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AZZUNO WP-17V(10-25)-3

AZZUNO WP-17V LIFT TIG Welding Torch User Manual

Model: WP-17V(10-25)-3

INTRODUCTION

This manual provides essential instructions for the safe and effective use of your AZZUNO WP-17V Air-Cooled LIFT TIG Welding Torch. Please read this manual thoroughly before operation to ensure proper setup, usage, and maintenance. This torch is designed for precise TIG welding applications and is compatible with specific AZZUNO MIG welding machines.



Image: The AZZUNO WP-17V LIFT TIG Welding Torch, showcasing its ergonomic design and components.

PACKAGE CONTENTS

Upon unpacking, verify that all the following items are included in your package:

- 1 x WP-17V TIG Torch with 13-ft Cable and Gas Hose
- 3 x Ceramic Cups (various sizes)
- 3 x Collets (various sizes)
- 1 x Collet Body
- 1 x Long Back Cap
- 1 x Short Back Cap

WP-17V ACCESSORIES



CERAMIC CUP #4



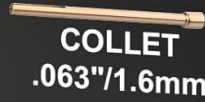
CERAMIC CUP #5



CERAMIC CUP #6



COLLET BODY



COLLET
.063"/1.6mm



COLLET
.078"/2.0mm



COLLET
.094"/2.4mm

SHORT
BACK CAP



LONG
BACK CAP



Image: A detailed view of the WP-17V TIG torch accessories, including ceramic cups, collets, collet body, and back caps.

SIZE OF ACCESSORIES

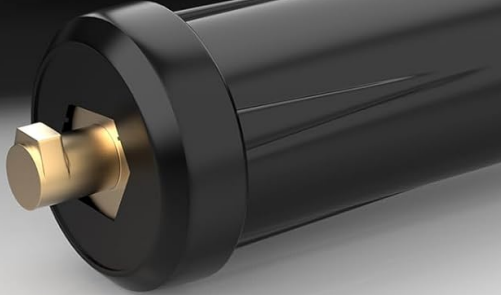


Image: Diagram illustrating the dimensions and sizes of the ceramic cups, collets, collet body, and back caps for the WP-17V TIG torch.

SETUP INSTRUCTIONS

- 1. Connect the Quick Connector:** Attach the 10-25mm² quick connector of the TIG torch cable to the corresponding output terminal on your compatible AZZUNO welding machine. Ensure a secure connection.
- 2. Connect the Gas Hose:** Connect the 5/8"-18 gas hose connector to the gas outlet on your welding machine. Ensure the gas hose is properly tightened to prevent leaks.
- 3. Install Consumables:**
 - Insert the appropriate collet and collet body into the torch head.
 - Place the tungsten electrode into the collet and tighten the back cap to secure it.
 - Screw on the ceramic cup (nozzle) to the torch head.
- 4. Gas Supply:** Connect your argon gas cylinder to the welding machine's gas inlet and ensure the regulator is set to the recommended flow rate for TIG welding.

CABLE LENGTH: 13ft/4m



Quick Connector: 10-25mm²



External Thread 5/8"

Gas Hose Connector

Image: Close-up view of the 13-ft cable, 10-25mm² quick connector, and 5/8" external thread gas hose connector for the TIG torch.

OPERATING INSTRUCTIONS

Lift TIG Start

The AZZUNO WP-17V TIG torch features a reliable Lift TIG start mechanism. This method allows for arc initiation without high-frequency interference, providing a smooth and stable start for precise welding. To initiate the arc:

1. Ensure your welding machine is set to TIG mode and appropriate welding parameters (current, gas flow) are selected.
2. Lightly touch the tungsten electrode to the workpiece.
3. Slowly lift the torch from the workpiece. The arc will initiate as the torch is lifted, providing a controlled start.
4. Maintain a consistent arc length and travel speed for optimal weld quality.

Ergonomic Design

The WP-17V TIG torch is designed with an ultra-lightweight body and a non-slip rhombus-patterned handle.

This ergonomic design ensures a comfortable grip, reducing operator fatigue during extended welding sessions and enhancing control for precise work.

MAINTENANCE

Regular maintenance ensures the longevity and optimal performance of your TIG welding torch:

- **Clean Consumables:** Regularly inspect and clean the ceramic cups, collets, and collet body. Replace them if they show signs of wear, cracking, or damage.
- **Tungsten Electrode:** Keep the tungsten electrode sharp and free from contamination. Re-grind or replace as needed.
- **Cable and Hose Inspection:** Periodically check the 13-ft cable and gas hose for any cuts, abrasions, or leaks. Ensure all connections remain tight.
- **Storage:** Store the torch in a clean, dry environment away from dust and moisture when not in use.

TROUBLESHOOTING

This section addresses common issues you might encounter with your TIG torch. For more complex problems, consult your welding machine's manual or contact AZZUNO customer support.

- **Poor Arc Start:**
 - Check tungsten electrode condition (sharpness, contamination).
 - Verify proper gas flow and connection.
 - Ensure correct welding parameters are set on the machine.
- **Inconsistent Arc:**
 - Inspect collet and collet body for wear or damage.
 - Check for gas leaks in the hose or connections.
 - Ensure the tungsten is securely tightened.
- **Gas Leaks:**
 - Tighten all gas hose connections.
 - Inspect the gas hose for visible damage and replace if necessary.

SPECIFICATIONS

Manufacturer	AZZUNO
Part Number	WP-17V(10-25)-3
Item Weight	2 pounds
Package Dimensions	10.6 x 7.5 x 2.8 inches
Style	WP-17V(10-25mm ²) with 5/8"-18
Cable Quick Connector	10-25mm ²
Gas Hose Connector	5/8"
Cable Length	13-FT (approximately 4 meters)

COMPATIBILITY

The AZZUNO WP-17V TIG Welding Torch (with 10-25mm² connector) is specifically designed for compatibility with the following AZZUNO welding machines:

- AZZUNO MIG-135F
- AZZUNO MIG-155F
- AZZUNO MIG-135PRO
- AZZUNO MIG-135L
- AZZUNO MIG-145L
- AZZUNO MIG-155L
- And other compatible models with 10-25mm² quick connectors and 5/8" gas hose connections.

LIFT TIG TORCH WP-17V(10-25mm²)

Compatible For

MIG-135F/MIG-135PRO/MIG-155F



Image: The WP-17V TIG torch shown alongside compatible AZZUNO MIG welding machines, illustrating the connection.

WARRANTY AND SUPPORT

For warranty information, technical support, or any inquiries regarding your AZZUNO WP-17V LIFT TIG Welding Torch, please contact AZZUNO customer service directly. You can often find contact details on the official AZZUNO website or through the retailer where the product was purchased.

Visit the official AZZUNO store for more products and support: [AZZUNO Store](#)