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› AZZUNO LIFT TIG Welding Torch WP-17V User Manual

AZZUNO WP-17V(10-25)-2

AZZUNO LIFT TIG Welding Torch WP-17V User Manual

Model: WP-17V(10-25)-2

1. INTRODUCTION

Thank you for choosing the AZZUNO LIFT TIG Welding Torch WP-17V. This air-cooled TIG gun is designed for reliable performance and ease of use, featuring a 10-25mm² quick connector and a 13-ft cable and gas hose. This manual provides essential information for the safe and effective operation, maintenance, and troubleshooting of your new welding torch. Please read this manual thoroughly before use and retain it for future reference.

2. PRODUCT OVERVIEW

The AZZUNO WP-17V TIG welding torch is an air-cooled unit engineered for precision welding tasks. Its ergonomic design ensures comfortable handling during extended use, and its robust construction provides durability. The torch is equipped with a standard 10-25mm² quick connector for easy integration with compatible welding machines.

Key Features:

- **Air-Cooled Design:** Efficiently dissipates heat during operation.
- **Extended Cable Length:** 13-ft (approximately 4 meters) cable and gas hose for increased reach.
- **Quick Connector:** Features a 10-25mm² quick connector for rapid setup.
- **Ergonomic Handle:** Non-slip rhombus-patterned handle designed for comfortable grip and reduced fatigue.
- **Wide Compatibility:** Compatible with AZZUNO MIG-135PRO, MIG-135F, MIG-155F, and similar welding machines.

Package Contents:

- WP-17V TIG Torch (1 unit)
- Ceramic Cups (3 units)
- Collets (3 units)
- Collet Body (1 unit)
- Long Back Cap (1 unit)
- Short Back Cap (1 unit)



Figure 2.1: The AZZUNO WP-17V TIG Welding Torch with its 13-ft cable and included accessories.

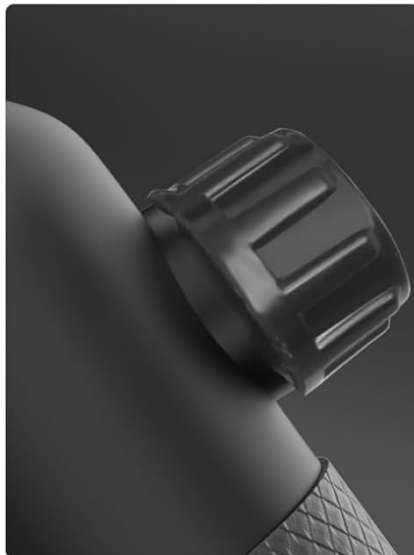


Figure 2.2: Detailed view of the WP-17V torch components, highlighting the ceramic cup, ergonomic handle, and gas flow adjustment knob.

3. SETUP

Proper setup is crucial for safe and effective welding. Ensure your welding machine is turned off and disconnected from the power source before proceeding with any connections.

Connecting the Torch:

1. Locate the 10-25mm² quick connector on the end of the TIG torch cable.
2. Insert the quick connector into the corresponding receptacle on your compatible AZZUNO welding machine (e.g., MIG-135PRO, MIG-135F, MIG-155F). Ensure it is fully seated and securely twisted to lock it in place.
3. Connect the gas hose from the torch to your inert gas supply (e.g., Argon) via a suitable regulator. Ensure all gas connections are tight to prevent leaks.
4. Install the appropriate collet, collet body, and ceramic cup onto the torch head according to your welding requirements. Refer to Section 5 for details on accessories.

WP-17V ACCESSORIES

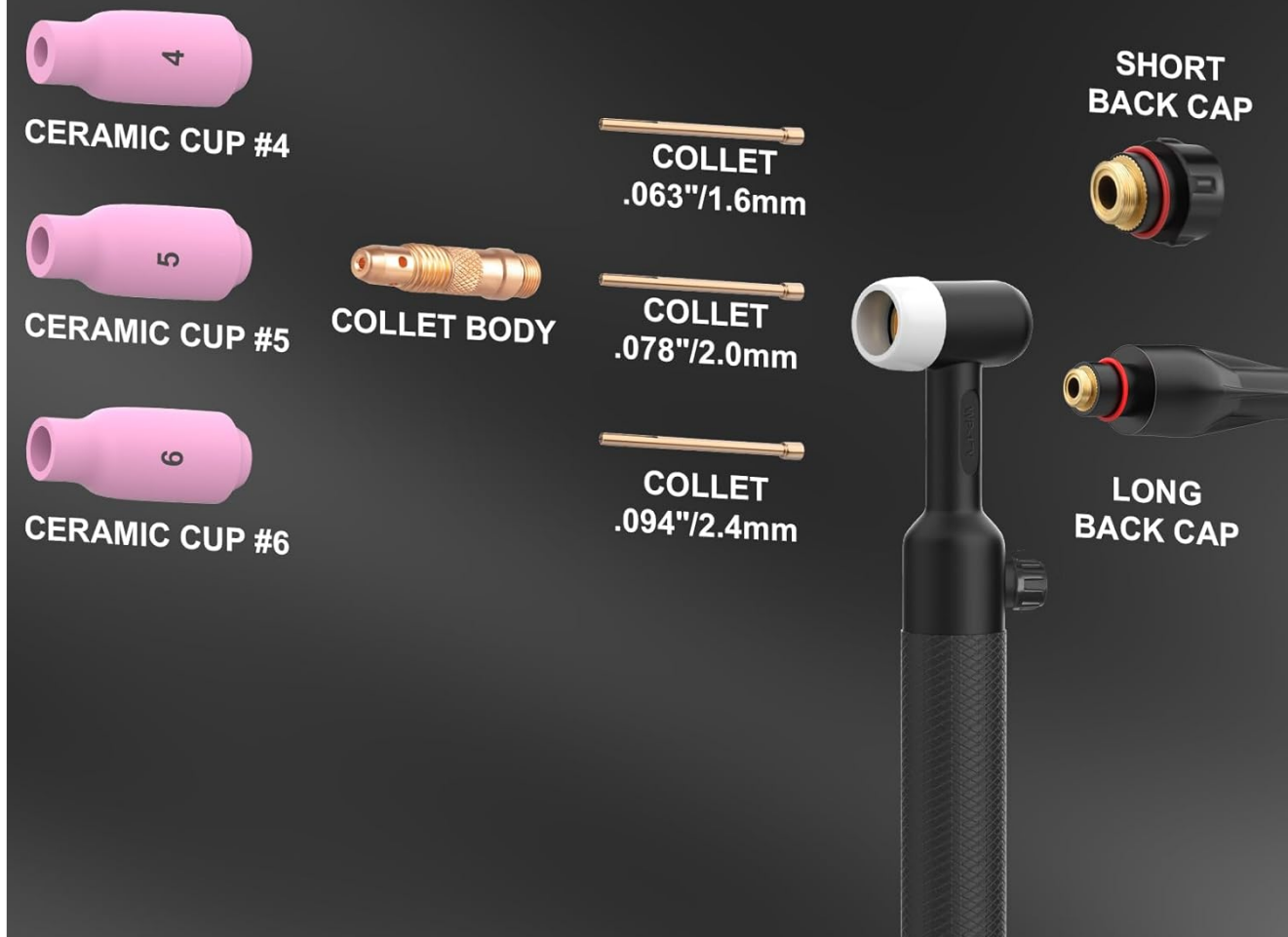


Figure 3.1: Illustration of the 13-ft cable, 10-25mm² quick connector, and gas hose connector for proper setup.

4. OPERATING

The WP-17V TIG torch is designed for LIFT TIG welding processes. Always wear appropriate personal protective equipment (PPE), including welding helmet, gloves, and protective clothing, before operating any welding equipment.

Basic Operation:

1. Ensure the torch is correctly connected to your welding machine and gas supply as described in Section 3.
2. Set your welding machine to the LIFT TIG mode and adjust welding parameters (current, gas flow) according to the material thickness and type.
3. Initiate the arc by gently touching the tungsten electrode to the workpiece and then lifting it slightly. The arc will ignite, and you can begin welding.
4. Maintain a consistent arc length and travel speed for optimal weld quality.
5. After welding, allow the post-flow gas to protect the weld puddle and tungsten electrode as it cools.

Compatibility:

The AZZUNO WP-17V TIG torch (with 10-25mm² connector) is specifically designed for compatibility with AZZUNO MIG-135PRO, MIG-135F, and MIG-155F welding machines. It may also be compatible with other welding machines that utilize a 10-25mm² quick connector for TIG torch input. Always verify the connector type and machine specifications before attempting to connect the torch to non-AZZUNO equipment.



Figure 4.1: The WP-17V TIG torch demonstrating compatibility with AZZUNO MIG-135F, MIG-135PRO, and MIG-155F welding machines.

5. MAINTENANCE

Regular maintenance ensures the longevity and optimal performance of your TIG welding torch. Always disconnect the torch from the welding machine and gas supply before performing any maintenance.

Cleaning:

- Periodically clean the ceramic cup and collet body to remove spatter and debris.
- Inspect the gas passages for any blockages and clear them if necessary.

- Wipe down the torch handle and cable with a clean, dry cloth. Avoid using harsh chemicals that could damage the materials.

Replacing Consumables:

The ceramic cups, collets, and collet bodies are consumable parts that will wear out over time and require replacement. Always use genuine AZZUNO replacement parts for best performance.

- **Ceramic Cups:** Replace if cracked, chipped, or if the opening becomes deformed, affecting gas shielding. The package includes Ceramic Cups #4, #5, and #6.
- **Collets:** Replace if they no longer securely hold the tungsten electrode or show signs of wear. The package includes collets for .063"/1.6mm, .078"/2.0mm, and .094"/2.4mm tungsten electrodes.
- **Collet Body:** Replace if damaged or if gas flow is impeded.
- **Back Caps:** Ensure the long and short back caps are in good condition to protect the tungsten electrode and maintain gas seal.



Figure 5.1: Overview of WP-17V accessories, including ceramic cups, collets, collet body, and back caps.

SIZE OF ACCESSORIES



Figure 5.2: Dimensional specifications for the WP-17V accessories, aiding in proper selection and replacement.

6. TROUBLESHOOTING

This section provides solutions to common issues you might encounter with your AZZUNO WP-17V TIG torch. For problems not listed here, please contact customer service.

Problem	Possible Cause	Solution
No Arc Ignition	Loose connections; Incorrect machine settings; Contaminated tungsten; No gas flow.	Check all cable and gas connections. Verify welding machine is set to LIFT TIG mode and correct current. Clean or replace tungsten electrode. Ensure gas supply is open and flowing.
Poor Weld Quality / Porosity	Insufficient gas shielding; Gas leaks; Contaminated workpiece; Incorrect gas flow rate.	Check ceramic cup for damage. Inspect gas hose and connections for leaks. Ensure proper gas flow rate. Clean workpiece thoroughly before welding.

Problem	Possible Cause	Solution
Overheating Torch	Exceeding duty cycle; Insufficient air cooling; Damaged cable.	Allow torch to cool down. Ensure adequate ventilation around the torch and cable. Inspect cable for damage and replace if necessary.
Gas Flow Issues	Blocked gas passages; Faulty regulator; Empty gas cylinder.	Clean gas passages in torch head and collet body. Check gas regulator for proper function. Verify gas cylinder has sufficient gas.

7. SPECIFICATIONS

The following table outlines the key specifications for the AZZUNO WP-17V TIG Welding Torch:

Attribute	Value
Model Number	WP-17V(10-25)-2
Torch Type	Air-Cooled LIFT TIG Torch
Cable & Gas Hose Length	13 feet (approx. 4 meters)
Quick Connector Size	10-25mm ²
Item Weight	2 pounds (approx. 0.91 kg)
Package Dimensions	10.6 x 7.5 x 2.8 inches (approx. 26.9 x 19.1 x 7.1 cm)
Manufacturer	AZZUNO
Date First Available	January 16, 2025

8. WARRANTY AND SUPPORT

AZZUNO is committed to providing high-quality products and excellent customer service. If you have any questions about your WP-17V TIG welding torch, require assistance with your purchase, or need support after the sale, our customer service team is available to assist you.

For support, please refer to the contact information provided with your product packaging or visit the official AZZUNO store on Amazon:

[Visit the AZZUNO Store on Amazon](#)