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> AZZUNO MIG Welding Gun Kit Components Instruction Manual for 14AK/15AK Torches

AZZUNO Nozzle-2+Tip-4

AZZUNO MIG Welding Gun Kit Components Instruction Manual

Model: Nozzle-2+Tip-4

1. INTRODUCTION

This manual provides essential information for the proper use, installation, and maintenance of your AZZUNO MIG Welding Gun Kit components. This kit includes gas nozzles and contact tips designed for 14AK and 15AK welding torches. Please read these instructions carefully before use to ensure safe and efficient operation.

2. PACKAGE CONTENTS

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

- 2 x Gas Nozzles
- 2 x Contact Tips 0.030" (0.8mm)
- 2 x Contact Tips 0.035" (0.9mm)



Image 1: Overview of the AZZUNO MIG Welding Gun Kit components. This image displays two silver-colored gas nozzles and four copper-colored contact tips, two labeled 0.8 and two labeled 0.9, indicating their respective sizes.

3. COMPONENT OVERVIEW

3.1 Gas Nozzles

The gas nozzles are designed to direct the shielding gas flow around the welding arc and molten weld pool, protecting it from atmospheric contamination. They are constructed from durable, heat-resistant materials for extended performance.

GAS NOZZLES



Image 2: Detailed view of an AZZUNO gas nozzle with dimensions. The nozzle measures approximately 2.1 inches in length, with an outer diameter of 0.5 inches and an inner diameter of 0.45 inches.

3.2 Contact Tips

Contact tips facilitate the transfer of electrical current to the welding wire. They are made from highly conductive material to ensure a stable arc and consistent welding performance. This kit includes two common sizes: 0.030" (0.8mm) and 0.035" (0.9mm).

CONTACT TIPS



Image 3: Close-up of AZZUNO contact tips. The image highlights the dimensions, showing a length of 0.95 inches and a diameter of 0.24 inches. It also indicates a hole diameter of 0.030" or 0.035" and an M6 thread type.

4. COMPATIBILITY

These gas nozzles and contact tips are specifically designed for use with **14AK** and **15AK** MIG welding torches. They are compatible with all AZZUNO MIG series welders, including models such as MIG-200F, MIG-130F, and MIG-135F.

SUITABLE FOR WELDING TORCHES

14AK / 15AK



Image 4: A welding torch in active use, demonstrating the application of these components. The image confirms suitability for 14AK and 15AK welding torches.

5. SETUP AND INSTALLATION

Follow these general steps for installing or replacing the gas nozzle and contact tip on your MIG welding torch:

1. **Safety First:** Ensure the welding machine is turned off and disconnected from the power source before handling any torch components.
2. **Remove Old Components:** Unscrew the existing gas nozzle and then the contact tip from the torch head.
3. **Select Correct Tip:** Choose the appropriate contact tip size (0.030" or 0.035") based on the diameter of your welding wire.
4. **Install New Contact Tip:** Thread the new contact tip onto the torch head, ensuring it is securely tightened but do not overtighten.
5. **Install New Gas Nozzle:** Slide the new gas nozzle over the torch head until it clicks or seats firmly into place. Ensure it is properly aligned.
6. **Inspect:** Visually inspect the installed components to ensure they are correctly seated and free from damage.

6. OPERATING INSTRUCTIONS

Proper selection and maintenance of these components are crucial for optimal welding performance:

- **Match Contact Tip to Wire:** Always use a contact tip that matches the diameter of your welding wire. Using an incorrect size can lead to poor wire feeding, arc instability, and premature tip wear.
- **Ensure Good Electrical Contact:** A securely tightened contact tip ensures efficient transfer of welding current. Loose tips can cause overheating and poor arc quality.
- **Maintain Gas Flow:** Ensure your shielding gas system is functioning correctly to provide adequate gas coverage through the nozzle, protecting the weld from contamination.

7. MAINTENANCE

Regular maintenance extends the life of your welding components and ensures consistent weld quality:

- **Clean Gas Nozzle:** Periodically remove spatter from inside the gas nozzle using a reamer or a suitable tool. Excessive spatter can obstruct gas flow and lead to porosity in welds.
- **Inspect Contact Tip:** Check the contact tip for wear, enlargement of the wire hole, or signs of arcing. A worn tip will result in poor electrical contact and an unstable arc. Replace as needed.
- **Check for Damage:** Inspect both the nozzle and tip for any cracks, deformation, or other damage that could affect performance or safety.

8. TROUBLESHOOTING

If you experience issues during welding, consider the following common problems related to these components:

- **Poor Arc Stability:** Often caused by a worn or incorrect contact tip. Ensure the tip matches the wire size and is securely tightened.
- **Wire Feeding Issues:** A contact tip with an enlarged or clogged hole can impede wire feeding. Replace the tip if necessary.
- **Porosity in Weld:** Insufficient shielding gas coverage, often due to a clogged or damaged gas nozzle, can lead to porosity. Clean or replace the nozzle.
- **Overheating Components:** A loose contact tip or excessive spatter buildup can cause components to overheat. Ensure proper installation and regular cleaning.

9. SPECIFICATIONS

- **Manufacturer:** AZZUNO
- **Part Number:** Nozzle-2+Tip-4
- **Item Weight:** 2.4 ounces
- **Package Dimensions:** 5.24 x 3.62 x 0.63 inches
- **Contact Tip Sizes:** 0.030" (0.8mm), 0.035" (0.9mm)
- **Compatibility:** 14AK/15AK Welding Torches, AZZUNO MIG series welders

10. WARRANTY AND SUPPORT

AZZUNO is committed to customer satisfaction. For any questions regarding this product, assistance with your purchase, or support after the sale, please contact AZZUNO customer service. Our team is available

to provide assistance.

For more information or to contact support, please visit the official AZZUNO store or contact your retailer.