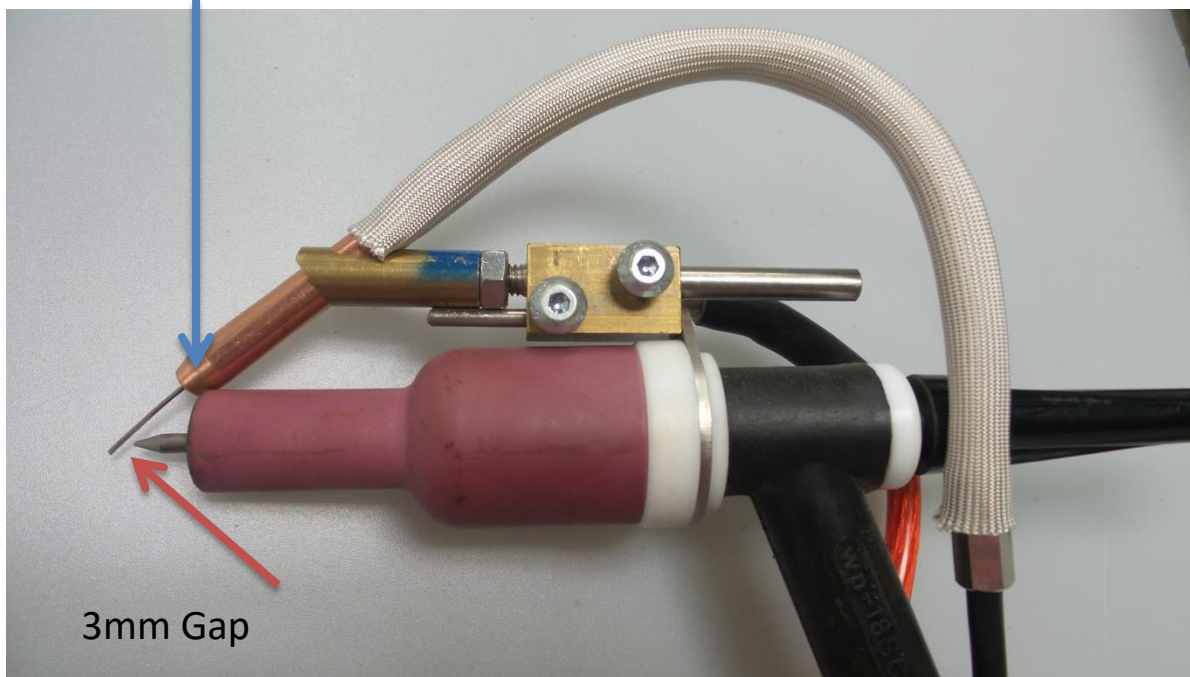


TIP TIG Proper Configuration for Fillet Weld Applications

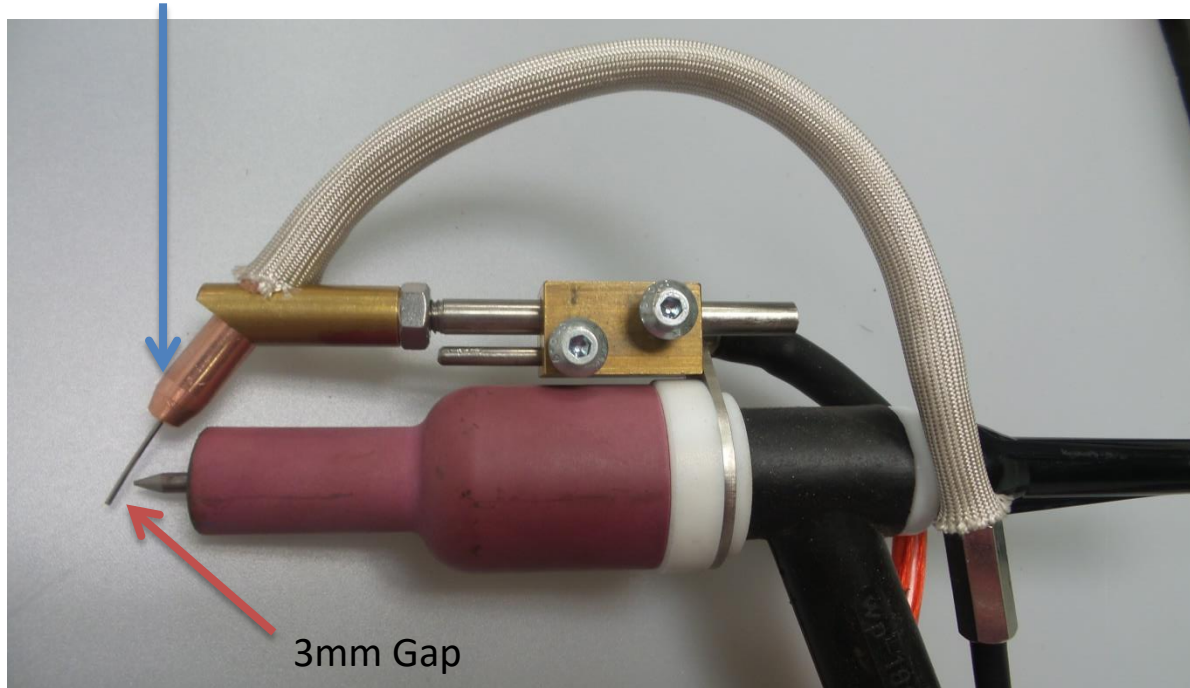
Contact Tip Placement



- Use the 39deg Blue Block.
- Use Tungsten with 30 deg bevel and a .010 Flat.
- Make sure the Contact Tip is on the leading edge of nozzle as shown in blue.
- Keep a 3mm gap with the wire to tungsten as shown in red.
- If you are changing the wire direction from the 12 O'clock position on the torch, adjust the tip to the desired location, adjust wire with 3mm gap, then run out wire approx. 12 inches until the cast is out and wire is on top of tungsten.

TIP TIG Proper Configuration for Pipe Weld Applications

Contact Tip Placement



- Use the 42deg Red Block.
- Use Tungsten with 30 deg bevel and a .010 Flat.
- Make sure the Contact Tip is on the leading edge of nozzle as shown in blue.
- Keep a 3mm gap with the wire to tungsten as shown in red.
- If you are changing the wire direction from the 12 O'clock position on the torch, adjust the tip to the desired location, adjust wire with 3mm gap, then run out wire approx. 12 inches until the cast is out and wire is on top of tungsten.