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› ANDELI CO2 Mig Welding Torch MB 15AK Accessories Kit M6251.0 User Manual

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Model: MB 15AK Accessories Kit M6251.0

1. INTRODUCTION

This manual provides instructions for the safe and effective use of the ANDELI CO2 Mig Welding Torch MB 15AK Accessories Kit M6251.0. Please read this manual thoroughly before installation, operation, or maintenance.

2. PRODUCT COMPONENTS

The MB 15AK Accessories Kit M6251.0 includes various components essential for MIG welding operations. Familiarize yourself with each part before use.



Figure 2.1: Overview of the ANDELI MB 15AK Accessories Kit components, including contact tips, gas nozzles, and gas diffusers.

- **Contact Tips:** Copper components that guide the welding wire and conduct electrical current.
- **Gas Nozzles:** Metal or ceramic cups that direct shielding gas to the weld pool.
- **Gas Diffusers:** Components that distribute shielding gas evenly within the gas nozzle.

3. SETUP AND INSTALLATION

Proper installation of the accessories is crucial for optimal welding performance and safety.

3.1. Installing Contact Tips

1. Ensure the welding torch is disconnected from the power source.
2. Unscrew the existing contact tip (if any) from the gas diffuser.
3. Select the appropriate contact tip size for your welding wire diameter.
4. Screw the new contact tip firmly into the gas diffuser. Do not overtighten.



Figure 3.1: Various contact tips and gas diffusers, ready for installation onto a welding torch.

3.2. Installing Gas Diffusers and Nozzles

1. After installing the contact tip, slide the gas diffuser over the torch neck and secure it.
2. Place the gas nozzle over the gas diffuser. Ensure it is seated correctly to prevent gas leakage.



Figure 3.2: Assembled and individual components of the welding torch kit, illustrating how they fit together.

4. OPERATION GUIDELINES

These accessories are designed to optimize the performance of your CO2 MIG welding torch. Always follow the safety guidelines of your primary welding equipment.

- **Shielding Gas Flow:** Ensure proper shielding gas flow rate for your application to prevent porosity in welds.
- **Contact Tip Recess:** Adjust the contact tip recess relative to the gas nozzle for optimal arc stability and spatter control.
- **Wire Feed Speed:** Match the contact tip size to your welding wire diameter for consistent wire feeding.

5. MAINTENANCE AND CARE

Regular maintenance extends the lifespan of your welding torch accessories and ensures consistent weld quality.

5.1. Cleaning

- **Contact Tips:** Clean spatter from contact tips regularly. Replace if the bore becomes elongated or clogged.

- **Gas Nozzles:** Remove spatter from inside the gas nozzle to maintain proper gas flow.
- **Gas Diffusers:** Inspect for blockages and clean as needed.

5.2. Replacement

Replace worn or damaged components promptly to avoid welding defects and ensure safety.



Figure 5.1: A clean gas nozzle, ready for use or replacement.

6. TROUBLESHOOTING COMMON ISSUES

Issue	Possible Cause	Solution
Excessive Spatter	Worn contact tip, incorrect gas flow, improper stick-out.	Replace contact tip, adjust gas flow, ensure correct contact tip recess.
Porosity in Weld	Insufficient shielding gas, clogged gas nozzle/diffuser.	Check gas supply, clean or replace gas nozzle/diffuser.

Issue	Possible Cause	Solution
Inconsistent Wire Feed	Contact tip bore too large/small, spatter in tip.	Use correct contact tip size, clean or replace contact tip.

7. SPECIFICATIONS

- **Model:** MB 15AK Accessories Kit M6251.0 (AG60 kit)
- **Compatibility:** CO2 MIG Welding Torches (MB 15AK type)
- **Included Components:** Contact Tips, Gas Nozzles, Gas Diffusers
- **Power Source:** Hand-powered (accessories for powered torch)

8. WARRANTY AND SUPPORT

For warranty information or technical support, please refer to the documentation provided with your primary ANDELI welding equipment or visit the official ANDELI website.

Manufacturer: ANDELI

Part Number: ADL-980

ASIN: B0FP263P4R

