



## I. Wire does not feed

- ☑ Check for bad gun trigger leads or connections if drive rolls don't turn
- ☑ Check for proper drive roll pressure or blocked liner or tip



## II. Contact tip burnback

- ☑ Check for proper tip recess (distance from end of nozzle to tip)
- ☑ Check for proper wire stick out (distance from end of tip to workpiece)
- ☑ Check ground & electric connections



## III. Short contact tip life

- ☑ Check for correct tip size & capacity of gun
- ☑ Check to make sure that drive rolls aren't deforming wire and sawing at I.D. of tip



## IV. Erratic wire feeding

- ☑ Check for worn out or kinked liner
- ☑ Check for build up or foreign material in liner
- ☑ Check liner size and gaps at junctions caused by improper trimming of liner
- ☑ Check for proper type, size and tension of drive rolls. Check wear
- ☑ Check for proper size contact tip



## V. Erratic Arc (poor electrical conductivity)

- ☑ Check for worn out tip and proper size for wire.
- ☑ Check if gun neck is too straight, use 45-60°
- ☑ Check causes of erratic wire feeding



## VI Excessive spatter

- ☑ Check that tip is installed properly & correct recess
- ☑ Check that correct shielding gas is being used & diffuse holes are not plugged
- ☑ Check AMPS & volts for wire and adjust.



## VII. Weld porosity

- ☑ Check for plugged gas ports, ruptured hose, too much or too little gas
- ☑ Check for worn or plugged o-rings, insulator, diffuser
- ☑ Check for windy welding conditions – reduce draft.



## VIII. Hot Gun

- ☑ Check for exceeding gun rating & duty cycle
- ☑ Check for loose connections, degraded cables

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