

Telwin 64243

Telwin Cylindrical Nozzle for Bimax 105 and Telmig 130 Welding Machines User Manual

1. INTRODUCTION

This manual provides essential instructions for the proper installation, use, and maintenance of the Telwin Cylindrical Nozzle. This accessory is specifically designed for compatibility with Telwin Bimax 105 and Telmig 130 welding machines, ensuring optimal performance and safety during welding operations.

2. PRODUCT OVERVIEW

The Telwin Cylindrical Nozzle is a critical component in MIG/MAG welding processes. Its primary function is to direct the shielding gas precisely to the weld pool, protecting it from atmospheric contamination and ensuring a clean, strong weld. This nozzle is identified by article number 722054.



Figure 1: A close-up view of the Telwin cylindrical nozzle, showing its metallic construction and cylindrical shape, designed to fit compatible welding torches.

3. SETUP AND INSTALLATION

1. **Safety First:** Always ensure the welding machine is powered off and disconnected from the main power supply before attempting any installation or maintenance.
2. **Preparation:** Inspect the torch head and the new cylindrical nozzle for any damage or debris. Ensure both surfaces are clean.
3. **Attachment:** Carefully align the cylindrical nozzle with the torch head. Gently push and twist the nozzle until it is securely seated. Avoid excessive force to prevent damage to the nozzle or torch.
4. **Verification:** Once installed, ensure the nozzle is firmly attached and does not wobble.

4. OPERATING CONSIDERATIONS

While the nozzle itself does not have operational controls, its proper function is integral to the welding process. Ensure the nozzle is clean and free from spatter before each welding session. A clear and unobstructed gas flow through the nozzle is crucial for effective shielding and high-quality welds. Monitor the nozzle for any signs of wear or damage during operation.

5. MAINTENANCE

- **Regular Cleaning:** After each welding session, or as needed, inspect the nozzle for spatter buildup. Use a wire brush or a specialized nozzle reamer to carefully remove any accumulated spatter from both the inside and outside surfaces of the nozzle.
- **Inspection:** Periodically check the nozzle for signs of wear, cracks, deformation, or excessive heat damage.
- **Replacement:** A damaged or heavily worn nozzle can compromise gas flow and weld quality. Replace the nozzle immediately if it shows significant signs of damage or wear.

6. TROUBLESHOOTING

- **Poor Weld Quality / Porosity:** If you experience poor weld quality, excessive porosity, or inconsistent gas shielding, first check the nozzle. Ensure it is clean, free of spatter, and securely attached. Blockages or damage to the nozzle can severely impact gas flow.
- **Nozzle Overheating:** Ensure proper gas flow settings and check for any obstructions that might restrict cooling. Excessive spatter buildup can also contribute to overheating.

7. SPECIFICATIONS

Manufacturer	TELWIN
Model Reference	64243
Item Weight	8 kilograms (17.64 pounds)
Quantity	1
Batteries Included	No
Batteries Required	No
ASIN	B00B3W11CA
Date First Available	January 21, 2013
Discontinued by Manufacturer	No

8. WARRANTY AND SUPPORT

Specific warranty information for this Telwin Cylindrical Nozzle is not provided within this manual. For details regarding warranty coverage, technical support, or spare parts availability, please refer to the official Telwin website or contact your authorized Telwin dealer. Please have the model reference (64243)

and article number (722054) available when seeking support.