Saved from manuals.plus.
Open the live page for links to other documents and user manuals.

ANDELI AMZTGHS2LB30-3

ANDELI ER70S-6 .030-Inch Carbon Steel Solid MIG Welding Wire Instruction Manual

Model: AMZTGHS2LB30-3

1. Product Overview

The ANDELI ER70S-6 MIG Welding Wire is a copper-coated mild steel GMAW (MIG) wire designed for single or multiple pass welding applications. It features a high combination of manganese and silicon deoxidizers, which allows for higher welding currents when using 100% CO2 shielding gas. This results in a smoother weld bead with minimal post-weld cleanup.

This wire is engineered to produce porosity-free, X-ray quality welds with high tensile strength. Its consistent and continuous feeding characteristics contribute to uninterrupted welding operations, enhancing efficiency and reducing material waste.



Figure 1: ANDELI ER70S-6 MIG Welding Wire in operation, demonstrating low splatter and a stable arc for efficient welding.

2. Safety Information

Always prioritize safety when welding. Read and understand all safety instructions provided with your welding equipment and shielding gas. Wear appropriate personal protective equipment (PPE), including a welding helmet with proper shade, flame-resistant clothing, welding gloves, and safety shoes. Ensure adequate ventilation to avoid inhaling welding fumes. Keep a fire extinguisher nearby.

- **Electric Shock:** Can kill. Do not touch live electrical parts.
- **Fumes and Gases:** Can be hazardous to your health. Keep your head out of the fumes. Use enough ventilation and/or exhaust at the arc to keep fumes and gases away from the breathing zone.
- **Arc Rays:** Can burn eyes and skin. Wear a welding helmet with a proper shade filter and appropriate clothing to protect your body.
- **Fire and Explosion:** Welding can cause fire or explosion. Keep flammables away from the welding area.

3. Setup and Installation

1. **Prepare Welding Machine:** Ensure your MIG welding machine is turned off and disconnected from the power source before installation.
2. **Open Wire Compartment:** Locate and open the wire spool compartment on your MIG welder.
3. **Install Wire Spool:** Place the ANDELI ER70S-6 wire spool onto the spool holder. Ensure it is seated correctly and rotates freely. The wire should unwind from the bottom of the spool.
4. **Secure Spool:** Use the retaining nut or clip to secure the spool, preventing it from coming loose during operation. Adjust the spool tensioner to prevent overrun but allow smooth feeding.
5. **Feed Wire:** Straighten about 6-8 inches of wire and carefully feed it through the inlet guide, over the drive rolls, and into the gun liner. Ensure the drive rolls are set for the correct wire diameter (.030-inch or 0.8mm).
6. **Close Drive Roll Tension:** Close the drive roll tension arm and adjust the tension. The tension should be firm enough to feed the wire without slipping, but not so tight that it deforms the wire.
7. **Connect Shielding Gas:** Connect your 100% CO2 shielding gas cylinder to the welder and set the flow rate according to your welding machine's recommendations, typically 15-25 cubic feet per hour (CFH).
8. **Trim Wire:** Once the wire is fed through the gun, trim the excess wire, leaving about 1/2 inch extending from the contact tip.



Figure 2: A MIG welding machine with the ANDELI wire spool correctly installed, illustrating the wire feeding path.

4. Operating Instructions

The ER70S-6 wire is suitable for all-position gas welding. Optimal performance is achieved with 100% CO2 shielding gas.

1. **Power On:** Connect the welding machine to power and turn it on.
2. **Set Parameters:** Adjust your welding machine's voltage and wire feed speed settings based on the material thickness and joint type. Refer to your welder's manual or a welding parameter chart for guidance.
3. **Prepare Workpiece:** Ensure the workpiece is clean, free of rust, paint, and oil. Secure the workpiece with clamps.
4. **Establish Ground:** Attach the ground clamp securely to the workpiece or welding table, ensuring good electrical contact.
5. **Start Welding:** Position the welding gun at the start of the joint. Press the trigger to initiate the arc and wire feed. Maintain a consistent travel speed and gun angle (typically 10-15 degrees push angle for MIG).

6. **Observe Weld Pool:** Monitor the weld pool for proper penetration and bead formation. Adjust settings as needed.
7. **Finish Weld:** Release the trigger at the end of the weld. Allow the weld to cool before handling.

Welding Positions

This wire supports various welding positions:

- **Vertical Welding:** Welding upwards or downwards on a vertical surface.
- **Flat Welding:** Welding on a horizontal surface.
- **Up Welding:** Welding overhead or in an upward direction.
- **Corner Welding:** Welding into an internal or external corner joint.



Figure 3: Illustration of common welding positions achievable with ANDELI ER70S-6 wire.

5. Maintenance and Storage

Proper maintenance and storage of your welding wire ensure its longevity and consistent performance.

- **Storage:** Store welding wire in a dry, cool environment, away from moisture, dust, and direct sunlight. The vacuum packaging helps protect the wire from atmospheric contamination.
- **Handling:** Handle spools carefully to avoid damage or deformation of the wire.
- **Drive Rolls:** Regularly inspect and clean the drive rolls of your welding machine to remove any wire residue or debris that could impede smooth feeding.
- **Gun Liner:** Periodically check the gun liner for wear or blockages. A worn or dirty liner can cause feeding issues.
- **Contact Tip:** Replace the contact tip when it shows signs of wear or becomes clogged, as this can affect arc stability and wire feeding.



Figure 4: The ANDELI welding wire is supplied in sturdy cartons with vacuum packaging to ensure product integrity and protection from moisture.



Figure 5: The upgraded ABS plastic spool design offers increased durability and resistance to breakage compared to older, more fragile spools.

6. Troubleshooting

Common Issues and Solutions

Problem	Possible Cause	Solution
Poor Wire Feeding	Incorrect drive roll tension, worn drive rolls, clogged gun liner, incorrect contact tip size.	Adjust drive roll tension, clean/replace drive rolls, clean/replace gun liner, ensure correct contact tip for .030-inch wire.
Excessive Splatter	Incorrect voltage/wire feed speed, insufficient shielding gas flow, dirty workpiece.	Adjust voltage and wire feed speed, check gas flow rate and connections, clean workpiece thoroughly.

Problem	Possible Cause	Solution
Porosity in Weld	Insufficient shielding gas, gas leaks, contaminated workpiece, excessive wire stick-out.	Increase gas flow, check for gas leaks, clean workpiece, reduce wire stick-out.
Unstable Arc	Poor ground connection, incorrect welding parameters, worn contact tip.	Ensure solid ground connection, adjust voltage/wire feed speed, replace contact tip.

7. Specifications

- **Model Number:** AMZTGHS2LB30-3
- **Wire Type:** ER70S-6 Carbon Steel Solid MIG Welding Wire
- **Diameter:** .030 inches (0.8mm)
- **Weight:** 2 lbs (0.9 kg) per spool
- **Quantity:** 3 spools per pack
- **Material:** Carbon Steel
- **Shielding Gas:** 100% CO2 recommended for optimal performance
- **Package Dimensions:** Approximately 10 x 10 x 6 inches
- **Item Weight (Total):** Approximately 6 pounds

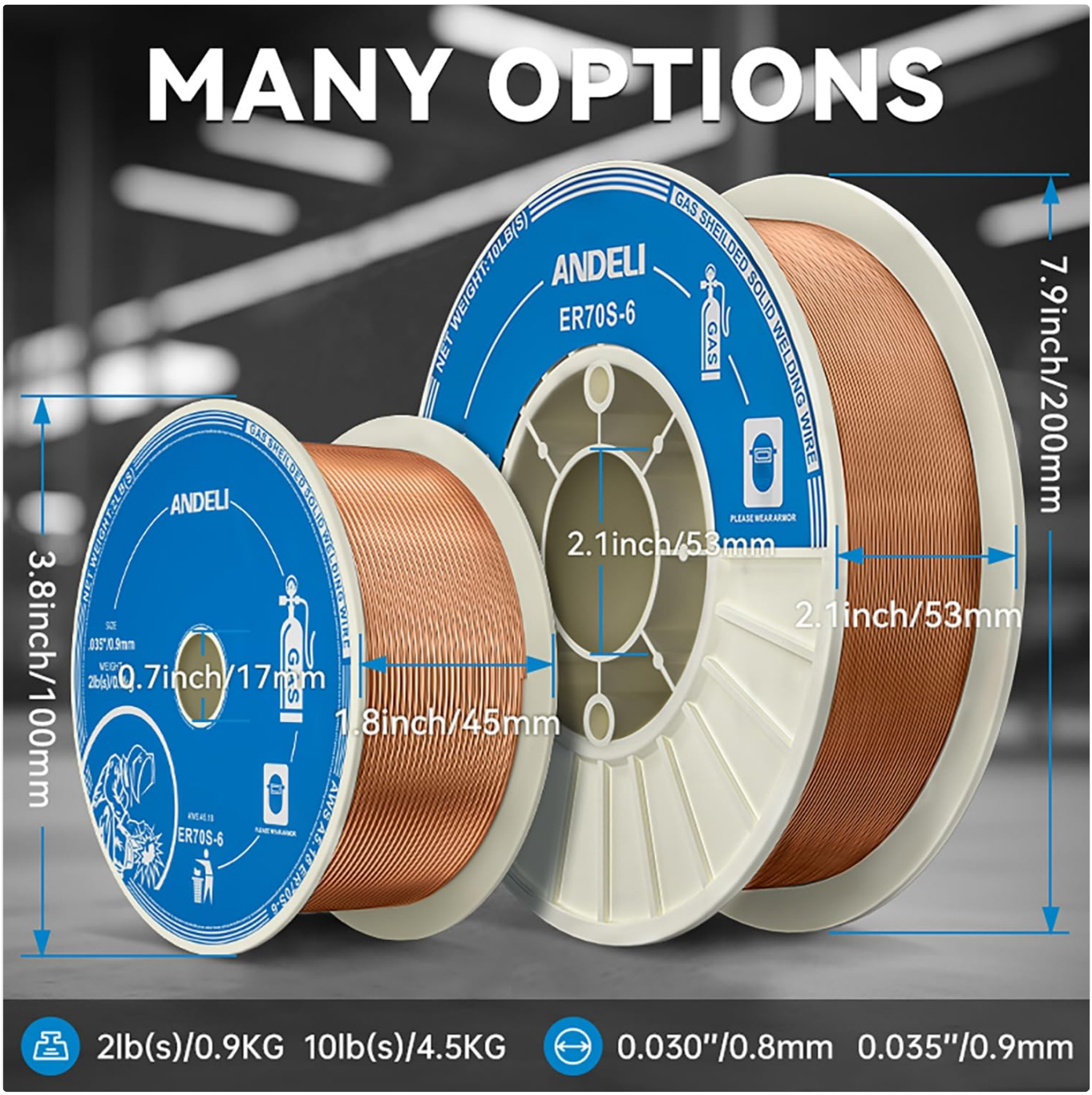


Figure 6: Various packaging options for ANDELI ER70S-6 welding wire, detailing different weights and diameters available.

8. Warranty and Support

For warranty information or technical support regarding your ANDELI ER70S-6 Carbon Steel Solid MIG Welding Wire, please refer to the documentation provided with your purchase or contact ANDELI customer service directly. Contact details can typically be found on the product packaging or the official ANDELI website.

ANDELI is committed to providing quality products and support. If you encounter any issues or have questions, please reach out to their support team for assistance.

© 2024 ANDELI. All rights reserved.

Ask a question about this manual

Ask about setup, troubleshooting, compatibility, parts, safety, or missing instructions. Manuals+ will review the

question and use this page's manual context to help answer it.

Name

Anonymous

Email

you@example.com

After a successful submission, we securely hash the supplied account or form email before sending it to Microsoft Advertising for conversion attribution. Privacy details.

Question

Example: How do I reset this device or fix this error?

Details

Model number, symptoms, what you tried, or the section of the manual you are using.

Submit question

Open the live page

https://manuals.plus/asin/B0DQWY16DK

More documents and user manuals: **https://manuals.plus/**