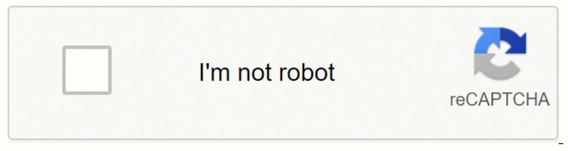

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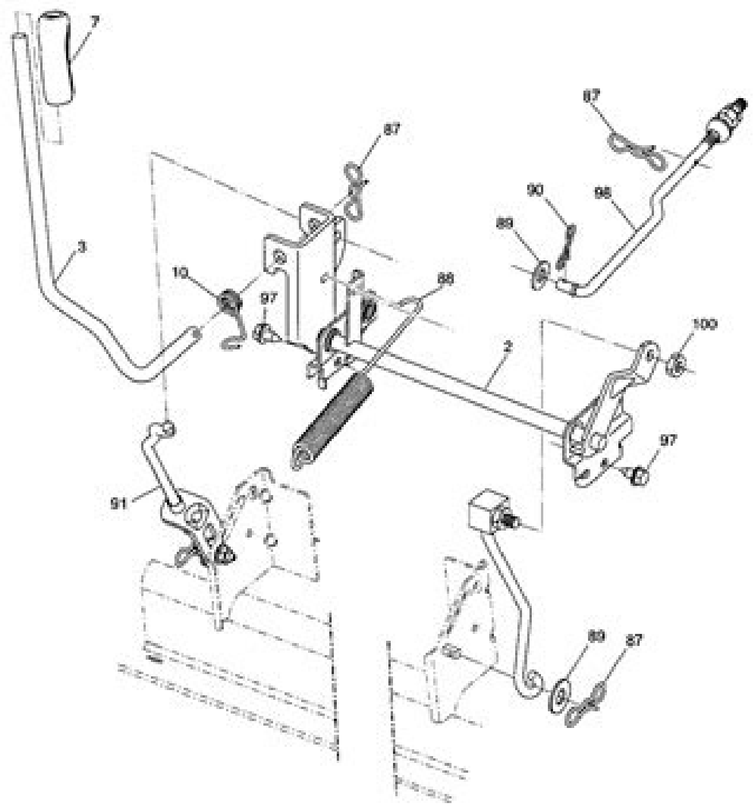

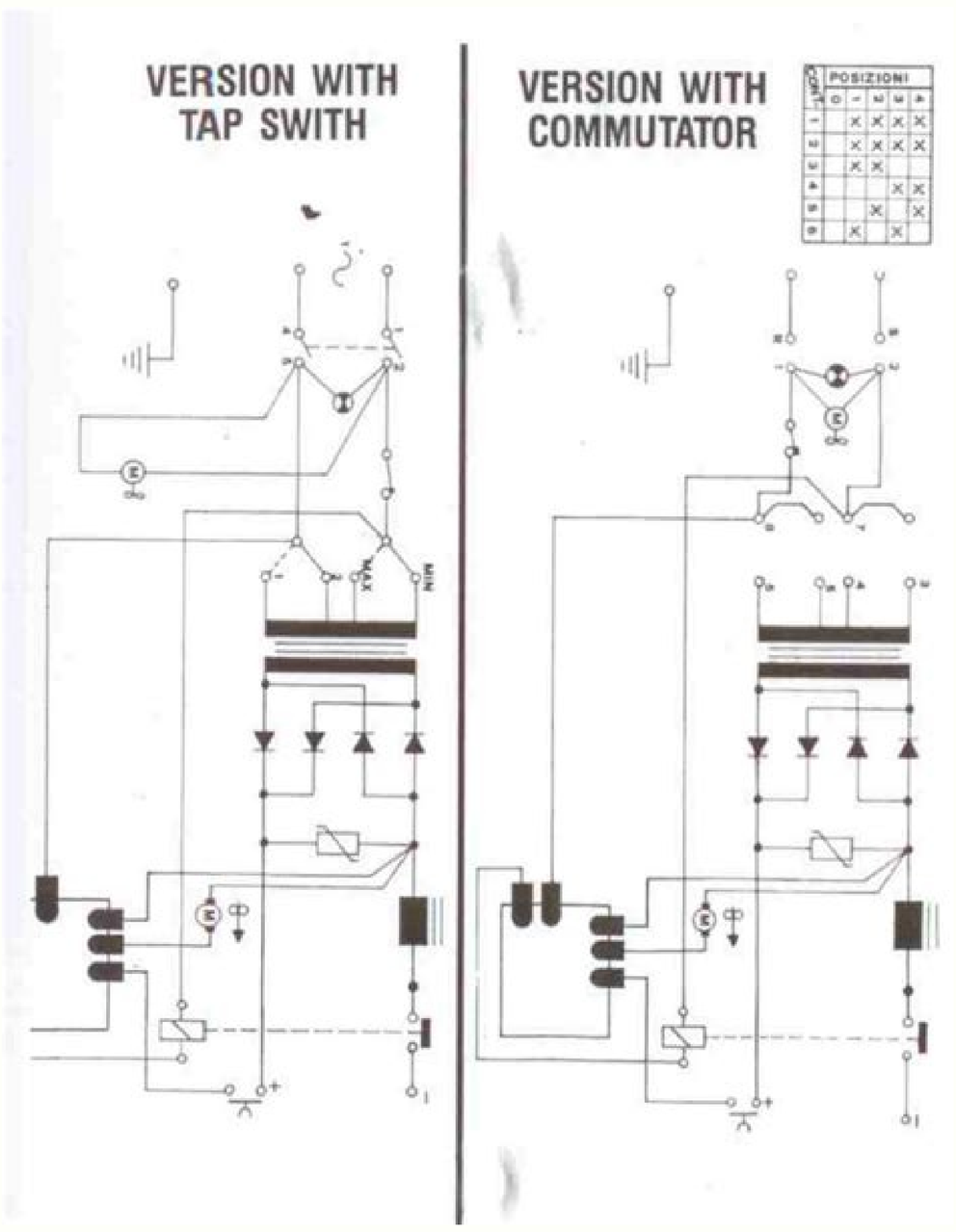

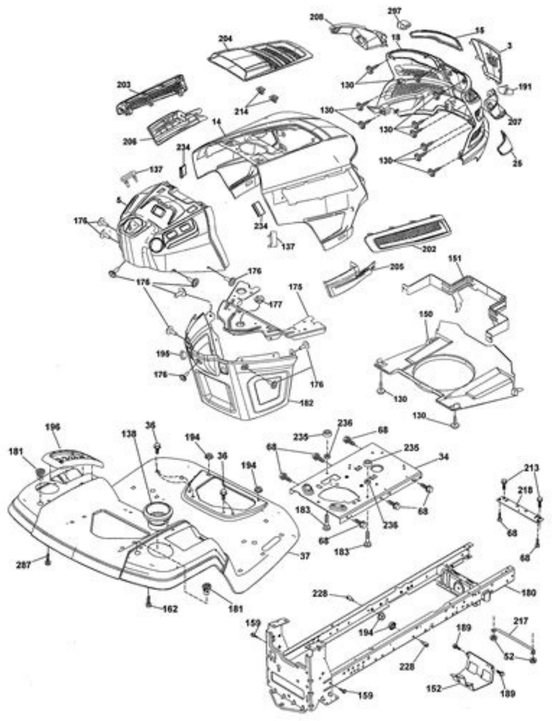

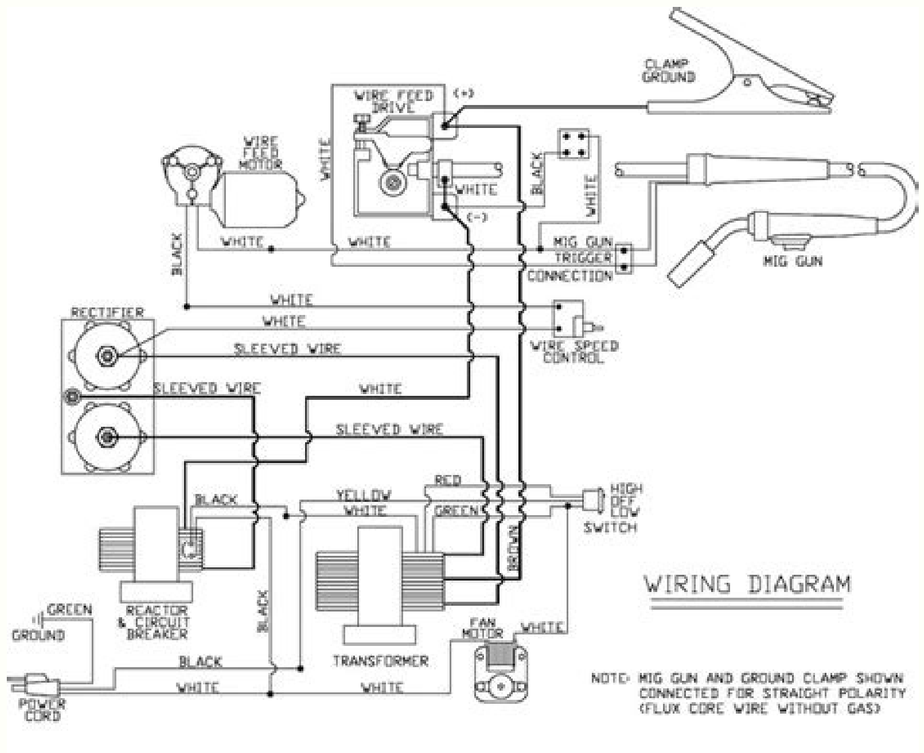

MIG (GMAW) and flux-cored (FCAW) welding, commonly referred to as “wire welding,” offer the potential for significant gains in productivity compared to stick welding. If a dial-type regulator/flow meter is used, a leak can be detected by applying a soap and water solution to all hoses and connections. Also, if the nozzle is too large in diameter or the contact tip extends too far from the end of the nozzle or if the contact tip-to-work distance is too great, shielding gas coverage will be impacted. You should begin troubleshooting the system by ensuring the wire is not obstructed anywhere along its path from the spool tension to the contact tip and everywhere in-between. After the cell has been welding for a while, check all connection points and welding cables for heat. Over-tightened drive roll tension causes all of these problems in addition to placing excessive pressure on the drive shaft that could wear out a gear box or drive motor by misaligning it. These components should be checked several times throughout the day, even if a shielding gas problem isn’t suspected. Too tight and you can crush the wire and flake off the coating, deform the wire, wear out the rolls, and damage the motor. No paint, rust or washers of any type should be between the copper lugs and the connection surfaces. Flow rates lower than this can provide inadequate shielding, resulting in porosity. This problem is mostly caused by using too small of a gun for the amperage being used to weld and from the constant flexing of the gun during use. Wire manufacturers have already properly prepared the surface of the wire for maximum feedability and adding or even subtracting that can affect the weld quality. Deformed wire will wear grooves into the contact tip limiting electrical conductivity and also causing poor feedability. Drive roll tension should be adjusted so that it is not too tight, but not too loose. The smallest pinhole in a gas hose can act like a carburetor and draw in air, contaminating the weld. If either the connections or cables feel hot, it is a likely indication that there is too much electrical resistance in the circuit. The inside diameter of the welding gun nozzle can also have an impact on shielding gas delivery. Check Gun Condition Check the O-rings found on the end of the welding gun where it attaches to the wire feeder guide. Accurately troubleshooting these problems when they arise or, better yet, avoiding them before they arise, is crucial to maximizing the benefits that these processes offer. Resistance is the “unknown” welding variable and the largest cause of inconsistencies in any welding system. The MIG gun is constantly bent and twisted during normal use. Wear out the grooved surfaces of the rolls and you have poor friction to feed the wire properly. Hub Tension It is important not to over-tighten the hub tension, which allows the spool of wire to turn. Check the gas ports found in the diffuser, and on some consumables brands, in the nozzle. Remember, gas connections and hoses downstream from the gas valve have to be checked with the gas flowing. A cable that is too small for the application will likely be hot along its entire length, where as a break in the cable will result in a specific point along the cable becoming hot. All electrical connections for the welding cables and work cables need to be checked. If you insist on using something to “lubricate” or “wipe off” the wire before it goes into the system, a cotton cloth with a clothes pin would be best so that there is no contamination of the wire and dust cannot collect on a ‘wet” surface. GAS SUPPLY In MIG and gas-shielded flux-cored arc welding, a number of problems can occur that interfere with the delivery of shielding gas to the weld pool, leading to porosity, excess spatter, an unstable arc and other defects. Over-tightening this will force the drive motor to work harder just to get the wire off of the spool and will lead to welding problems. These holes can also become clogged with spatter and restrict shielding gas flow to the weld pool. When the wire is actually stopped, the drive rolls should spin on the wire and no bird nesting should occur. If the nozzle diameter is too small and gas flow is set too high, a venturi-type of effect can occur, drawing in the atmosphere and contaminating the gas supply. However, the wire feed system uses a more complicated mechanical system than the others to deliver the welding wire to the weld pool and the current to the wire, resulting in more potential problems in the functioning of the welding equipment. The hub tension is simply a means to keep the wire from de-coiling off of the spool when wire feeding stops. Check Drive Roll Alignment The drive rolls can be adjusted side-to-side to ensure they are in line with the inlet guide to the GMAW gun. If this occurs, replace the tip with a new one and ensure that it is tightly fastened to the diffuser. Check Liner Condition The gun liner should be the proper size for the wire being used and should also be clean and free of dust and debris. Flaked coating will cause these small flakes to enter the liner, further limiting the simple feedability of the wire to the puddle. Check Drive Roll Pressure Drive roll pressure is a very common problem in wire welding. The weld current needs to pass through this connection and into the wire, so it must be held tightly to the diffuser and it must make good contact with the welding wire. There is no cut-and-dry answer as to the exact pressure needed to ensure proper drive roll pressure. Escaping gas will cause bubbles to form in the soap and water solution at the point of the leak. For troubleshooting purposes, the wire welding system can be divided into three distinct categories based on function – wire delivery, gas supply and electricity transmission. They should not have grooves in them – often caused by misalignment or improper size. Flow rates higher that this can cause problems where the surrounding atmosphere can be drawn into the shielding gas, providing a contaminated shielding gas supply, also resulting in porosity. The contact tip can get clogged up from spatter or from touching it to the weld puddle. A good indication of a poor electrical connection is heat. Use the purge function during this process. The best way to avoid these problems, or troubleshoot them when they occur, is to verify that all of the electrical connections between the welding components are tight and secure. WIRE DELIVERY Regardless if you are using one-pound spools, large drums, or larger coils of wire, the mechanical feedability of the wire plays an important role in determining arc quality and weldability. If the wire is wearing grooves into the contact tip you need to check your drive roll tension. Liners are wear items and should be replaced on a regular schedule. Here are several steps that should be taken to troubleshoot suspected shielding gas problems: Check the Regulator/Flow Meter The glass tube-and-ball type of flow gauge can be used as an indicator of gas leaks. This hose can also fail from overuse and holes can be created inside of the cable, through which gas can escape and you would never see it. This should be just tight enough to keep the wire from de-coiling when you stop feeding a full spool at maximum wire feed speed. Start with the drive roll pressure very loose. If one or both O-rings are missing, cracked, gouged or worn, shielding gas can leak out or the atmosphere can be drawn in, with both instances resulting in reduced welding performance. On a large drum of wire, this function may be served by a mechanism that traces around the spool. Check Gas Flow More is not necessarily better here. Check to ensure that all weld cable-to-lug crimps are tight. This, combined with heat from the welding application, breaks down the copper in the gun over time. Over-tensioned wire will flake off and place excessive particles into the liner, clogging it up. The contact tip is another common source of interruptions in the electrical current. Although, it would take an entire book to list all of the problems that could potentially arise in wire welding and their possible causes, following the guidelines above should put you well on your way to renewed welding success. ELECTRICITY TRANSMISSION Without good electrical flow between the power source, wire feeder, lead cable and work cable, you could experience a variety of problems, including a sputtering arc, excessive spatter and reduced equipment longevity. Too loose and you have no wire feeding into the puddle. This could be caused by loose or faulty connections, cables that are too small for the application or an internal break in a cable. An indication of a loose connection is a discolored contact tip where it makes its connection to the diffuser. Using special wire lubricants can also cause the wire to become ‘wet’ and dust can collect on the wire dragging it into the liner as well. All connections need to be clean and tight. Inside the gun cable is a hose that contains both the liner and the shielding gas. Go perhaps one-half of a turn beyond this point. If the ball does not drop to the bottom of the gauge when not welding, it is an indicator that gas is still flowing, indicating a leak. Check Inlet Guides The inlet guides should be of the proper size for the wire used. Gas flow rates will typically be between 30 and 50 CFH (cubic feet per hour). Use a pliers or block of wood to try and stop the wire from feeding. Increase the pressure only until it is very difficult to stop the wire from feeding out of the contact tip. Contact Tip Condition Many times feeding problems can be fixed by replacing the contact tip. Also, turning off the cylinder and watching the high pressure side slowly fall will also indicate that there is a leak in the system. Failure within any of these systems will result in sub-optimal welding performance, including reduced productivity and increased downtime for reworking bad welds. If you find yourself turning up your machine from the day when everything was new and correct to achieve the same result, you likely have a resistance issue.

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