source OFF then turn the power source back ON.
12 Error Screen is displayed and welding arc cannot be established.	Over current condition is detected.	Turn the power source OFF then turn the power source back ON. If Error screen is still present contact an accredited Cigweld Service Provider.
13 TIG electrode melts when arc is struck.	TIG torch is connected to the (+) VE terminal.	Connect the TIG torch to the (-) VE terminal.
14 Arc flutters during TIG welding.	Tungsten electrode is too large for the welding current.	Select the correct size of tungsten electrode. Refer to Table 6-1.
15 LCD screen has frozen or adjustment does change display of data.	Overloaded operation and LCD cannot react.	<p>A Press and hold Control Knob until the screen returns to Home Page.</p> <p>B Press and hold Control Knob to return to Home Page and into the Information Menu then to Factory Reset. Refer to Section 4.02.1 for detailed instruction.</p>

Table 8-4

## SECTION 9: KEY SPARE PARTS

### 9.01 Tweco Professional Fusion DX250 Digital MIG Torch

MIG Torch Part No: W4018900

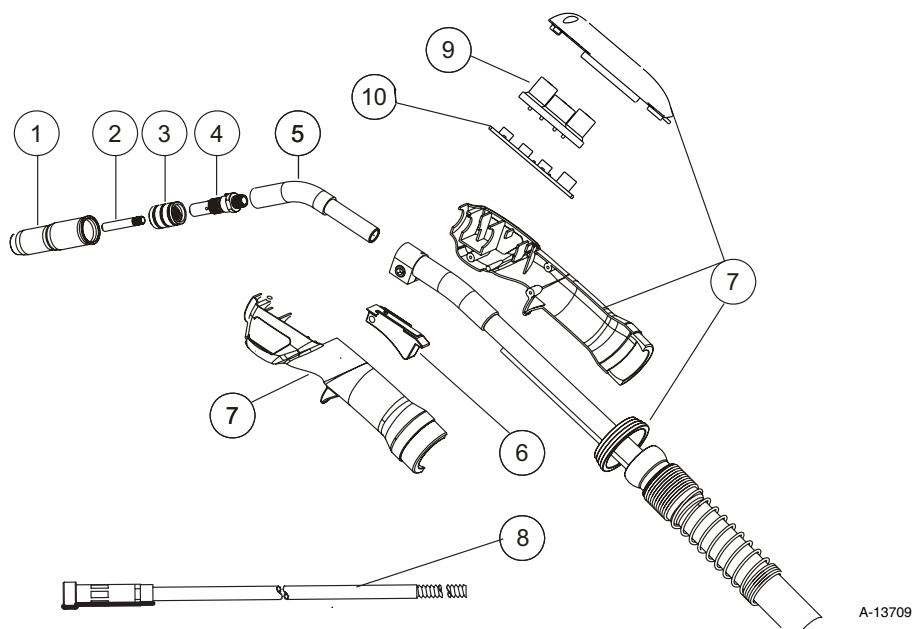


Figure 9-1

TWECO FUSION DX250 DIGITAL MIG TORCH PARTS		
ITEM	PART NO.	DESCRIPTION
1	OTW22/50	Nozzle 13mm
	OTW22/62	Nozzle 16mm
2	OTW14/23	Contact Tip 0.6mm
	OTW14/30	Contact Tip 0.8mm
	OTW14/35	Contact Tip 0.9mm
	OTW14/40	Contact Tip 1.0mm
	OTW14/45	Contact Tip 1.2mm
3	OTW32	Insulator
4	OTW52	Gas Diffuser
5	62J-45S	Conductor Tube, 45 Degree
6	W7005001	Trigger Assembly
7	W7005002	Handle Mouldings
8	OTW42/035DX	Conduit Liner Steel 0.8-1.0 (Hard Wires) DX250
	OTW42/045DX	Conduit Liner Steel 1.0-1.2 (Hard Wires) DX250
	OTW42N/545DX	Conduit Liner Nylon 0.9-1.2 (Soft Wires) DX250
9	W7005003	Wirespeed / Voltage Control Buttons
10	W7005004	Digital MIG Torch Control PCBA

Table 9-1

### 9.02 Power Source

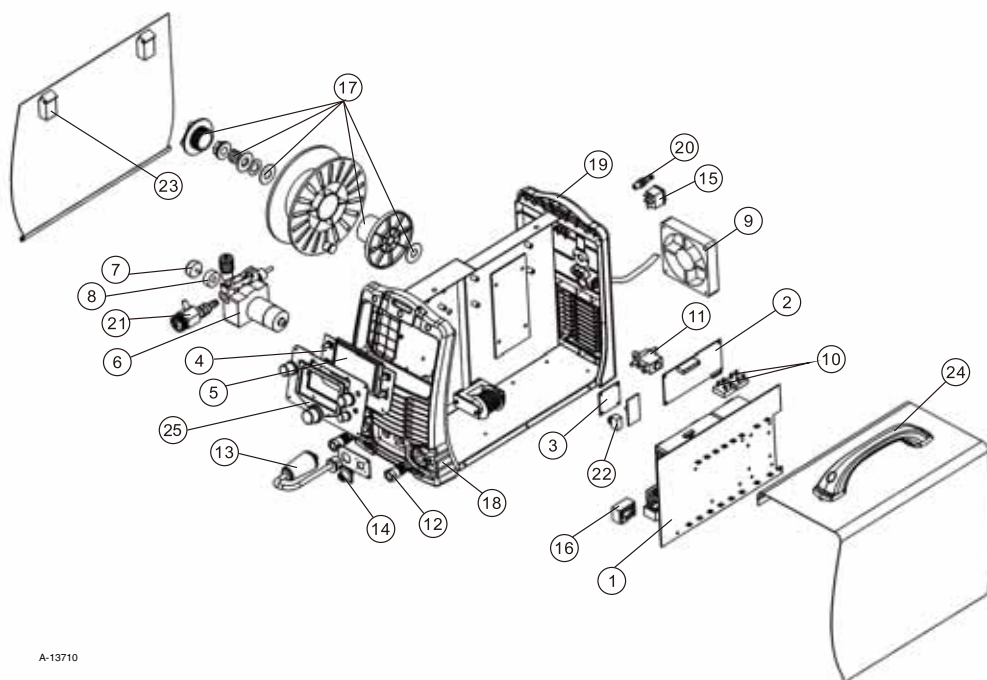


Figure 9-2

TRANSMIG 185 ULTRA POWER SOURCE SPARE PARTS		
ITEM	PART NUMBER	DESCRIPTION
1	W7005570	PCBA Power
2	W7005571	PCBA Control
3	W7005607	PCBA Spool Gun
4	W7005572	PCBA LCD Display
5	W7005573	LCD Screen 4.3 Inch
6	W7005574	Wiredrive Assembly
7	W7004906	Thumbscrew, Feedroll Positioner
8	Refer Page 2-7 (Options and Accessories Table)	Feed Roll
9	W7004907	Fan Assembly
10	W7003010	Input Rectifier
11	W7004908	Gas Solenoid Valve
12	W7004909	Dinse Socket
13	704461	Dinse Plug Male 50mm2
14	W7005587	Control Socket 8 Pin with Harness (Note 8 Pin Control Plug is UOA706900)
15	W7005575	Input Supply ON/OFF Switch
16	W7004911	CT Output
17	W7004912	Wire Hub Assembly
18	W7005576	Front Panel
19	W7005577	Rear Panel
20	W7005578	Gas Inlet Fitting
21	W7004917	Adaptor, Euro

See overpage for further parts listed.

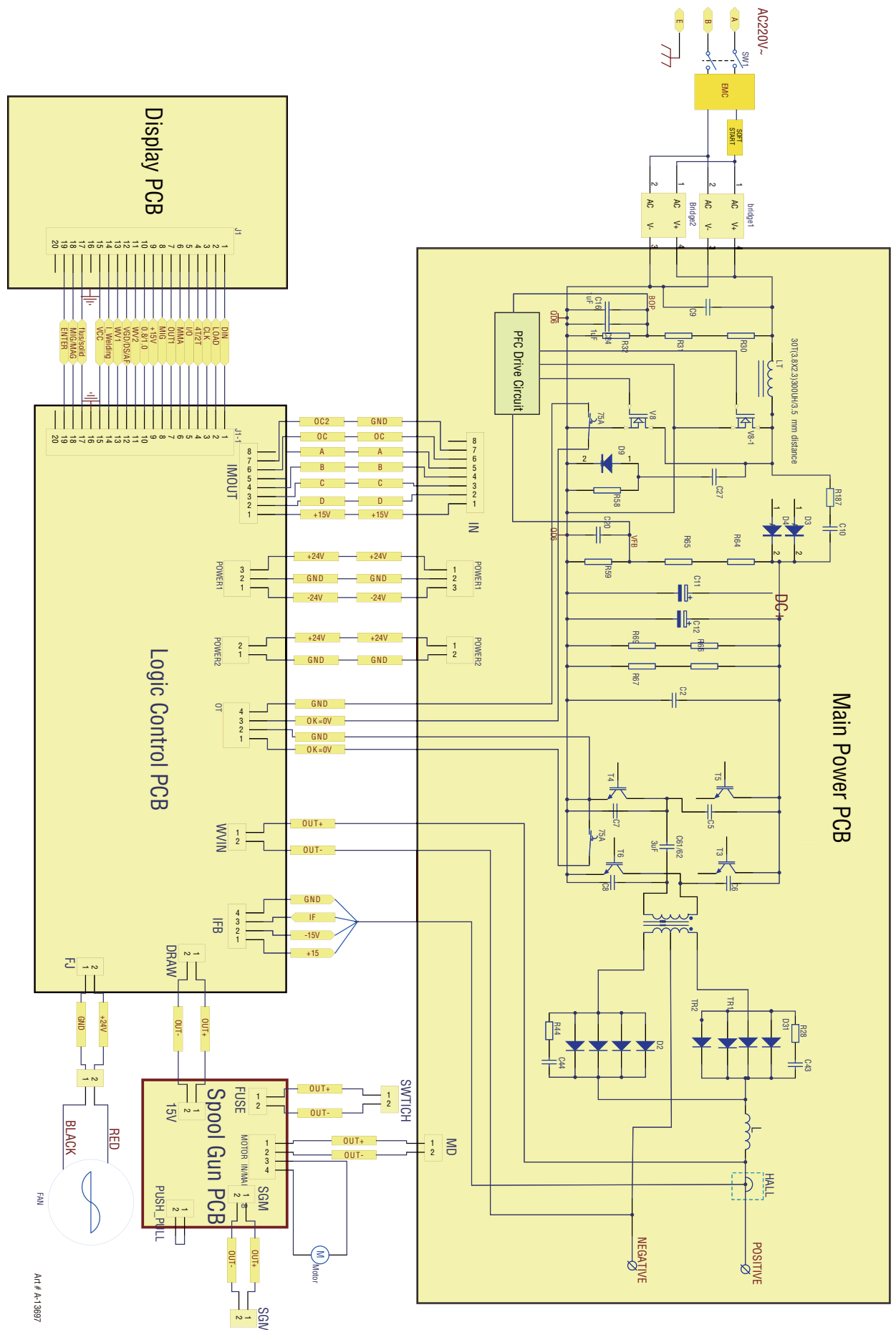
ITEM	PART NUMBER	DESCRIPTION
22	W7005629	Circuit Breaker, 4A
23	W7005635	Latch, Door
24	W7005579	Handle
25	W7005586	LCD Screen Protector Lens Frame
26	W7005585	Clear LCD Screen Protector Lens (not shown)

Table 9-2



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## APPENDIX



## CIGWELD - LIMITED WARRANTY TERMS

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**LIMITED WARRANTY:** CIGWELD Pty Ltd, An ESAB Brand, hereafter, "CIGWELD" warrants to customers of its authorized distributors hereafter "Purchaser" that its products will be free of defects in workmanship or material. Should any failure to conform to this warranty appear within the time period applicable to the CIGWELD products as stated below, CIGWELD shall, upon notification thereof and substantiation that the product has been stored, installed, operated, and maintained in accordance with CIGWELD's specifications, instructions, recommendations and recognized standard industry practice, and not subject to misuse, repair, neglect, alteration, or accident, correct such defects by suitable repair or replacement, at CIGWELD's sole option, of any components or parts of the product determined by CIGWELD to be defective.

CIGWELD MAKES NO OTHER WARRANTY, EXPRESS OR IMPLIED. THIS WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHERS, INCLUDING, BUT NOT LIMITED TO ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE.

**LIMITATION OF LIABILITY:** CIGWELD SHALL NOT UNDER ANY CIRCUMSTANCES BE LIABLE FOR SPECIAL, INDIRECT OR CONSEQUENTIAL DAMAGES, SUCH AS, BUT NOT LIMITED TO, LOST PROFITS AND BUSINESS INTERRUPTION. The remedies of the Purchaser set forth herein are exclusive and the liability of CIGWELD with respect to any contract, or anything done in connection therewith such as the performance or breach thereof, or from the manufacture, sale, delivery, resale, or use of any goods covered by or furnished by CIGWELD whether arising out of contract, negligence, strict tort, or under any warranty, or otherwise, shall not, except as expressly provided herein, exceed the price of the goods upon which such liability is based. No employee, agent, or representative of CIGWELD is authorized to change this warranty in any way or grant any other warranty.

PURCHASER'S RIGHTS UNDER THIS WARRANTY ARE VOID IF REPLACEMENT PARTS OR ACCESSORIES ARE USED WHICH IN CIGWELD'S SOLE JUDGEMENT MAY IMPAIR THE SAFETY OR PERFORMANCE OF ANY CIGWELD PRODUCT. PURCHASER'S RIGHTS UNDER THIS WARRANTY ARE VOID IF THE PRODUCT IS SOLD TO PURCHASER BY NON-AUTHORIZED PERSONS.

The warranty is effective for the time stated below beginning on the date that the authorized distributor delivers the products to the Purchaser. Notwithstanding the foregoing, in no event shall the warranty period extend more than the time stated plus one year from the date CIGWELD delivered the product to the authorized distributor.

Any claim under this warranty must be made within the warranty period which commences on the date of purchase of the product. To make a claim under the warranty, take the product (with proof of purchase from a Cigweld Accredited Seller) to the store where you purchased the product or contact Cigweld Customer Care 1300 654 674 for advice on your nearest Service Provider. CIGWELD reserves the right to request documented evidence of date of purchase. CIGWELD or our Accredited Distributor must be notified in writing of its claim within seven (7) days of becoming aware of the basis thereof, and at its own expense returning the goods which are the subject of the claim to CIGWELD or nominated Accredited Distributor/Accredited Service Provider

This warranty is given.

Cigweld Pty Ltd

A.B.N. 56007226815

71 Gower Street, Preston

Victoria, Australia, 3072

Phone: 1300 654 674

Email: [enquiries@cigweld.com.au](mailto:enquiries@cigweld.com.au)

Website: [www.cigweld.com.au](http://www.cigweld.com.au)

This warranty is provided in addition to other rights and remedies you have under law: Our goods come with guarantees which cannot be excluded under the Australian Consumer Law. You are entitled to replacement or refund for a major failure and to compensation for other reasonably foreseeable loss or damage. You are also entitled to have the goods repaired or replaced if the goods fail to be of acceptable quality and the failure does not amount to a major failure.

Please note that the information detailed in this statement supersedes any prior published data produced by CIGWELD.

## WARRANTY SCHEDULE – TRANSMIG 185 ULTRA

WARRANTY	WARRANTY PERIOD – (Parts and Labour)
Transmig 185 Ultra Inverter Power Source	3 Years
ACCESSORIES	WARRANTY PERIOD
MIG torch, electrode holder lead and work lead.	3 Months
MIG torch consumable items	NIL
Gas regulator/flowmeter (excluding seat assembly, pressure gauges, elastomer seals and “O” rings).	1 Year
Regulator seat assemblies and pressure gauges.	6 Months
Elastomer seals and “O” rings used in the equipment	3 Months

CIGWELD Limited Warranty does not apply to;

- Obsolete goods sold at auction, second-hand goods and prototype goods.
- Consumable Parts for MIG, TIG, Plasma welding, Plasma cutting and Oxy fuel torches, O-rings, fuses, filters or other parts that fail due to normal wear.

Note:

\* No employee, agent, or representative of CIGWELD is authorized to change this warranty in any way or grant any other warranty, and CIGWELD shall not be bound by any such attempt. Correction of non-conformities, in the manner and time provided herein, constitutes fulfilment of CIGWELD's obligations to purchaser with respect to the product.

\* This warranty is void, and seller bears no liability hereunder, if purchaser used replacement parts or accessories which, in CIGWELD's sole judgment, impaired the safety or performance of any CIGWELD product and if the unit is altered or serviced by an unauthorised CIGWELD Service Provider. Purchaser's rights under this warranty are void if the product is sold to purchaser by unauthorized persons.



**CIGWELD Pty Ltd**  
**CIGWELD An ESAB Brand**  
71 Gower Street, Preston VIC 3072 Australia

**Customer Care**  
Tel: 1300 654 674 | Fax: 03 9474 7391  
Email: [enquiries@cigweld.com.au](mailto:enquiries@cigweld.com.au)

**International Enquiries**  
Tel: +61 3 9474 7508 | Fax: +61 3 9474 7488

#### **Malaysia**

Lot 151, Jalan Industri 3/5A  
Rawang Integrated Industrial Park,  
Jln Batu Arang  
48000 Rawang Selangor Darul Ehsan  
West Malaysia

Tel: 60 3 6092 2988 | Fax: 60 3 6092 1085

#### **Indonesia**

JL Akasia II Blok A-05 No. 10A  
Delta Silicon - Lippo Cikarang  
Bekasi, 17550  
Indonesia

**Toll Free: 0 800 1842 867**  
Tel: +62 21 8990 6095 | Fax: +62 21 8990 6096