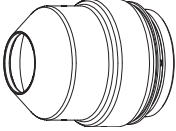

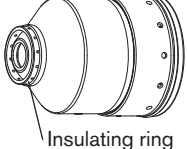
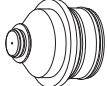

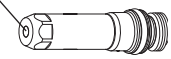


OPERATION

Inspect consumables

Inspect	Look for	Action
Shield cap 	Erosion, missing material Cracks Burned surface	Replace shield cap Replace shield cap Replace shield cap
Shield 	<u>General:</u> Erosion or missing material Molten material attached Blocked gas holes <u>Center hole:</u> Must be round <u>O-rings:</u> Damage Lubricant	Replace shield Replace shield Replace shield Replace the shield when the hole is no longer round Replace shield Apply a thin film of silicone lubricant if the o-rings are dry
Nozzle retaining cap  <p>Insulating ring</p>	<u>General:</u> Damage to insulating ring Poor cut quality after replacing other consumables	Replace nozzle retaining cap Replace nozzle retaining cap
Nozzle  <p>Always replace the nozzle and electrode as a set.</p>	<u>General:</u> Erosion or missing material Blocked gas holes <u>Center hole:</u> Must be round Signs of arcing <u>O-rings:</u> Damage Lubricant	Replace nozzle Replace nozzle Replace the nozzle when the hole is no longer round Replace nozzle Replace nozzle Apply a thin film of silicone lubricant if the o-rings are dry
Swirl ring 	<u>General:</u> Chips or cracks Blocked gas holes Dirt or debris <u>O-rings:</u> Damage Lubricant	Replace swirl ring Replace swirl ring Clean and check for damage; replace when damaged Replace swirl ring Apply a thin film of silicone lubricant if the o-rings are dry
Electrode  <p>Emitter</p> <p>Always replace the nozzle and electrode as a set.</p>	<u>Center surface:</u> Emitter wear - a pit forms as the emitter wears. <u>O-rings:</u> Damage Lubricant	In general, replace the electrode when the pit depth is 0.04 inches or greater. For the 400 amp mild steel electrode and all SilverPlus electrodes, replace the electrode when the pit depth is 0.06 inches or greater. Replace electrode Apply a thin film of silicone lubricant if the o-rings are dry