



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 to 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.

► For more information on consumable options, visit [Tregaskiss.com/AccuLockS](https://www.tregaskiss.com/AccuLockS).