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GZ GUOZHI AK15-0.8

GZ GUOZHI Welding Tip and Nozzle Set Instruction Manual

Model: AK15-0.8

1. Product Overview

This GZ GUOZHI welding tip and nozzle set is designed for semi-automatic MIG welding machines. It provides essential consumable components for maintaining optimal welding performance. The components are manufactured from high-quality red copper, ensuring durability, high temperature resistance, and corrosion resistance for a long service life.

1.1 Package Contents

- 2 x Welding Nozzles
- 2 x Tip Holders
- 20 x 0.8mm Welding Tips



Image 1.1: The complete set includes 2 welding nozzles, 2 tip holders, and 20 welding tips.

1.2 Compatible Models

This set is compatible with the following GZ GUOZHI semi-automatic MIG welding machines:

- MIG-125T
- MIG-145LCD-JP
- MIG-135LCD
- MIG-205-JP

It is also compatible with other semi-automatic welding machines that utilize similar MIG function components.



Image 1.2: Visual representation of compatible MIG welding machine models.

2. Components Description

2.1 Welding Nozzle

The welding nozzle directs the shielding gas to protect the weld pool from atmospheric contamination. It is made of durable material to withstand high temperatures and spatter.



Image 2.1: Welding Nozzle (Length: 54.8mm).

2.2 Tip Holder

The tip holder secures the welding tip in place and provides electrical contact for the welding current. It is designed for efficient

heat dissipation and stable wire feeding.



Image 2.2: Tip Holder (Length: 34.2mm).

2.3 Welding Tip (0.8mm)

The welding tip guides the welding wire and transfers the electrical current to the wire. The 0.8mm size is suitable for 0.8mm welding wire. These tips are made from red copper for excellent conductivity and wear resistance.

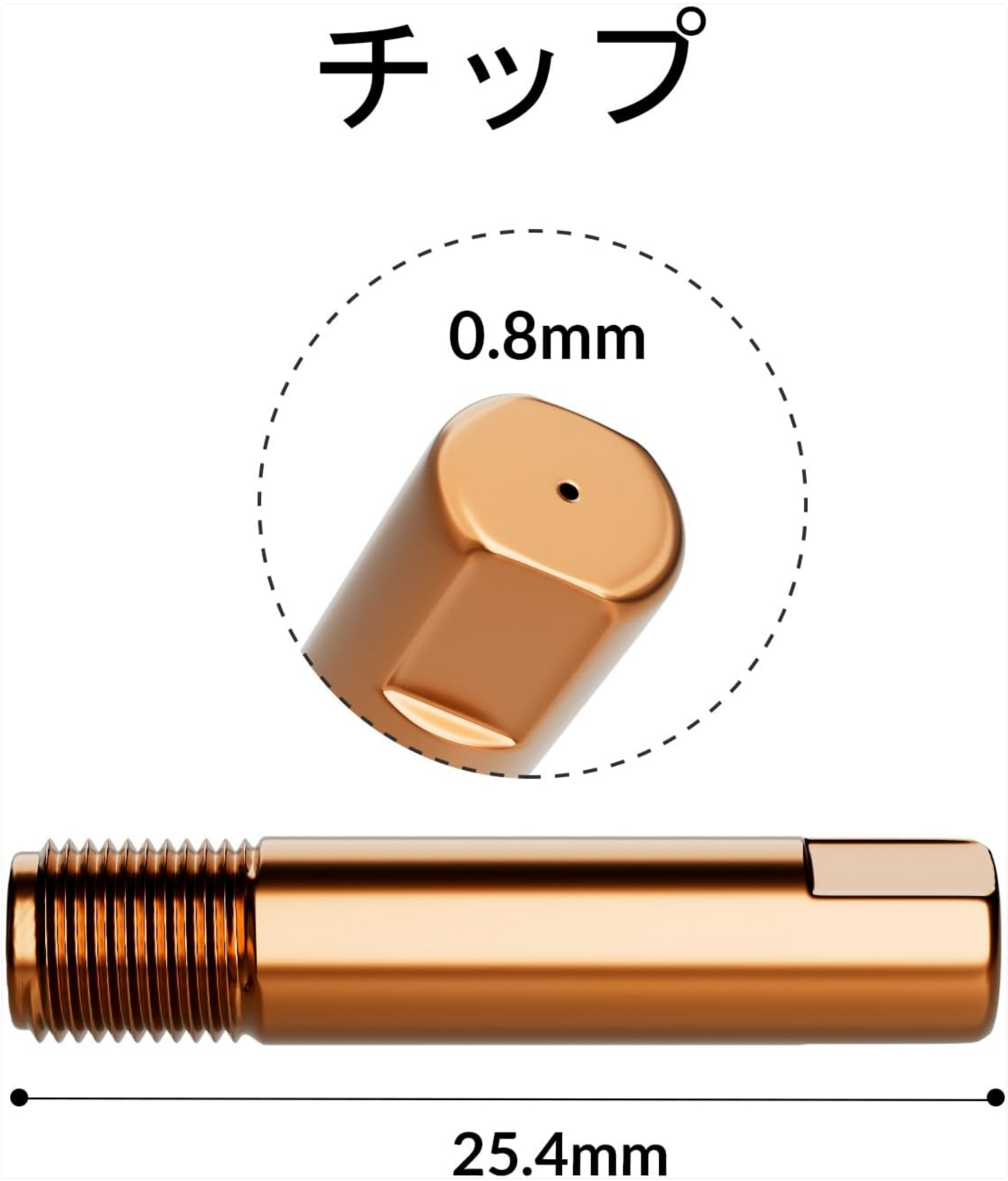


Image 2.3: 0.8mm Welding Tip (Length: 25.4mm).

3. Setup and Installation

Proper installation of the welding tip, tip holder, and nozzle is crucial for safe and effective welding. Always ensure the welding machine is powered off and disconnected from the power source before performing any installation or maintenance.

1. **Prepare the Welding Torch:** Ensure the welding torch is clean and free from spatter or debris.
2. **Install the Tip Holder:** Screw the tip holder securely onto the torch body. Do not overtighten.
3. **Insert the Welding Tip:** Insert the 0.8mm welding tip into the tip holder. Ensure it is seated correctly.

4. **Attach the Welding Nozzle:** Slide the welding nozzle over the tip holder and secure it. Some nozzles may screw on, while others may simply push and lock into place. Ensure it is firmly attached to prevent gas leaks.



Image 3.1: Assembly sequence of the welding nozzle, tip, and tip holder onto a MIG torch.

4. Operating Considerations

While these are consumable parts, their correct use impacts welding quality and safety.

- **Matching Wire Size:** Always use the 0.8mm welding tips with 0.8mm welding wire to ensure proper electrical contact and smooth wire feeding. Using an incorrect tip size can lead to poor arc stability, wire feeding issues, and premature tip wear.
- **Contact Tip Extension:** Adjust the contact tip extension (the distance the tip protrudes from the nozzle) according to your welding application and material thickness.
- **Shielding Gas Flow:** Ensure adequate shielding gas flow to protect the weld pool. A properly installed nozzle is essential for effective gas delivery.

5. Maintenance

Regular maintenance of your welding consumables extends their lifespan and ensures consistent weld quality.

- **Nozzle Cleaning:** Periodically clean the inside of the welding nozzle to remove spatter buildup. Spatter can obstruct gas flow and affect weld quality. Use a reamer or anti-spatter spray.
- **Tip Inspection and Replacement:** Inspect the welding tip regularly for wear, enlargement of the wire hole, or signs of burn-back. A worn tip can cause erratic arc behavior and poor wire feeding. Replace tips as needed.
- **Tip Holder Inspection:** Check the tip holder for any damage or poor electrical contact. Ensure it is clean and securely fastened.

6. Troubleshooting

If you experience issues during welding, check the following related to these consumables:

- **Poor Wire Feeding:**
  Possible Cause: Worn welding tip (enlarged hole).
  Solution: Replace the welding tip. Ensure the tip size matches the wire diameter.
  Possible Cause: Spatter buildup in the tip holder or nozzle.
  Solution: Clean the tip holder and nozzle.

- **Erratic Arc / Poor Weld Quality:**
  Possible Cause: Insufficient shielding gas due to a loose or clogged nozzle.
  Solution: Ensure the nozzle is securely attached and clean. Check gas flow.
  Possible Cause: Worn or incorrect welding tip.
  Solution: Replace the tip with a new 0.8mm tip.
- **Burn-back (wire melting back into the tip):**
  Possible Cause: Worn tip, incorrect stick-out, or improper welding parameters.
  Solution: Replace the tip. Adjust stick-out and welding parameters as per your welding machine's instructions.

7. Specifications

Brand	GZ GUOZHI
Model Number	AK15-0.8
Material	Red Copper
Tip Size	0.8mm
Product Weight (Set)	150 g
Set Contents	2 Welding Nozzles, 2 Tip Holders, 20 Welding Tips
Compatibility	MIG-125T, MIG-145LCD-JP, MIG-135LCD, MIG-205-JP, and similar semi-automatic MIG welding machines

8. Safety Information

Always prioritize safety when working with welding equipment and accessories. Failure to follow safety precautions can result in serious injury or death.

- **Personal Protective Equipment (PPE):** Always wear appropriate PPE, including a welding helmet with proper shade, flame-resistant clothing, welding gloves, and safety shoes.
- **Ventilation:** Ensure adequate ventilation to remove welding fumes, which can be hazardous to your health.
- **Fire Hazards:** Keep flammable materials away from the welding area. Have a fire extinguisher readily available.
- **Electrical Safety:** Ensure all electrical connections are secure and the welding machine is properly grounded. Never work in wet conditions.
- **Read Machine Manual:** Always refer to your specific welding machine's instruction manual for comprehensive safety guidelines and operating procedures.

9. Warranty and Support

For any questions regarding the GZ GUOZHI Welding Tip and Nozzle Set, or for technical support, please contact your retailer or the manufacturer directly. Please retain your proof of purchase for any warranty claims.

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