



HELPFUL HINTS TO AVOID MIG GUN CONSUMABLE PROBLEMS

MIG welding consumables may be a small part of the welding operation, but issues with them can add up.

WELDING NOZZLES

- A 1/8-inch contact tip recess provides good shielding gas coverage in most applications to **reduce spatter, porosity and burn-through/warping of thinner materials.**
- Use a long tapered nozzle to **reach restricted joints.** Pair with a tapered tip for optimal gas flow.
- **For better durability and longer life,** choose brass nozzles. Exception: In very high heat applications use copper nozzles.

CONTACT TIPS

- Match the contact tip size to the diameter of wire to gain the best electrical conductivity and **reduce premature wear and burnbacks.**
- Use a contact tip with coarse threads to **avoid cross-threading** during replacement.
- Use a contact tip with a taper lock to the gas diffuser to **prevent loosening**, which can increase heat and wear.
- Use a contact tip protected from heat by the gas diffuser and cooled by shielding gas to **extend tip life.**

WELDING LINERS

- Use a gas diffuser and a power pin that locks the liner in place at the front and back of the gun to **provide flawless wire feeding.**
- Avoid twisting the gun when trimming a conventional liner to **reduce burnbacks, bird-nesting and erratic arc.**
- Periodically clear out the liner with compressed air to **avoid erratic wire feeding, blockages and bird-nesting.**