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> USWELDWIRE Titanium Mig Gun Parts AK15 Instruction Manual for Mig Kit .035

USWELDWIRE WMKTITANIUM

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Brand: USWELDWIRE | Model: WMKTITANIUM

INTRODUCTION

This instruction manual provides essential information for the proper installation, operation, and maintenance of your USWELDWIRE Titanium Mig Gun Parts AK15 Mig Kit .035. These parts are designed for use with Titanium Mig 140, 170, Unlimited 200, 64804, 64805, and 64806 welding machines. Adhering to these guidelines will help ensure optimal performance and longevity of your welding consumables.

PRODUCT OVERVIEW

The USWELDWIRE Mig Kit .035 includes essential consumable components for your MIG welding gun. These parts are crucial for directing welding wire and shielding gas to the weld puddle.



Image: Components of the USWELDWIRE Mig Kit .035. This kit typically includes gas nozzles, contact tips, and tip holders (also known as diffusers), all designed for .035 inch welding wire.

The kit generally contains:

- **Gas Nozzles:** These direct the shielding gas to protect the weld puddle from atmospheric contamination.
- **Contact Tips:** Made of copper, these conduct the welding current to the wire. The .035 inch size corresponds to the wire diameter.
- **Tip Holders (Diffusers):** These secure the contact tip and help distribute the shielding gas evenly.

SETUP AND INSTALLATION

Proper installation of these consumables is critical for effective welding. Always ensure your welding machine is powered off and disconnected from the power source before performing any maintenance or part replacement.

1. **Remove Old Consumables:** Carefully unscrew the existing gas nozzle, then the tip holder, and finally the contact tip from the MIG gun. Dispose of worn parts responsibly.
2. **Install New Contact Tip:** Thread the new .035 inch contact tip onto the MIG gun's conductor tube. Hand-tighten only; over-tightening can damage the threads.
3. **Install New Tip Holder:** Slide the new tip holder over the contact tip and thread it onto the MIG gun. Ensure it is seated firmly.
4. **Install New Gas Nozzle:** Place the new gas nozzle over the tip holder and secure it. Some nozzles twist on, while others may snap into place. Ensure a snug fit to prevent gas leaks.
5. **Verify Wire Size:** Confirm that the installed contact tip matches the diameter of the welding wire being used (.035 inch in this case). Using an incorrect tip size can lead to poor wire feeding and arc instability.

For specific instructions related to your particular MIG gun model, refer to your welding machine's user manual.

OPERATING INSTRUCTIONS

Once the consumables are correctly installed, you can proceed with welding operations. These parts are designed to facilitate the MIG welding process.

- **Shielding Gas Flow:** Ensure the shielding gas flow rate is set correctly according to your welding machine's recommendations and the type of material being welded. An adequate gas flow is essential for protecting the weld.
- **Contact Tip Recess:** The contact tip should typically be recessed slightly within the gas nozzle for optimal gas coverage and to prevent arc starting issues. Adjust as needed for specific applications.
- **Wire Feed Speed and Voltage:** Set your welding machine's wire feed speed and voltage according to the welding wire type, material thickness, and joint configuration.
- **Cleanliness:** Keep the gas nozzle free of spatter to maintain consistent gas flow and prevent short circuits.

MAINTENANCE

Regular maintenance of your MIG gun consumables will extend their lifespan and ensure consistent weld quality.

- **Clean Gas Nozzle:** Frequently remove spatter from the inside and outside of the gas nozzle using a reamer or pliers designed for MIG guns. Excessive spatter can impede gas flow and cause poor welds.
- **Inspect Contact Tip:** Check the contact tip for wear, such as an enlarged bore or signs of arcing. A worn tip can lead to erratic wire feeding and poor electrical contact. Replace as necessary.
- **Inspect Tip Holder:** Ensure the tip holder is clean and free of spatter. Check for any damage that might affect gas distribution.
- **Replacement Schedule:** Consumables are designed to be replaced periodically. The frequency depends on usage, welding parameters, and material. Replace parts when they show significant wear or when weld quality deteriorates.

TROUBLESHOOTING

If you encounter issues during welding, check the following common problems related to consumables:

Problem	Possible Cause (Consumable Related)	Solution
Poor Arc Stability / Erratic Arc	Worn or incorrect contact tip size. Loose contact tip.	Replace contact tip. Ensure contact tip is securely tightened. Verify tip size matches wire.
Excessive Spatter	Gas nozzle clogged with spatter. Incorrect contact tip recess.	Clean gas nozzle. Adjust contact tip recess.
Porosity in Weld	Insufficient shielding gas coverage due to clogged or damaged gas nozzle/tip holder. Gas leaks.	Clean or replace gas nozzle/tip holder. Check for gas leaks around connections.
Wire Feeding Issues (Sticking/Jamming)	Worn contact tip bore. Incorrect contact tip size.	Replace contact tip. Ensure tip size matches wire diameter.

SPECIFICATIONS

- **Model:** WMKTITANIUM
- **Size:** Mig Kit .035

- **Material:** Titanium (referring to compatibility with Titanium welders, actual parts are typically copper/brass/steel)
- **Compatibility:** Titanium Mig 140, 170, Unlimited 200, 64804, 64805, 64806 MIG Guns
- **Manufacturer:** XLIANE (as listed in product specifications)
- **Item Weight:** Approximately 5 ounces (for the kit)
- **Package Dimensions:** Approximately 4.13 x 2.24 x 0.71 inches

WARRANTY AND SUPPORT

As welding consumables, these parts are subject to wear during normal use. Specific warranty information for these consumable parts may vary. For detailed warranty terms or technical support, please contact USWELDWIRE directly or refer to the documentation provided with your original purchase.

You can often find contact information on the manufacturer's official website or through your retailer.