

TROUBLESHOOTING 101

MIG Welding	TIG Welding
Problem: Porosity	Problem: Porosity
Possible Solutions	Possible Solutions
<p>Inadequate shielding gas coverage Check the following:</p> <ul style="list-style-type: none"> • <i>Tip</i> <ul style="list-style-type: none"> - Make sure you are using the correct size tip that is not worn or dirty • <i>Gun Seat</i> <ul style="list-style-type: none"> - Make sure the gun is inserted all the way against the gun seat • <i>Drive Roll Tension</i> <ul style="list-style-type: none"> - If the tension is set too high, the wire can become deformed and cause rough wire feeding - See manual for proper settings 	<p>Inadequate shielding gas coverage Check the following:</p> <ul style="list-style-type: none"> • All gas connections for gas leaks • Shut off fans • Close doors or windows producing wind • Gas CFH should be between 20-25 (see manual) • Tungsten could be bad • Gun seat may be loose • Regulators for loose fittings or leaks
Problem: Bird Nesting	Problem: Machine Set-up
Possible Solutions	Possible Solutions
<ul style="list-style-type: none"> • Ensure tip is the correct size in regards to the wire diameter • Check the liner for bends or kinks (change liner) • Drive roll tension is too tight 	<ul style="list-style-type: none"> • Make sure all settings are set properly based on the material type and thickness • Refer to manual for proper set-up
Problem: Burn Back	
Possible Solutions	
<ul style="list-style-type: none"> • Wire feed may be too slow • Amperage may be too high • Wrong size tips • Spool tension may be too tight 	
Problem: Erratic Wire Feeding	
Possible Solutions	
<ul style="list-style-type: none"> • Liner Damage • Tip size or damage • Drive roll may be too tight/loose 	

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