DO THE JOB RIGHT.

Part #12012

MIG175 WELDER

ASSEMBLY & OPERATING INSTRUCTIONS

SPECIFICATIONS

Output Amperage Range	Maximum Output No Load Voltage	Maximum Input Amperage	Input Voltage	Rated Duty Cycle	Wire Feed Rate	Welding Wire Spool Sizes	Weight	Overall Dimensions
30-175 A	30 V DC	22 Amp	220 VAC 60 Hz	30% @ 130 A	40-450 IPM	4-8”	67 Lbs. (25kg)	24.4” (620 mm) x 12.6” (320 mm) x 17” (430 mm)

	Solid	Stainless	Flux Cored
Wire Type & Diameter	0.023-0.030” (0.6-0.8mm)	0.023-0.030” (0.6-0.8mm)	0.030-0.035” (0.8-0.9mm)

	Wire Sizes
Spool Gun Wire Type & Diameter	0.030-0.035” (0.8-0.9mm)

DUTY CYCLE

The rated Duty cycle refers to the amount of welding that can be done within an amount of time. It is easiest to look at your welding time in blocks of 10 Minutes and the Duty Cycle being a percentage of that 10 Minutes. If welding at 130 Amps with a 30% Duty Cycle, within a 10 Minute block of time you can weld for 3 Minutes with 7 Minutes of cooling for the welder. If the duty cycle is exceeded and the breaker is tripped, allow the unit to cool for a minimum of 15 Minutes. To increase the duty cycle you can turn down the Voltage Output control. Going above 130 Amps will yield a lower duty cycle.

SAFETY INFORMATION

⚠ WARNING

ARC WELDING CAN BE DANGEROUS.

THIS WELDING MACHINE MUST BE CONNECTED TO A POWER SOURCE IN ACCORDANCE WITH APPLIANCE ELECTRICAL CODES.

DISCONNECT FROM POWER SOURCE BEFORE ASSEMBLING, DISASSEMBLY OR MAINTENANCE OF THE TORCH OR CONTACT TIP OR CHANGING WIRE SPOOLS.

⚠ NOTICE

FOR SAFETY TURN OFF AND UNPLUG MACHINE WHEN INSTALLING NEW WIRE SPOOL, ADJUSTING WIRE TENSION ROLLER OR REPLACING CONTACT TIP.

⚠ WARNING

THE GAS NOZZLE MUST ALWAYS BE INSTALLED WHEN WELDING-DO NOT WELD WITHOUT THE GAS NOZZLE IN PLACE. THE CONTACT TIP IS ELECTRICALLY “HOT” AND IF IT CONTACTS THE GROUNDED WORK PIECE IT WILL CAUSE DAMAGE.

ALL INSTALLATION, MAINTENANCE, REPAIR OPERATION OF THIS EQUIPMENT SHOULD BE PREFORMED BY QUALIFIED INDIVIDUALS IN ACCORDANCE WITH NATIONAL, STATE AND LOCAL CODES.

⚠ DANGER

ELECTRIC SHOCK CAN KILL! Improper use of an electric welder can cause electric shock, injury and death!
Read all precautions described in this manual to reduce the possibility of electric shock.

1. The MIG175 power switch is to be in the OFF (“0”) position when installing the work cable and gun and while plugging in the power cord.
2. Always wear dry, protective clothing and leather welding gloves and insulated footwear.
3. Always operate the welder in a clean, dry, well ventilated area. Do not operate the welder in humid, wet, rainy or poorly ventilated areas.
4. Be sure that the work piece is properly supported and grounded prior to beginning an electric welding operation.
5. The electrode and work (or ground) circuits are electrically “hot” when the welder is on. Do not touch these “hot” parts with your bare skin or wet clothing.

⚠ NOTICE

DO NOT TOUCH THE CONTACT TIP WITH THE UNIT TURNED “ON”. TURN THE UNIT OFF BEFORE CHANGING TIPS OR CLEANING THE NOZZLE.

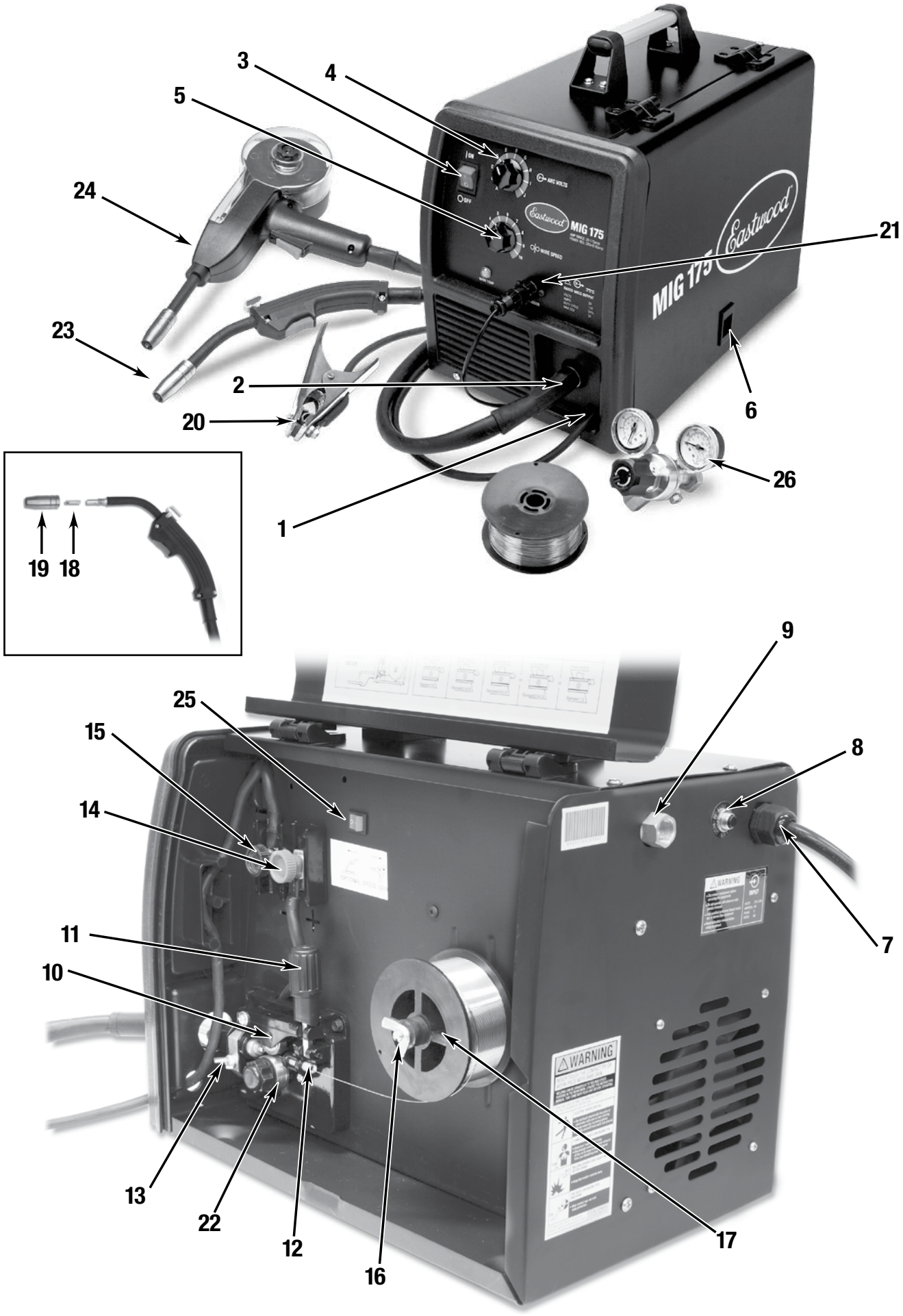
UNPACKING

When unpacking your Eastwood MIG175, check to make sure all of the parts listed below are included:

- MIG175 Welder
- Torch / Gun Cable Assembly
- Spool Gun Assembly
- Ground Cable Assembly
- Gas Flow Regulator
- Gas Hose
- Hand Held Shield
- Wire Brush
- 2lb Spool of 0.030" (0.8mm) Solid Steel MIG Wire
- 1lb Spool of 0.030" (0.8mm) 4043 Aluminum Wire
- 2 Contact Tips
- Contact Tip Wrench
- Instructions
- DVD

COMPONENTS AND CONTROLS

1. Ground Cable Access Hole
2. MIG Gun/Spool Gun Access Hole
3. Power Switch
4. Voltage Control
5. Wire Speed Control
6. Latch
7. Power Cord
8. Breaker Reset Switch
9. Shielding Gas Inlet
10. Rocker Arm
11. Pressure Adjuster
12. Guide Pipe
13. Torch Tensioner
14. Positive Terminal
15. Negative Terminal
16. Wire Tension Thumb Screw
17. Wire Spindle
18. Contact Tip
19. Nozzle
20. Ground Clamp
21. Trigger Connections
22. Drive Roller
23. MIG Torch
24. Spool Gun
25. MIG Gun/Spool Gun Selector Switch
26. Regulator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WARNING

INSTALLATION

INSTALLING THE WELDING GUN

1. Open the side door of the welder and loosen the Torch Tensioner (Fig. 1B) located on the Drive Motor.
2. Slide the brass body of the Welding Gun in through the front of the unit in the designated hole. (Fig. 1A) Be sure to insert until it bottoms against the drive assembly or a gas leak may occur.
3. Connect the black cannon plug to the cannon plug connection on the front of the welder. (Fig. 3A)
4. Tighten the Torch Tensioner (Fig. 1B) finger tight.
5. Switch the selector switch to the Welding Gun position. (Fig. 2B)
   NOTE: Make sure that the gun end is tight against the drive assembly or gas may either leak or not be able to pass through the connections to the end of the Welding Gun.

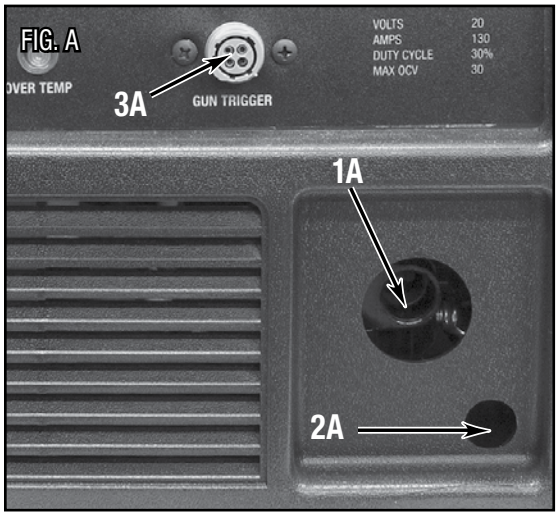
INSTALLING THE GROUND CLAMP

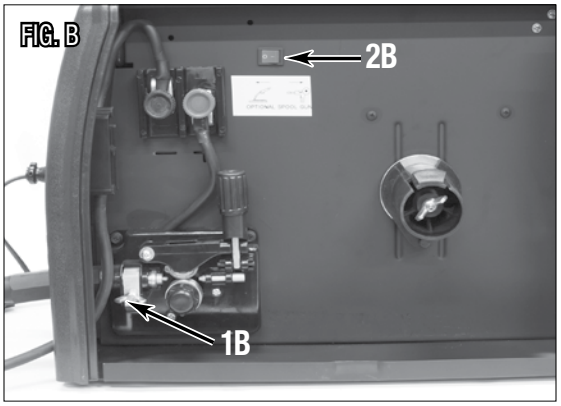
1. Insert the terminal connection of the Ground clamp through the designated hole in the front of the unit. (Fig. 2A)
2. Pull the cable through and route it though the wire loom located on the back side of the front panel. (See Fig. C for routing)
3. Remove the Black Ground Knob and install the wire terminal on the stud.
4. Reinstall the Black Ground Knob and finger tighten.

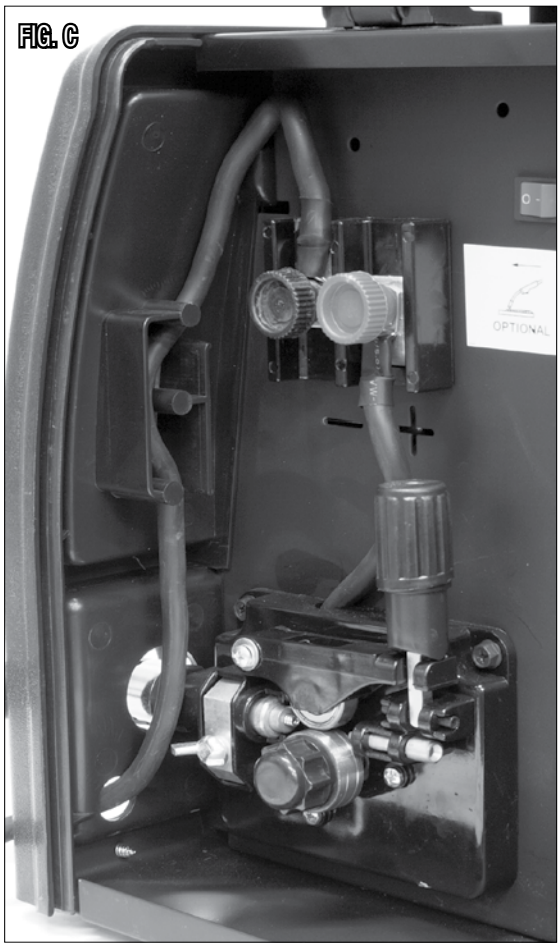
CHANGING POLARITY

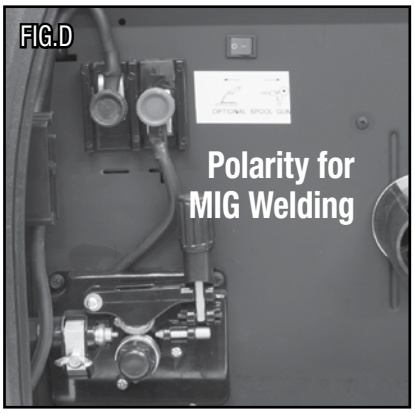
The Eastwood MIG175 comes set up to weld with Solid Wire, to use a Flux Cored wire the Polarity must be changed.

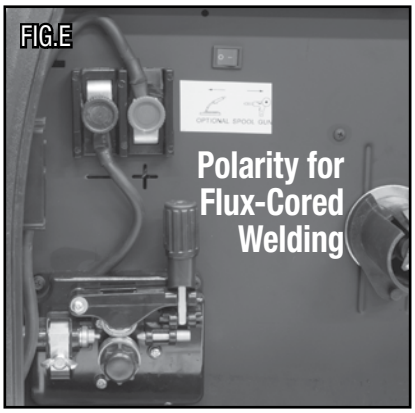
1. Disconnect the wire lead coming from the Drive Motor by removing the Red Positive Knob.
2. Remove the lead from the stud.
3. Remove the Black Ground Knob and its associated lead.
4. Install the lead from the drive motor onto the Negative (-) Stud and replace the Black Ground Knob.
5. Install the lead from the ground clamp onto the Positive (+) Stud and replace the Red Positive Knob.











INSTALLING SHIELDING GAS SUPPLY

A Shielding Gas Bottle is not included with your Eastwood MIG175 but is necessary to welding using Solid Wire, but can be bought at most local Welding Supply Stores. Eastwood recommends the use of 75% Argon / 25% CO2 for shielding gas when MIG welding Steel, 100% Argon for Aluminum, and Tri-Mix (90% He / 7.5% Ar / 2.5% CO2) for Stainless Steel.

1. Place the Eastwood MIG175 in its dedicated area or on a welding cart.
2. Secure your Shielding Gas Bottle to a stationary object or mount to your welding cart if it is equipped to hold one so that the cylinder cannot fall over.
3. Remove the cap from the Shielding Gas Bottle.
4. Insert the large brass male fitting on the Shielding Gas Regulator into the female fitting on the Shielding Gas Bottle.
   NOTE: Do not use White Teflon Tape on this connection as it is a tapered thread and does not require it, if you have a leak check for burrs or dirt in the threads. If the leak persists, use gas type sealing tape.
5. Tighten the fitting with a wrench till snug, do not over tighten.
6. Connect either end of the Gas Line included with your Eastwood MIG175 to the fitting on the regulator and wrench tighten till snug.
7. Connect the other end of the gas line to the fitting on the rear of the Eastwood MIG175 and wrench tighten till snug.
8. Check the gas line for leaks by slowly opening the valve on the gas bottle. When welding the valve on the bottle should always be all the way open.

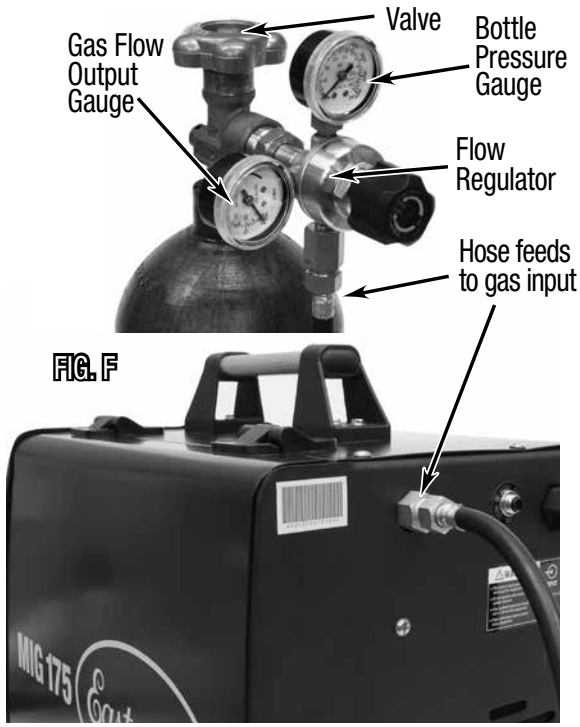


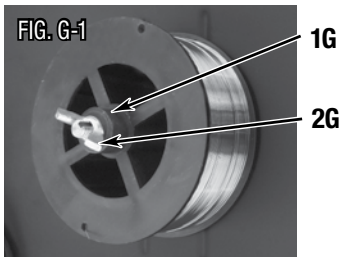
FIG. F

INSTALLING WIRE SPOOL

The Eastwood MIG175 can be used with either a 4"or an 8" Wire Spool. To use the larger 8" spool an included adaptor is necessary.

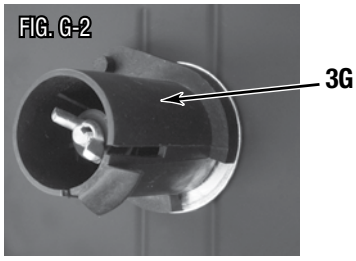
To install a 4" Wire Spool:

1. Open the door of the welder and remove the wing nut (Fig. 2G), spacer (Fig. 1G), and 8in Spool Adaptor (Fig. 3G) from the Wire Spool Spindle.
2. Slide the 4" Wire Spool onto the spindle and reinstall the spacer and the wing nut and place the 8in Spool Adaptor (Fig. 3G) in a safe place if it is needed in the future.
3. To set the tension on the wire, tighten the wing nut till there is a slight resistance to spinning the wire spool on the spindle. If the tension is set too loose the wire spool will spin on the shaft and unspool all of the wire. If the tension is too tight, the drive roller will have issues pulling the wire off the spool and some slipping may occur.
   NOTE: Hold exposed wire end to keep the spool from unraveling.



To install an 8" Wire Spool:

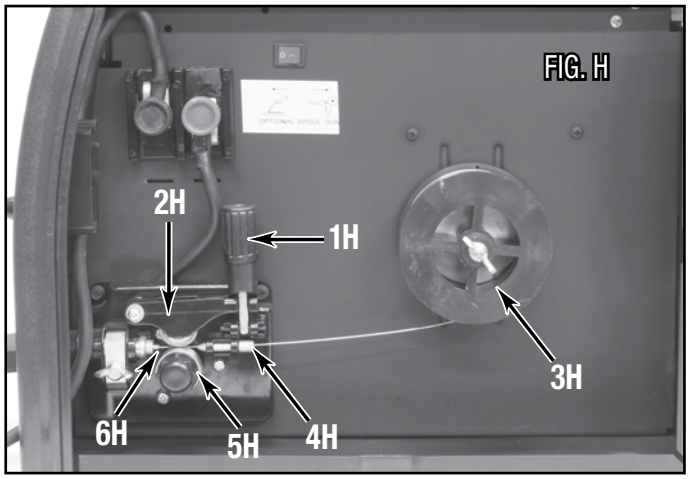
1. Open the door of the welder and remove the wing nut, spacer, and 8" Spool Adaptor from the Wire Spool Spindle.
2. Slide the 8" Wire Spool Adaptor into the center of the wire spool.
3. Slide the 8" Wire Spool Adaptor with the wire spool installed onto the spindle and reinstall the spacer and the wing nut.
4. To set the tension on the wire, tighten the wing nut till there is a slight resistance to spinning the wire spool on the spindle. If the tension is set too loose the wire spool will spin on the shaft and unspool all of the wire. If the tension is too tight, the drive roller will have issues pulling the wire off the spool and some slipping may occur.



CONNECTING THE WELDER TO A POWER SOURCE

The Eastwood MIG175 welder requires a dedicated 220 VAC 30 Amp grounded outlet protected by a time delay breaker. The MIG175 is equipped with a NEMA 6-50P Plug which requires a NEMA 6-50R outlet to be connected.

THREADING WELDING WIRE THROUGH THE DRIVE MOTOR TO THE WELDING GUN



1. Unlock the Pressure Adjuster (Fig. 1H) on the wire tensioner and lift up the rocker arm (Fig. 2H). Insure that the wire drive wheel is appropriate to the welding wire size, see above describing the installation to wire feed roller installation.
2. Pull out the welding wire (Fig. 3H) from the welding wire spool carefully. **NOTE:** Do not let go of the wire prior to step 5 or the entire spool will unravel and be useless.
3. Cut off the small piece of the curved segment at the front of welding wire and straighten the welding wire approximately 3.0" long.
4. Thread the welding wire through the guide pipe (Fig. 4H) and over the wire feed roller (Fig. 5H) and into the torch hole (Fig. 6H).
5. Reattach the rocker arm (Fig. 2H) and reset the Pressure Adjuster (Fig. 1H) on the wire feeder (now the welding wire can be fed smoothly).
6. Remove the contact tip and nozzle from the MIG Gun.
7. Turn on the machine and set the wire speed about 1/2 on the scale.
8. With the gun pointed away from you and others, depress the trigger to begin feeding wire. **NOTE:** Watch the drive roller to see if any slipping is occurring between the roller and the wire—if so turn the machine off and tighten the Pressure Adjuster

1. 1⁄4 turn and test again.
2. You do not want too much tension on the tension roller as it will tend to deform the wire. Just enough to feed the wire without slipping
3. Once the wire has emerged from the tip of the gun, turn the machine OFF and replace the tip and nozzle.

SHIELDING GAS FLOW ADJUSTMENT

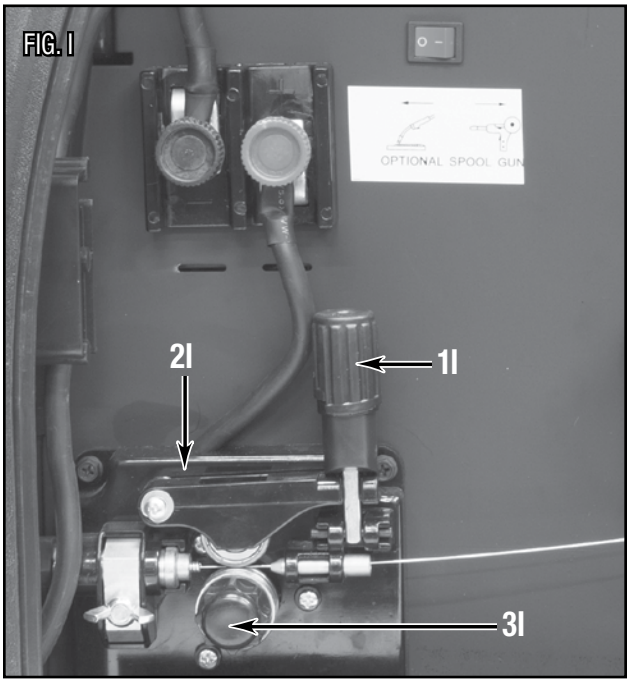
After connecting your Shielding Gas Regulator, the gas flow rate needs to be adjusted so that the proper amount of Shielding Gas is flowing over your weld. If there is too little gas flow there will be porosity in your welds as well as excessive spatter, if there is too much gas flow you will be wasting gas and may affect the weld quality. The included regulator has 2 gauges on it; the gauge on the left is your flow rate while the gauge on your right is your tank pressure.

1. Open your Shielding Gas tank valve all the way.
2. Adjust the knob on the regulator to ~30 CFH.
3. Turn on the welder and trigger the torch switch which will start the gas flow.
4. As you trigger the torch switch you will notice that as the gas flow starts the needle on the gauge drops to a steady reading. The reading while flowing is the value you want to read.
5. The gas flow should be set to ~20CFH while flowing. The CFH (Cubic Feet per Hour) scale is the inside scale in red on your flow gauge. 20CFH is the most typical flow rate but it may need to be adjusted in some cases depending if there is a slight breeze or some other instance where additional shielding gas is required to prevent porosity in the weld.
6. When finished welding remember to close the gas valve on the bottle.

CHANGING THE DRIVER ROLLER

The wire feed drive roller on the drive motor has 2 grooves, one for 0.023” (0.6mm) welding wire and another for 0.030” (0.8mm) or 0.035” (0.9mm) welding wire. Your MIG175 comes with the drive roller pre installed for using 0.030” (0.8mm) wire. In the event that 0.023” welding wire is to be used, the wire feed roller needs to be changed.

1. Turn off the welder and unplug the welder from power.
2. Unlock the Tensioner (Fig. 1I) by pulling it towards you.
3. Lift the Rocker Arm (Fig. 2I) up and rotate out of the way.
4. Remove the star knob (Fig. 3I) by loosening it by hand.
5. Slide the drive roller off the shaft.
6. Determine which size wire is going to be used and slide the drive roller back onto the shaft by aligning the key on the shaft with the keyway on the roller.



NOTE: The stamped marking on the side of the drive roller indicates the size of the groove on the opposite side of the roller. The groove closest to the drive motor is the groove that will be used. If setting up to use 0.023” (0.6mm) wire, the ‘0.6’ stamping should be facing the user when installing it.

7. Tighten the star knob finger tight.
8. Push the rocker arm back down into place.
9. Lift up on the Tensioner to put back in place and adjust as necessary.

INSTALLING THE SPOOL GUN

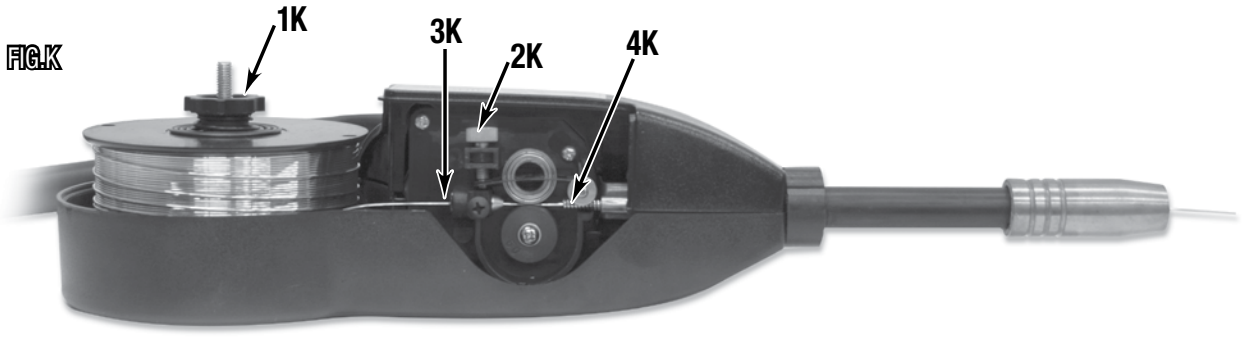
1. Turn off welder and unplug from power source.
2. Switch the selector switch to the Spool Gun position.
3. Open the side door of the welder and loosen the Torch Tensioner located on the side of the drive roller. If the standard welding gun is installed remove it and its associated connector.
4. Slide the brass body of the Spool Gun in through the front of the unit in the designated hole as shown in Fig. J. Be sure to insert until it bottoms against the drive assembly or a gas leak may occur.
5. Connect the black cannon plug to the cannon plug connection on the front of the welder.
6. Tighten the Torch Tensioner finger tight.
7. Set the Selector Switch to “Spool Gun” (Fig. 1J)

FIG.J

THREADING WELDING WIRE THROUGH THE SPOOL GUN

1. Turn off welder and unplug from power source.
2. Set the switch above the drive motor to the spool gun setting. (Fig. 1J)
3. Remove the thumb screw and clear plastic wire spool cover.
4. Remove the thumb screw and spring tensioner that holds the wire spool on. (Fig. 1K)
5. Place wire spool on spindle and replace the thumb screw with spring tensioner and tighten till the point that the spool has some tension on it.
6. Loosen the Brass Tensioner Thumb Screw (Fig. 2K) until it is possible to feed the welding wire through the drive roller grooves.
7. Feed the wire by hand from the spool into the inlet guide, (Fig. 3K) past the drive rollers and into the wire inlet. (Fig. 4K)
8. Tighten the Brass Tensioner Thumb Screw (Fig. 2K) until it applies light pressure onto the welding wire. If this is too tight it will deform the wire and cause feeding issues, if it is too loose the drive roller will slip on the wire.
9. Remove the nozzle and contact tip.
10. Replace the wire spool cover.
11. Plug in welder to your power source and turn on the welder.
12. Trigger the Spool Gun to feed the wire and adjust the Brass Tensioner Thumb Screw (Fig. 2K) so that the wire does not slip.
13. Replace Contact Tip and Nozzle.

FIG.K



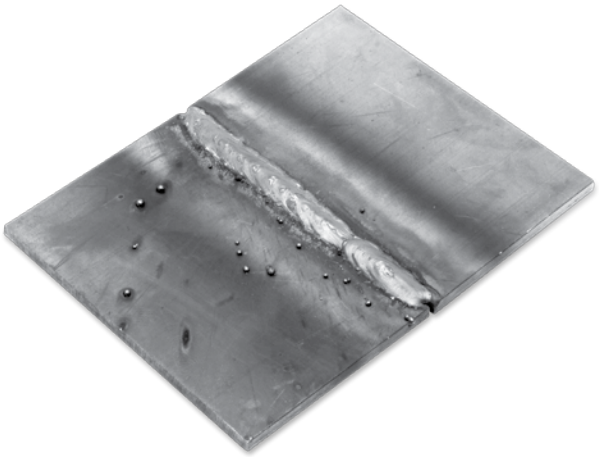
OPERATION

WELDING PROCESS

Your Eastwood MIG175 can be used to form a large number of different joints and welds all of which will require practice and testing before using on an actual project piece. This following welding process is just a baseline to get you started.

1. Refer to the 'Suggested Settings' chart which is located inside the side door of your Eastwood MIG175 as well as below in the instruction manual. From the chart select your baseline starting point for the recommended settings described in the chart.
2. Change the output polarity if necessary according to the welding wire's specifications. This welder comes set up to use Solid MIG wire, if using Flux Cored wire, the polarity will need to be changed.
3. Connect your ground clamp to the work pieces that are to be welded. Make sure the ground clamp contacts are placed on a clean piece of metal free of paint, grease, rust, oils, etc. It is recommended to place your ground clamp as close to the weld area as possible.
4. Assess your weld area and make sure the welding area is also cleaned of any paint, grease, rust, oils, etc.
5. Plug in the welder and switch to the ON position.
6. Open your gas valve on the bottle and adjust the flow rate if necessary.
7. Depress the torch trigger pointing the welding gun away from your body and then let go of the trigger and cut the wire back to ~1/4" stick out length.
8. Wearing your welding helmet, gloves, and long sleeve shirt and pants, put the end of the wire sticking out of the gun into the joint to be welded.
9. Position the welding gun so that it is perpendicular to the base metal with ~20° tilt back.
10. Depress the trigger to start the wire feed which starts the arc. **NOTE:** A push, perpendicular, or drag technique can be used to weld the pieces together; the type used depends on the type of joint as well as other influential conditions.
11. Once you depress the trigger and the arc has started, you will notice a molten puddle will form; this puddle is the weld bead and will follow the motion of the welding torch. Watching the size of the puddle dictates how fast you should be moving with the torch. If you burn through the material you are either moving to slow or you need to make some setting adjustments to the welder settings. If you're not penetrating the base metal you're either moving too fast or you need to make adjustments to the welder settings.
12. Release the trigger on the welding gun to stop the weld.
13. After finished welding, close the valve completely on the Shielding Gas Bottle.

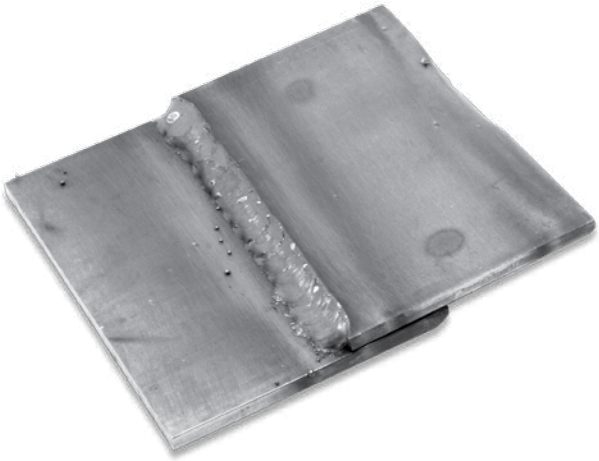
TYPES OF WELD JOINTS



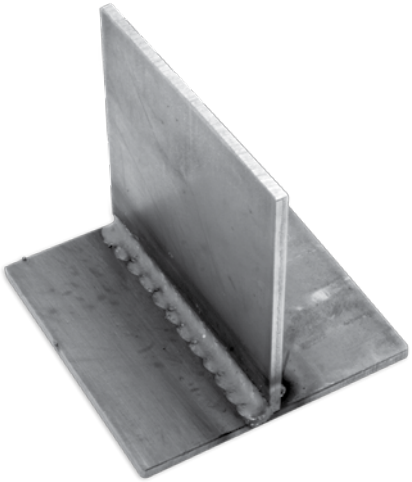
1. **Butt Weld** is a joint between two pieces that are laying in the same direction.

2. **Corner Weld** is a joint between two pieces that meet at or near perpendicular at their edges.

3. **Edge Weld** is a joint between two pieces where the edges are being joined.



4. **Lap Weld** is a joint between two overlapping pieces.



5. **Tee Weld** is a joint between two pieces where one is perpendicular to the other.

6. **Plug Weld** is a joint which joins two overlapping pieces by filling in a hole punched in the top piece.

SHEET METAL WELDING TECHNIQUES

When welding sheet metal a different approach is usually taken to account for how thin the metal is and it's susceptible to warping it is. The technique most often used is called Stitch Welding and this process is described below:

1. Clean the metal to be welded of any paint, rust, oil, grease, dirt or any other contaminants that may be on the surface of the piece.
2. Secure the pieces to be welded in place using clamps. Be sure to leave a small gap between the two pieces of sheet metal for the weld to flow into, this will result in a lower bead height which will require minimal finishing.
3. Consult the Suggested Settings Chart and set the Voltage and Wire Speed knobs appropriately.
4. Get some pieces of scrap metal of the same thickness and verify that the settings will work for the specific weld you will be making.
5. Once the settings have been fine tuned tack weld your final pieces in places and remove the clamps if they are in the way of the weld.
6. The Stitch Welding technique can now be utilized which is basically a series of tacks connecting together. To perform the technique, trigger the gun to form a tack weld and then continue to trigger on and off the gun making a series of connected tack welds following along the path of the weld joint. Continue the series of tacks for an inch or so and then move to a different section of the weld and perform the process there. It is essential to keep moving around to spread out the heat making sure not to get one section too hot and warp the metal.
7. Once the entire weld has been completed allow the metal to cool. If necessary follow up with a flap disc to grind the weld bead flush.

HEAVY GAUGE METAL WELDING TECHNIQUES

When welding sheet metal, a different approach is usually taken to account for how thin the metal is and it's susceptible to warping it is. The technique most often used is called Stitch Welding and this process is described below:

1. Clean the metal to be welded of any paint, rust, oil, grease, dirt or any other contaminants that may be on the surface of the piece.
2. Secure the pieces to be welded in place using clamps. Be sure to leave a small gap between the two pieces of metal for the weld to flow into, this will result in a lower bead height which will require minimal finishing.
3. Consult the Suggested Settings Chart and set the Voltage and Wire Speed knobs appropriately.
4. Get some pieces of scrap metal of the same thickness and verify that the settings will work for the specific weld you will be making.
5. Once the settings have been fine-tuned tack weld your final pieces in places and remove the clamps if they are in the way of the weld.
6. When welding heavy gauge metal there are two basic approaches to creating the weld. The first is a continuous bead with steady gun movement along the length of the joint. The second type of weld is a Stringer or Weave bead. This is accomplished by moving the torch in a circular or zig zag pattern. Either of these techniques will create strong welds but in some cases the Stringer or Weave type will create a more aesthetically appeasing weld bead.
7. Once the entire weld has been completed, allow the metal to cool. If necessary, follow up with a flap disc to grind the weld bead flush.

OVERLOAD PROTECTION

Your Eastwood MIG175 is equipped with a temperature controller as well as an overload breaker. These two protection devices will protect your welder if the duty cycle is exceeded. If the output is exceeded, the internal breaker will trip and stop power supply to the drive motor although the fan will still run to cool the unit.

If the breaker tripped resulting from an overload, the circuit breaker button on the rear of the welder will extend out. This circuit breaker must be reset manually. Before resetting the circuit breaker button allow the welder to cool for a minimum of 15 minutes.

If there is no voltage output and the circuit breaker was not tripped, the internal thermal protector may have shut off the welder until it cools to normal operating temperature. This is an automatic function and does not require the user to manually reset anything.

TROUBLESHOOTING

Problem	Cause	Corrective Action
Burn Through	High Voltage	Adjust voltage output to lower setting
	Fast Wire Speed	Adjust wire speed to slower setting
	Slow Gun Travel	Increase your travel speed with the welding gun
Lack of Penetration	Low Voltage	Adjust voltage output to higher setting
	Slow Wire Speed	Adjust wire speed to faster setting
	Fast Gun Travel	Slow your travel speed of the welding gun making sure to pull or drag the molten metal puddle.
	Excessive Wire Stick Out	Move the contact tip on the welding gun closer to the work piece to shorten the length of exposed welding wire.
	Material Too Thick	The MIG175 is rated for a maximum thickness of 1/4", exceeding this will results in poor penetration.
	Poor Material Preparation	If welding heavy gauge metals it may be necessary to increase the welding gap between the two pieces and also bevel the edges on the weld side of the pieces.
Excessive Penetration	High Voltage	Adjust voltage output to lower setting
	Fast Wire Speed	Adjust wire speed to slower setting
	Slow Gun Travel	Increase your travel speed with the welding gun
Warping	Lack of Tack Welds	Tack weld the pieces in multiple areas to keep the pieces from pulling apart.
	No Clamping	Use welding clamps to secure the pieces in their proper shape.
	Poor Technique	To prevent warping allow the piece to cool after welding small sections at a time. Move your welding areas around by not completely all the welding in one section all at once rather welding a small amount in one area and then move to another to spread out the heat in the piece.

TROUBLESHOOTING

Poor Fusion	Low Voltage	Adjust voltage output to higher setting
	Slow Wire Speed	Adjust wire speed to faster setting
	Dirty Base Metal	Remove all paint, rust, oil, grease, dirt or any other contaminants that may be on the surface of the piece.
	Excessive Wire Stick Out	Move the contact tip on the welding gun closer to the work piece to shorten the length of exposed welding wire.
	Cold Base Metal	If welding on a large piece, particularly cast pieces, which will absorb a lot of heat, it may be necessary to pre heat your part with a torch.

Porosity	Poor Shielding Gas	Increase the flow rate of the shielding gas. If the bottle is getting low and porosity is starting to form in the welds, it means that the bottle needs to be refilled. Take note of any cross winds that may be blowing the shielding gas away from the welding zone.
	Wrong Shielding Gas	Make sure that you are using a 75% Argon / 25% CO2 Shield Gas on steel and 100% Argon on Aluminum.
	Dirty Base Metal	Remove all paint, rust, oil, grease, dirt or any other contaminants that may be on the surface of the piece.
	Excessive Wire Stick Out	Move the contact tip on the welding gun closer to the work piece to shorten the length of exposed welding wire.

Excessive Spatter	Fast Wire Speed	Adjust wire speed to slower setting
	Dirty Base Metal	Remove all paint, rust, oil, grease, dirt or any other contaminants that may be on the surface of the piece.
	Poor Shielding Gas	Increase the flow rate of the shielding gas. If the bottle is getting low and porosity is starting to form in the welds, it means that the bottle needs to be refilled. Take note of any cross winds that may be blowing the shielding gas away from the welding zone.
	Wrong Shielding Gas	Make sure that you are using a 75% Argon / 25% CO2 Shield Gas on steel and 100% Argon on Aluminum.
	Wrong Welding Wire	Check wire for type and make sure it is appropriate for the material and process being used.
	Excessive Wire Stick Out	Move the contact tip on the welding gun closer to the work piece to shorten the length of exposed welding wire.

ACCESSORIES

CONSUMABLE PARTS

- **12211 –** 0.023” / 0.6mm Contact Tips (5 Pack)
- **12224** – 0.030” / 0.8mm Contact Tips (5 Pack)
- **12210** – Nozzle
- **12226** – 0.023” Solid MIG Wire, 2lbs, 4” Spool
- **12227** – 0.030” Solid MIG Wire, 2lbs, 4” Spool
- **12225** – 0.030” Flux Cored Wire, 2lbs, 4” Spool

OPTIONAL PARTS

- **12236** – Welding Cart
- **11616** – Deluxe MIG / TIG / Plasma Welding Cart

APPAREL

- **13203** – Auto Darken Welding Helmet
- **13212** – Large View Auto Darken Welding Helmet
- **12957** – Welding Helmet Bag
- **12589 / 12590** – Top Grain Cowskin 4” Cuff Welding Gloves (M/L)
- **12762** – L/XL/XXL Welding Jacket

REPLACEMENT PARTS

Call Eastwood Customer Service at 1-800-343-9353 for assistance with replacement parts.