

AZZUNO WP-17V

AZZUNO WP-17V Air-Cooled TIG Welding Torch Instruction Manual

Model: WP-17V

INTRODUCTION

This manual provides essential information for the safe and effective use of your AZZUNO WP-17V Air-Cooled TIG Welding Torch. Please read these instructions carefully before operation to ensure proper setup, usage, and maintenance. Retain this manual for future reference.

PACKAGE CONTENTS

Verify that all items listed below are included in your package:

- TIG Torch (WP-17V) with 13-ft cable and gas hose
- Ceramic Cups x3
- Collet x2
- Collet Body x1
- Long Back Cap x1
- Short Back Cap x1

WP-17V ACCESSORIES



CERAMIC CUP #4



CERAMIC CUP #5



CERAMIC CUP #6



COLLET BODY



COLLET
.063"/1.6mm



COLLET
.078"/2.0mm

SHORT
BACK CAP



LONG
BACK CAP



Image: Components included with the WP-17V TIG torch, showing ceramic cups (#4, #5, #6), collets (.063"/1.6mm, .078"/2.0mm), collet body, and both short and long back caps.

LIFT TIG TORCH WP-17V(10-25mm²)

Compatible For

MIG-135F/MMA-160F/MMA-145F



Image: Detailed dimensions for the ceramic cups, collets, collet body, and back caps, indicating their sizes in inches and millimeters.

PRODUCT FEATURES

- **Air-Cooled Design:** The WP-17V torch is air-cooled for efficient heat dissipation during operation.
- **Extended Cable Length:** Equipped with a 13-ft (4m) cable and gas hose for increased reach and flexibility.
- **Quick Connector:** Features a 10-25mm² quick connector for easy and secure attachment to compatible welding machines.
- **Ergonomic Handle:** The non-slip rhombus-patterned handle provides a comfortable and secure grip, reducing user fatigue during prolonged welding tasks.
- **Wide Compatibility:** Designed for use with AZZUNO MIG-135F, MMA-160F, MMA-145F, and other compatible welding machines.

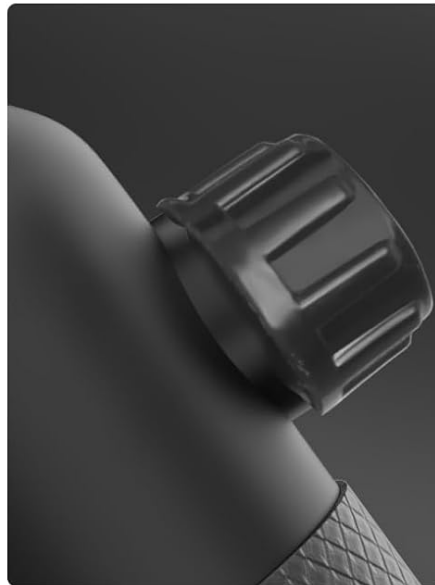


Image: Detailed views highlighting the ergonomic non-slip handle, the gas valve for precise control, and the secure gas hose connection point of the WP-17V TIG torch.

SETUP INSTRUCTIONS

1. Prepare the Torch Head:

- Select the appropriate collet and collet body for your tungsten electrode size.
- Insert the collet into the collet body, then screw the assembly into the torch head.
- Insert the tungsten electrode through the collet and collet body.
- Thread the ceramic cup onto the torch head.
- Attach either the long or short back cap, ensuring it is tightened to secure the tungsten electrode.

2. Connect to Welding Machine:

- Locate the 10-25mm² quick connector on your welding machine.
- Insert the quick connector from the TIG torch cable into the corresponding port on the welding machine and

twist to secure.

- Connect the gas hose connector to the gas outlet on your welding machine or gas regulator. Ensure all connections are tight to prevent gas leaks.

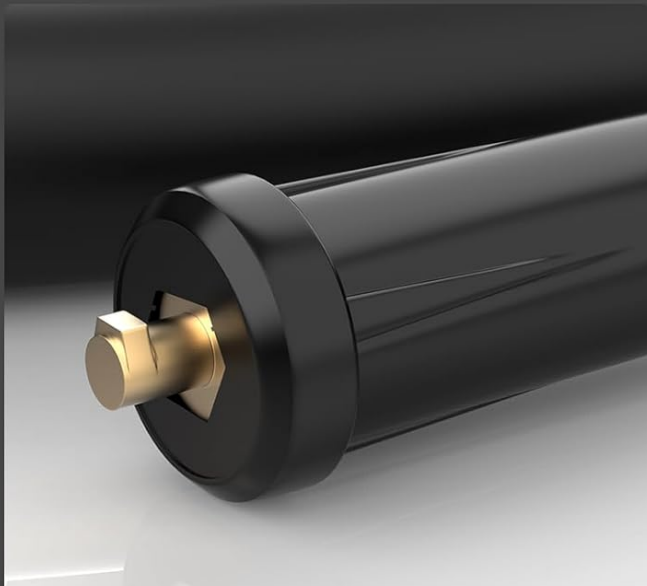
3. **Gas Supply:** Connect your shielding gas cylinder (e.g., Argon) to the gas regulator, and then connect the regulator to the torch's gas hose. Set the gas flow rate according to your welding requirements.

4. **Power Supply:** Ensure your welding machine is properly connected to a suitable power supply as per its own instruction manual.

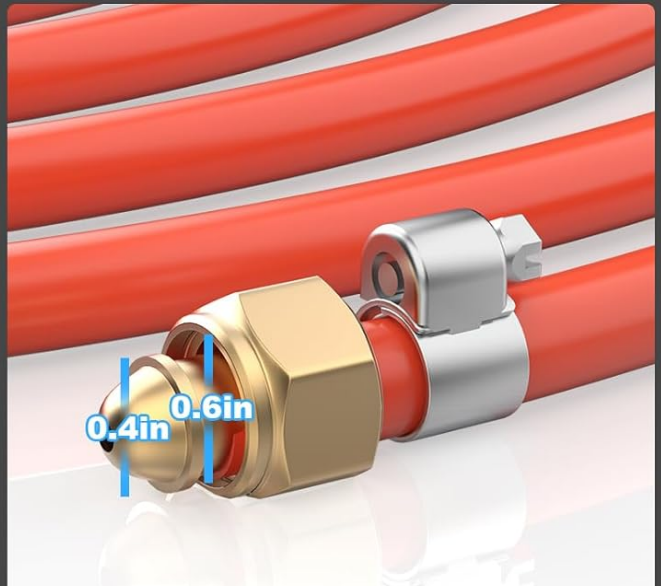


Image: The complete AZZUNO WP-17V TIG torch assembly, showing the torch head, cable, and quick connectors for power and gas.

CABLE LENGTH: 13ft/4m



Quick Connector: 10-25mm²



Gas Hose Connector

Image: A close-up illustrating the 13-foot cable length, the 10-25mm² quick connector for electrical connection, and the gas hose connector for shielding gas supply.

OPERATING INSTRUCTIONS

Safety Precautions:

- Always wear appropriate personal protective equipment (PPE), including a welding helmet with proper shade, welding gloves, and protective clothing.
- Ensure adequate ventilation in the welding area to disperse fumes.
- Never touch live electrical parts.
- Keep a fire extinguisher nearby.

Welding Process:

1. **Power On:** Turn on your welding machine and set the desired welding parameters (amperage, gas pre-flow/post-flow, etc.) according to the material and thickness being welded.

2. **Gas Flow:** Ensure the shielding gas is flowing at the correct rate.
3. **Arc Initiation:** For Lift TIG, touch the tungsten electrode to the workpiece and then lift it slightly to initiate the arc. The torch features a gas valve for manual gas control if your welder does not provide automatic gas flow.
4. **Welding:** Maintain a consistent arc length and travel speed. Feed filler rod into the weld puddle as needed.
5. **Arc Termination:** Slowly withdraw the torch to extinguish the arc. Allow the shielding gas to flow for the set post-flow time to protect the cooling weld puddle and tungsten.



Image: The AZZUNO WP-17V TIG torch connected to various AZZUNO welding machines (MIG-135F, MMA-160F, MMA-145F), demonstrating its compatibility.

MAINTENANCE

- **Tungsten Electrode:** Sharpen or replace the tungsten electrode as needed to maintain a sharp point for optimal arc stability.
- **Ceramic Cups:** Inspect ceramic cups for cracks or damage. Replace if necessary to ensure proper gas shielding.
- **Collets and Collet Bodies:** Check for wear or deformation. Replace if they no longer securely hold the tungsten electrode.
- **Cable and Hose:** Regularly inspect the cable and gas hose for cuts, abrasions, or leaks. Repair or replace damaged components immediately to prevent safety hazards and performance issues.
- **Cleaning:** Keep the torch head and handle clean from spatter and debris. Use a soft cloth to wipe down surfaces.

TROUBLESHOOTING

Problem	Possible Cause	Solution
Unstable Arc / Poor Weld Quality	<ul style="list-style-type: none">• Contaminated or improperly ground tungsten electrode.• Insufficient or incorrect shielding gas flow.• Incorrect amperage settings.	<ul style="list-style-type: none">• Regrind or replace tungsten.• Check gas connections, regulator, and flow rate.• Adjust amperage according to material.

Problem	Possible Cause	Solution
No Gas Flow	<ul style="list-style-type: none">Gas cylinder empty or valve closed.Gas hose kinked or disconnected.Faulty gas regulator.	<ul style="list-style-type: none">Check cylinder level and open valve.Inspect hose for obstructions or damage.Test or replace regulator.
Torch Overheating	<ul style="list-style-type: none">Exceeding duty cycle of the torch.Poor air circulation around the torch.	<ul style="list-style-type: none">Allow torch to cool down.Ensure proper ventilation.

SPECIFICATIONS

Feature	Detail
Model	WP-17V
Cooling Method	Air-Cooled
Cable Length	13 ft (4 meters)
Quick Connector Size	10-25mm ²
Item Weight	2.79 pounds
Package Dimensions	11.46 x 9.25 x 2.91 inches
Included Components	TIG Torch, 3 Ceramic Cups, 2 Collets, 1 Collet Body, 1 Long Back Cap, 1 Short Back Cap

CUSTOMER SERVICE AND SUPPORT

AZZUNO provides dedicated customer service. For any questions regarding our products, assistance with your purchase, or post-sale support, please contact our customer service team. We are available to assist you.

For further information or to contact support, please visit the official AZZUNO website or refer to the contact details provided with your purchase documentation.

