Hasweld 8FT Liner MIG Welder Gun

Hasweld 8FT Liner MIG Welder Gun for Ozito MWR-135: Instruction Manual

Model: 8FT Liner MIG Welder Gun

Introduction

This instruction manual provides essential information for the safe and effective use, installation, and maintenance of your Hasweld 8FT Liner MIG Welder Gun, designed for compatibility with the Ozito Welding Torch MWR-135 Mig Welder. Please read this manual thoroughly before operation to ensure proper function and to prevent injury or damage.

Safety Information

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

- **Electric Shock Can Kill:** Ensure the welder is properly grounded. Do not touch live electrical parts. Wear dry gloves and protective clothing.
- **Fumes and Gases Can Be Hazardous:** Keep your head out of the fumes. Use adequate ventilation or exhaust at the arc.
- **Arc Rays Can Burn Eyes and Skin:** Wear a welding helmet with a proper shade filter. Wear appropriate protective clothing to protect skin.
- **Fire and Explosion Hazard:** Remove all flammable materials from the welding area. Have a fire extinguisher readily available.
- **Hot Parts Can Cause Severe Burns:** Allow equipment to cool before touching. Wear insulated gloves.
- **Read and Understand:** Always read and understand the instruction manual for your welding machine and all related equipment before use.

Package Contents

Verify that all items are present and undamaged upon unpacking.

- 1 x Hasweld 8FT Liner MIG Welder Gun
- 9 x Contact Tips (.030 tip included)

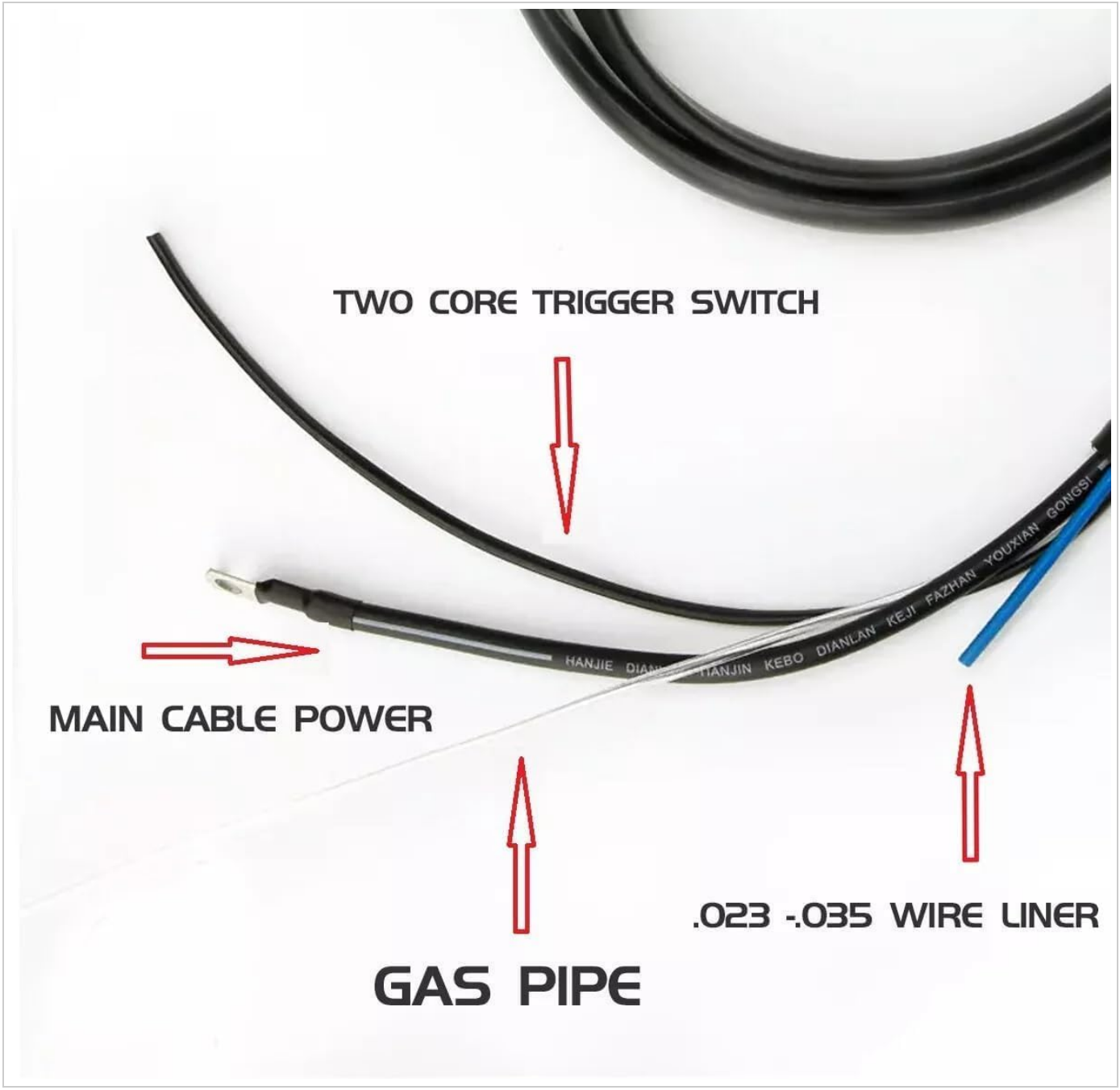


Image 1: Hasweld 8FT Liner MIG Welder Gun and included contact tips. This image displays the complete MIG gun assembly along with a small bag containing additional contact tips.

Product Overview and Components

The Hasweld 8FT Liner MIG Welder Gun is designed for efficient wire feeding and reliable arc stability. Understanding its main components is crucial for proper setup and operation.

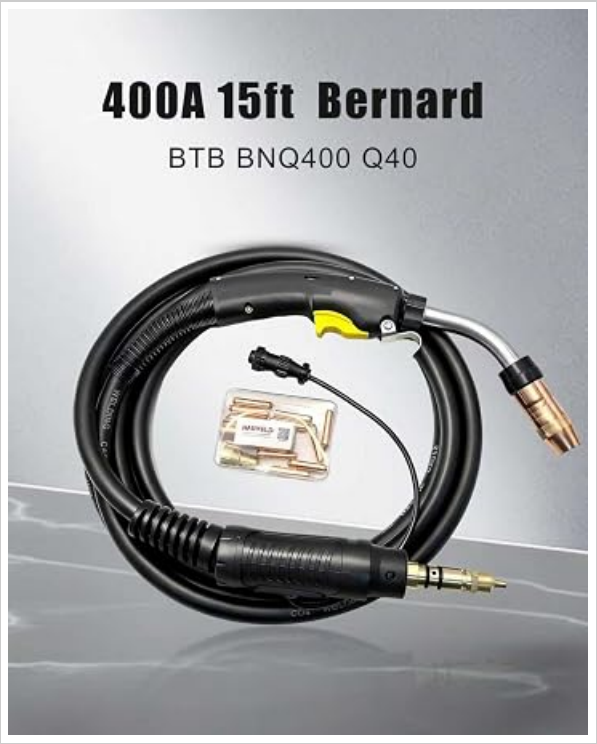


Image 2: Diagram illustrating the internal components of the MIG welder gun. Key components shown include the two-core trigger switch, main cable power, gas pipe, and the .023-.035 wire liner.

- **Two Core Trigger Switch:** Activates the welding process, controlling wire feed and gas flow.
- **Main Cable Power:** Carries welding current from the machine to the gun.
- **Gas Pipe:** Delivers shielding gas to the weld puddle.
- **Wire Liner (.023-.035):** Guides the welding wire from the feeder through the gun to the contact tip.
- **Contact Tip:** Electrically connects to the welding wire and directs the current to the wire.
- **Nozzle:** Directs the shielding gas to the weld area and protects the contact tip.

Setup Instructions

1. **Ensure Power is OFF:** Before connecting or disconnecting any components, ensure your Ozito MWR-135 Mig Welder is turned off and unplugged from the power source.
2. **Connect Main Cable Power:** Insert the main power connector of the MIG gun into the corresponding receptacle on your Ozito MWR-135 welder. Secure it firmly according to your welder's manual.
3. **Connect Trigger Switch:** Plug the two-core trigger switch cable into the designated control port on your welder.
4. **Connect Gas Pipe:** Attach the gas pipe to the gas outlet on your welder or gas regulator. Ensure a tight, leak-free connection.
5. **Install Wire Liner:** If not pre-installed, feed the appropriate wire liner (.023-.035) through the gun cable. Ensure it extends slightly beyond the gun's front end and is properly seated at the back connection.
6. **Load Welding Wire:** Follow your welder's instructions to load the welding wire through the wire feeder and into the gun's wire liner.
7. **Install Contact Tip and Nozzle:** Select the correct contact tip for your wire size (.030 tip is included for common use) and screw it firmly into the gun. Then, attach the nozzle over the contact tip.
8. **Check Connections:** Double-check all connections for security and proper seating before powering on the welder.

Operating Instructions

Once the MIG gun is properly set up and connected to your Ozito MWR-135 welder, you can begin welding. Always refer to your welder's specific operating manual for detailed instructions on power settings, wire speed, and gas flow.

1. **Prepare Workpiece:** Clean the workpiece thoroughly to remove rust, paint, oil, or other contaminants.
2. **Ground Clamp:** Attach the ground clamp securely to the workpiece or welding table, ensuring good electrical contact.
3. **Power On:** Turn on your Ozito MWR-135 Mig Welder.
4. **Adjust Settings:** Set the voltage, wire speed, and gas flow according to the material thickness and type of weld.
5. **Purge Gas (Optional):** Briefly press the trigger without touching the workpiece to purge air from the gas line.
6. **Start Welding:** Position the gun nozzle approximately 1/4 to 3/8 inch (6-10mm) from the workpiece. Press the trigger to initiate the arc and wire feed. Maintain a consistent travel speed and gun angle for optimal weld quality.
7. **Release Trigger:** Release the trigger to stop the welding process.
8. **Cool Down:** Allow the workpiece and gun components to cool before handling.

Maintenance

Regular maintenance ensures the longevity and optimal performance of your MIG welder gun.

- **Clean Nozzle:** Regularly remove spatter from the nozzle using spatter spray or a nozzle reamer. Excessive spatter can obstruct gas flow.
- **Inspect Contact Tip:** Check the contact tip for wear, enlargement of the bore, or spatter buildup. Replace worn or damaged tips promptly to ensure good electrical contact and consistent wire feeding.
- **Check Wire Liner:** Periodically inspect the wire liner for kinks, blockages, or wear. A damaged liner can cause erratic wire feeding. Replace the liner if necessary.
- **Inspect Cables:** Examine the main power cable and trigger switch cable for any signs of damage, cuts, or fraying. Replace if damaged.
- **Gas System Check:** Ensure all gas connections are tight and free of leaks.



Image 3: A selection of various welding gun tips, nozzles, and other consumables. This image highlights the different types of parts that may require periodic inspection and replacement during maintenance.

Troubleshooting

This section addresses common issues you might encounter during operation.

Problem	Possible Cause	Solution
No Wire Feed	◦ Wire spool tangled or empty ◦ Drive rollers not engaged or tension incorrect ◦ Wire liner blocked or kinked ◦ Contact tip clogged ◦ Trigger switch faulty	◦ Check wire spool and replace if empty ◦ Adjust drive roller tension and ensure engagement ◦ Inspect and clear/replace wire liner ◦ Clean or replace contact tip ◦ Check trigger switch connection and function
No Gas Flow	◦ Gas cylinder empty or valve closed ◦ Gas line kinked or disconnected ◦ Regulator faulty ◦ Nozzle clogged with spatter	◦ Check gas cylinder and open valve ◦ Inspect gas line for obstructions or disconnections ◦ Check regulator pressure ◦ Clean nozzle
Poor Arc Stability	◦ Worn contact tip ◦ Poor ground connection ◦ Incorrect welding parameters (voltage, wire speed) ◦ Contaminated workpiece	◦ Replace contact tip ◦ Ensure solid ground connection ◦ Adjust welder settings ◦ Clean workpiece

Specifications

Feature	Detail
Product Type	MIG Welder Gun Parts
Brand	Hasweld
Compatibility	Ozito Welding Torch MWR-135 Mig Welder
Cable Length	8FT
Included Tips	9 tips (including .030 tip)
Power Source	AC/DC (dependent on welder)
Country of Origin	China

Warranty and Support

For warranty information or technical support, please refer to the documentation provided with your original Ozito MWR-135 Mig Welder or contact the manufacturer of the Hasweld MIG gun directly. Keep your purchase receipt as proof of purchase.

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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.

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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