



INNOVATION TO SHAPE THE WORLD"

BEST PRACTICE

ALUMINIUM WELDING SET-UP TWECO FUSION 250AMP MIG TORCH

MIG TORCH PART No W4013701 - 3M OR OTWF212X3035 - 3.6M



STEP 1 – TAKE OUT FRONT END CONSUMABLES (NOZZLE, INSULATOR & TIP)



STEP 2 – LOOSEN GRUB SCREW ON GAS DIFFUSER, THEN SCREW GAS DIFFUSER OUT OF THE CONDUCTOR TUBE WITH A 5/64" ALLEN KEY.



STEP 3 – SCREW OFF END CAP, PULL LINER BACK THROUGH THE MIG TORCH, TAKING IT COMPLETELY OUT.









STEP 4 – SELECT THE CORRECT NYLON LINER FOR THE TORCH AT HAND (OTW42N/3545).



STEP 5 - SELECT THE CORRECT COPPER JUMP LINER FOR THE TORCH AT HAND (WS0010304/R).







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STEP 6 – SCREW OFF THE BRASS NIPPLE OFF THE NYLON LINER & DRILL OUT THREAD WITH A 3.5MM (9/64") DRILL BIT SO THAT THE BRASS END CAP SLIDES ALONG THE NYLON LINER QUITE NEATLY.



STEP 7 – FIT THE JUMP LINER TO THE FRONT OF THE NYLON LINER THEN DO A SLIGHT CRIMP WITH A PAIR OF SIDE CUTTERS OR MIG PLIERS OF THE JUMP LINER ONTO THE NYLON LINER (TWO WAYS KEEPING IT FAIRLY ROUND TO STILL FIT UP THROUGH THE MIG TORCH)



STEP 8 – SLIDE THE NYLON LINER UP THROUGH THE BACK END OF THE MIG TORCH PUSHING THROUGH FROM THE ATTACHED JUMP LINER FIRST, MAKING SURE WHEN IT IS OUT THE FRONT OF THE MIG TORCH IT PROTRUDES OUT PAST WHERE THE GAS HOLES WOULD BE IN THE GAS DIFFUSER (SEE IMAGE ABOVE).









STEP 9 – FIT UP ALL FRONT END CONSUMABLES BACK IN THE MIG TORCH – FIRST GAS DIFFUSER INTO CONDUCTOR TUBE THEN TIGHTEN THE GRUB SCREW BACK ON THE JUMP LINER (FIRM NOT OVER TIGHTEN), THEN THE CONTACT TIP, DIFFUSER & LASTLY THE NOZZLE (FRONT END COMPLETE).



STEP 10 – SLIDE BRASS NIPPLE ON NYLON LINER & FIT END CAP OF MIG TORCH UP BY SCREWING ON BRASS END CAP, LEAVING NYLON LINER EXCESS HANGING OUT THE BACK END OF THE MIG TORCH TO TRIM OFF.

WHEN FITTING THE MIG TORCH TO THE POWER SOURCE IN USE FIRST TAKE OUT THE BRASS OUTLET GUIDE OF THE WIREFEEDER.

THEN SLIDE THE EXCESS NYLON LINER THROUGH THE EURO FITTING ON THE FRONT OF THE POWER SOURCE WITH THE FEED ROLLER OFF, THEN TRIM OFF THE EXCESS NYLON LINER SO THAT IT FITS NEAT UP TO THE EDGE OF THE FEE ROLLS, MAKING SURE YOU HOLD THE NYLON LINER FORWARD WHEN DOING THIS PROCESS OR IT WILL BE TOO SHORT.

FIT THE U GROOVE FEEDROLL BACK IN PLACE ON THE WIREFEEDER, FEED YOUR ALUMINIUM WIRE THROUGH THE TORCH & YOU ARE READY TO WELD ALUMINIUM.

THE LARGER THE DIAMETER OF ALUMINIUM WIRE THE BETTER, AS FEEDABILITY IS ALWAYS BETTER WITH SOFT WIRES IN LARGER DIAMETERS, (AS PRACTICAL FOR THE PLATE THICKNESS BEING WELDED)

THE ABOVE PRACTICE WHILE FOLLOWED IN THE CORRECT MANNER & AS PER THE STEPS WILL AVOID ANY FEEDABILITY ISSUES ARISEN IN THE PAST.

ANY FURTHER INFORMATION REQUIRED PLEASE FEEL FREE IN CONTACTING CIGWELD CUSTOMER CARE ON

PH: 1300 654 674





NOTE: WHEN WELDING ALUMINIUM MUST RUN BOTH THE OTW42N/3545 & WS0010304/R.

NOTE: ANY LINE ITEM WITH THE * ALONG SIDE IT IS ON THE MIG TORCH OUT OF THE BOX FROM NEW.

	REPLACEMENT TORCHES – COMPLETE (OPTIONS 3M OR 3.6M)		
1	TORCH MIG FUSION 250A EURO 3M	W4013701	
2	TORCH MIG FUSION 250A EURO 3.6M	OTWF212X3035	

#	DESCRIPTION	PART No
1	NOZZLE ADJUSTABLE 13MM *	OTW22A/50
1	NOZZLE ADJUSTABLE 16MM	OTW22A/62
1	NOZZLE HD FIXED 16MM	717532
2	CONTACT TIP 0.6MM	OTW14/23
2	CONTACT TIP 0.8MM	OTW14/30
2	CONTACT TIP 0.9MM *	OTW14H/35
2	CONTACT TIP 1.0MM	OTW14H/40
2	CONTACT TIP 1.2MM	OTW14H/45
2	CONTACT TIP 1.2MM (A)	717256
3	INSULATOR *	OTW32
3	INSULATOR #4 HD FIXED	717540
4	DIFFUSER *	OTW52
4	DIFFUSER #2 HD	OTW52FN
5	CONDUIT LINER 0.8-0.9MM HARD WIRE *	OTW42/3035
5	CONDUIT LINER 0.9-1.2MM HARD WIRE	OTW42/4045
5	CONDUIT LINER 0.8-1.2MM SOFT WIRE	OTW42N/3545 (ALUMINIUM)
5	COPPER JUMP LINER	WS0010304/R (ALUMINIUM)
6	CONDUCTOR TUBE 45° METAL JACKET *	62J-45S
6	CONDUCTOR TUBE 60° FLEX	62SFLX360
7	TRIGGER ASSEMBLY *	W7005001
8	FUSION HANDLE MOULDING *	W7005000

TWECO FUSION 250AMP MIG TORCH BREAKDOWN







