



# MIG TORCHES WITH 3M EURO CONNECTOR MB15 , MB25

MODEL NO: **MIG/T15.V2, MI/T25.V2**

Thank you for purchasing a Sealey product. Manufactured to a high standard, this product will, if used according to these instructions, and properly maintained, give you years of trouble free performance.

**IMPORTANT:** PLEASE READ THESE INSTRUCTIONS CAREFULLY. NOTE THE SAFE OPERATIONAL REQUIREMENTS, WARNINGS & CAUTIONS. USE THE PRODUCT CORRECTLY AND WITH CARE FOR THE PURPOSE FOR WHICH IT IS INTENDED. FAILURE TO DO SO MAY CAUSE DAMAGE AND/OR PERSONAL INJURY AND WILL INVALIDATE THE WARRANTY. KEEP THESE INSTRUCTIONS SAFE FOR FUTURE USE.



Refer to instruction manual



Wear a welding mask



Wear protective gloves



Warning! Electricity shock hazard



Warning! Keep away from rain



Caution required



Arc rays can burn eyes and injure skin



Electric shock from welding electrodes can kill



Breathing welding fumes can be hazardous to your health



Welding sparks can cause explosions or fire



Electromagnetic fields can cause pacemaker malfunction

## 1. SAFETY

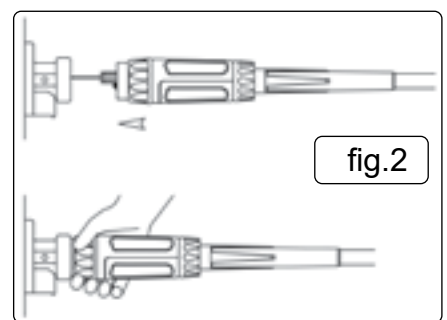
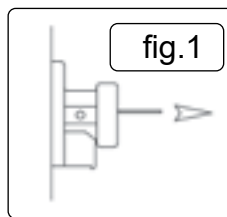
- **BEFORE USE, ALWAYS ENSURE THAT YOU ARE FAMILIAR WITH THE SAFETY WARNINGS AND INSTRUCTIONS FOR THE WELDER TO WHICH THIS TORCH IS TO BE FITTED.**
- × **DO NOT** exceed the rated current of the torch.
- × **DO NOT** use if any part of the torch, cable or connector is damaged in any way. Use only genuine Sealey replacement parts for repairs.
- × **DO NOT** allow the cable to come into contact with any sharp or hot items.
- ✓ Always use the correct personal protective equipment as specified in the welder instructions.

## 2. INTRODUCTION

Professional torches with contoured grip and heat-proof cable. Euro connection enables quick and simple plug connection to welder. No wiring means torch can be disconnected and stored safely. Made in Europe.

## 3. SPECIFICATION

Model No.	MIG/T15	MIG/T25
Rated Current CO <sub>2</sub>	140A	140A
Rated Current M21	160A	184A
Wire diameter	0.6 - 1.0mm	0.8 - 1.2mm
Gas Flow	10 - 18 l/m	10 - 18 l/m
Length	3m	3m
Torch Type	MB15	MB25



## 4. OPERATION

- **WARNING:** Disconnect from power source while setting up.
  - NOTE:** The type and quantity of the shielding gas quantity depends on the welding task and the gas nozzle geometry. Make all shielding gas connections gas-tight.
  - NOTE:** As the MIG/MAG welding torch is part of an integrated welding system, the operating instructions and safety guidelines of the of the welding power source, must be observed during operation.
- 4.1. Using a standard welding torch, the two-position mode of the trigger can be activated (press to weld, release to stop welding).
  - 4.2. Further operating modes and handle modules depend on the corresponding welding power source.
  - 4.3. To connect the torch to the power source:
    - 4.3.1. Remove the tip adaptor and contact tip.
    - 4.3.2. Inch the wire from the exit of the wire guide on the feed unit as Figure 1. Ensure that it does not short out on any machine panels.
    - 4.3.3. Carefully slide the electrode wire into the torch liner and slowly locate the torch gun plug body into the feed unit central connector and tighten the gun plug nut as Figure 2.
    - 4.3.4. Keeping the torch as straight as possible, use the power source inch facility or torch trigger to feed the electrode wire 50mm from the end of the liner conduit.
    - 4.3.5. Once the electrode wire has stopped, refit the tip adaptor, diffuser, contact tip and gas nozzle.

## 5. MAINTENANCE

- ▲ **DANGER:** Risk of injury due to unexpected start-up.
- Switch off the power supply and close off the gas supply, when connecting or disconnecting torch
- Switch off the power supply when changing consumable parts

### 5.1. GENERAL MAINTENANCE

#### 5.1.1. CLEANING

- 5.1.1.1. Remove the nozzle from the front of the neck.
- 5.1.1.2. Remove all spatter from the head, gas diffuser and the nozzle. These components must be clean and free of all debris to ensure efficient gas flow and to prevent short circuit.
- 5.1.1.3. Check all front end consumables for damage and wear. Replace with new genuine parts if necessary.
- 5.1.1.4. To maintain the best performance repeatedly check and clean the front end tip and shield periodically. Also use an anti-spatter spray on the tip and shield to reduce the build up of debris.

#### 5.1.2. LINER REPLACEMENT (STEEL LINER)

- **WARNING:** Risk of injury such as piercing or puncture caused by electrode tip, wear protective gloves and glasses
- 5.1.2.1. Switch off the power source and disconnect the torch from the power source (remove the wire from inside the torch by winding back inside the machine.)
- 5.1.2.2. Lay down the hose assembly straight and remove gas nozzle, contact tip and tip adaptor from torch neck.
- 5.1.2.3. Unscrew liner retention nut from central plug and pull the liner out of the torch.
- 5.1.2.4. Fit the new liner using a push and twist action until the liner is fully inserted. Refit the liner retention nut.
- 5.1.2.5. Cut off the excess length of the spiral wire liner flush with the torch neck or the tip adaptor.
- 5.1.2.6. Refit the torch to the machine  
**NOTE:** Ensure the cut end of the liner does not protrude into the hole where the wire passes. it is recommended to grind the front of the liner to 40 Deg and deburr.
- 5.1.2.7. Screw down liner retention nut by hand and cut off the excess length of the spiral wire liner flush with torch neck or tip adaptor.
- 5.1.2.8. Unscrew liner retention nut and pull out spiral wire liner.
- 5.1.2.9. Sharpen the spiral wire liner at the front to an angle of approx. 40° and deburr.

## 6. TROUBLESHOOTING

<p><b>1. Wire feed unit operates but no gas flow:</b></p> <ul style="list-style-type: none"> <li>Gas cylinder empty</li> <li>Gas regulator closed</li> <li>Faulty solenoid</li> <li>Restriction in torch cables</li> </ul>	<p><b>3. Burnback</b></p> <ul style="list-style-type: none"> <li>Improper voltage setting</li> <li>Contact tip overheating</li> <li>Incorrect or blocked liner</li> <li>Excessive cable kinking</li> <li>Erratic wire feed</li> <li>Improper stick out</li> </ul>
<p><b>2. Bird nesting</b></p> <ul style="list-style-type: none"> <li>Contact tip overheating/Burnback</li> <li>Incorrect contact tip size</li> <li>Incorrect or blocked liner</li> <li>Restriction in torch cable</li> <li>Excessive cable kinkage</li> <li>Excessive feed roll pressure</li> <li>Misaligned drive rolls or wire guides</li> </ul>	<p><b>4 Erratic Wire Feeding or Arc</b></p> <ul style="list-style-type: none"> <li>Adjust welding voltage</li> <li>Improper drive roll tension</li> <li>Improper drive roll size</li> <li>Worn drive rolls</li> <li>Incorrect or blocked liner</li> <li>Incorrect wire guide size</li> <li>Misaligned drive rolls or wire guide</li> <li>Gaps at liner or wire guide junctions</li> <li>Incorrect contact tip size</li> <li>Contact Tip overheating</li> <li>Spatter adhesion on exit geometry of tip bore</li> <li>Excessive cable kinkage</li> <li>Poor earth or cable connections</li> <li>Weld joint area dirty</li> </ul>



#### ENVIRONMENT PROTECTION

Recycle unwanted materials instead of disposing of them as waste. All tools, accessories and packaging should be sorted, taken to a recycling centre and disposed of in a manner which is compatible with the environment. When the product becomes completely unserviceable and requires disposal, drain any fluids (if applicable) into approved containers and dispose of the product and fluids according to local regulations.

**Note:** It is our policy to continually improve products and as such we reserve the right to alter data, specifications and component parts without prior notice.

**Important:** No Liability is accepted for incorrect use of this product.

**Warranty:** Guarantee is 12 months from purchase date, proof of which is required for any claim.



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