Welding quick start guide

DENALIWELD INC.

Fill Chiller

- Fill the chiller with provided funnel using distilled or purified water.

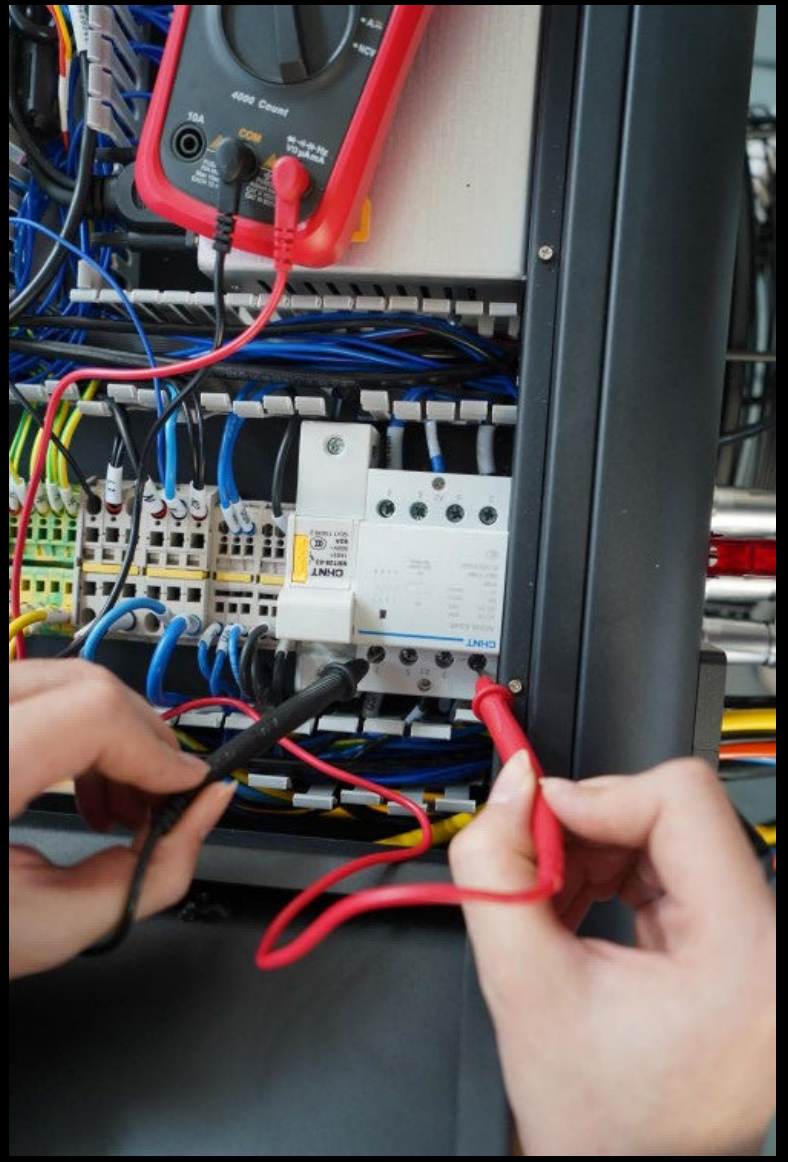
Approximately 4-5 gallons.

Fill until water level reaches the top 1/3 of the green normal range

Connect power

- Power supply is single phase 220
- Only turn on main power switch on back of machine

- Ensure power is 220v (+/- 10%)



Wire feeder signal cable and conductive clip

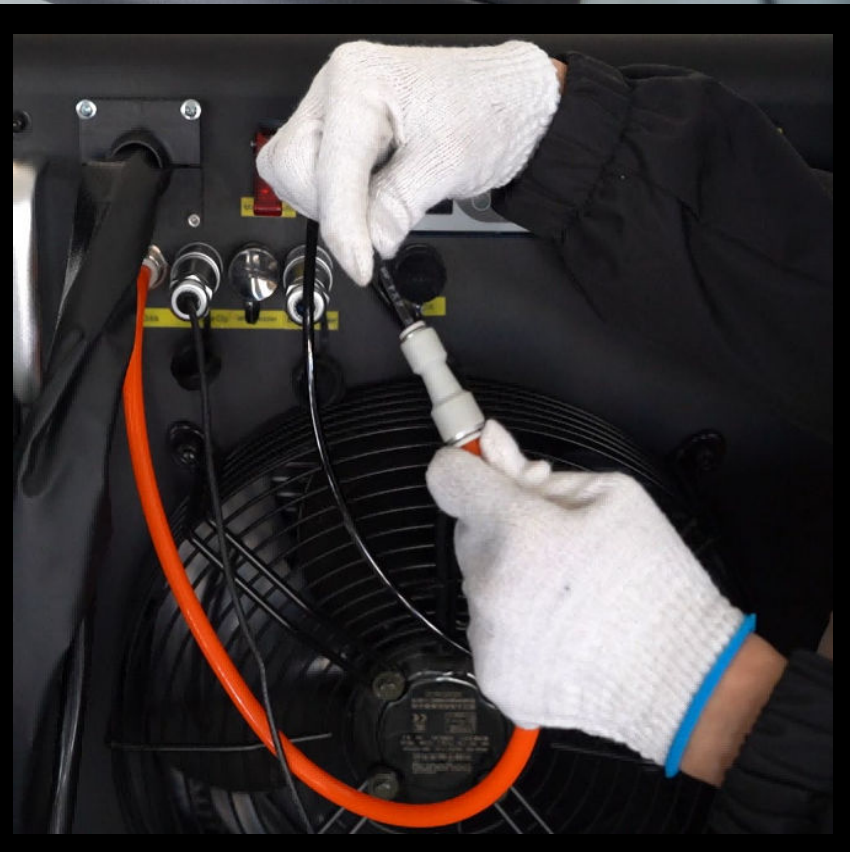
- Connect the wire feeder signal cable to the back of the wire feeder and the back of the machine as indicated by labels
- Connect conductive clip to back of welding machine and to work piece or welding table

Pictured are connection points on the back of welding machine

Turn on machine and connect gas

- Twist red emergency stop button and turn the key to on position

- Connect gas supply to back of machine and set flow rate



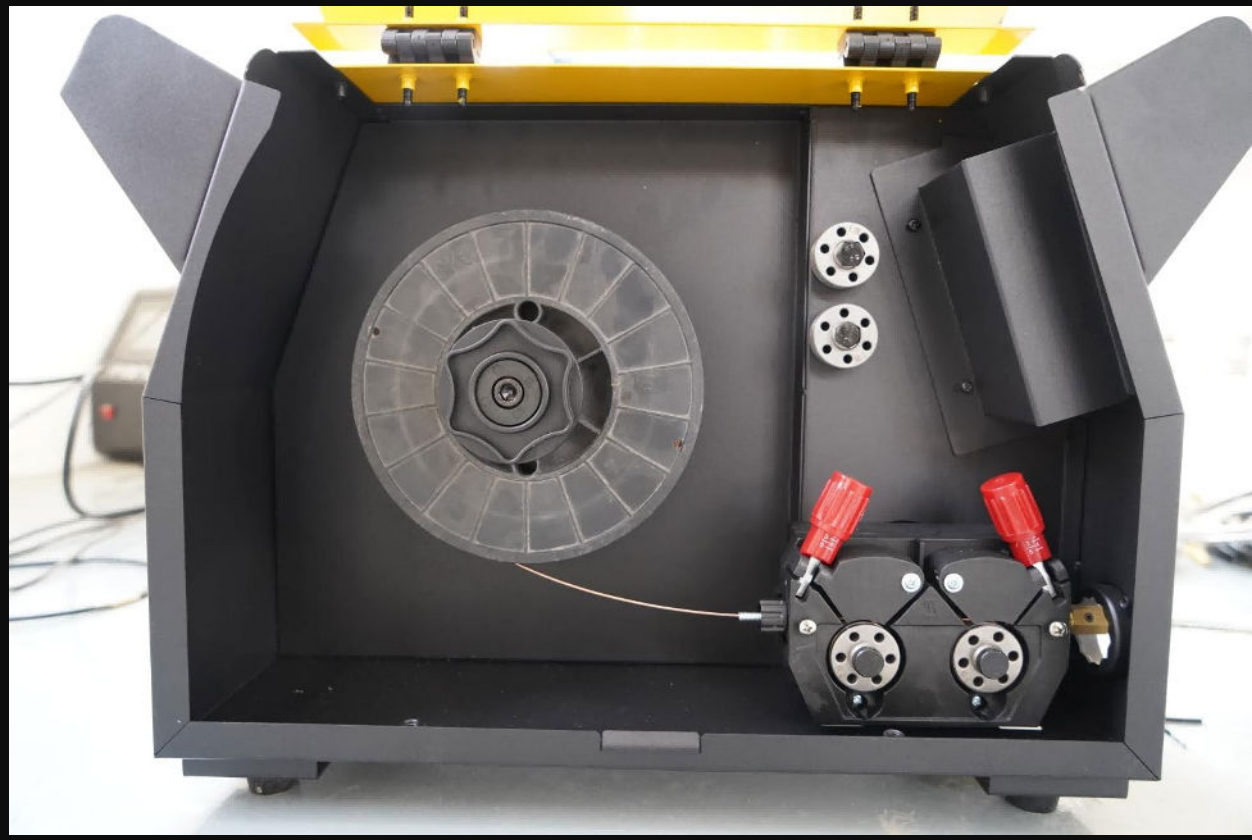
	Mpa	bar	L/min	Psi	cfh	ipm
welding	0.2-0.3	2-3	25-30	20-25	52ft3/h-63ft3/h	1525in3/min-1830in3/min
Weld cleaning	0.2-0.3	2-3	25-30	20-25	52ft3/h-63ft3/h	1525in3/min-1830in3/min
cutting	0.3-0.4	3-4	30-35	25-30	64ft3/h-74ft3/h	1831in3/min-2135in3/min
cleaning	0.3-0.4	3-4	30-35	25-30	64ft3/h-74ft3/h	1831in3/min-2135in3/min

Wire feeder

Add a spool of preferred filler metal to the wire feeder

Ensure drive wheels are of proper size and material.

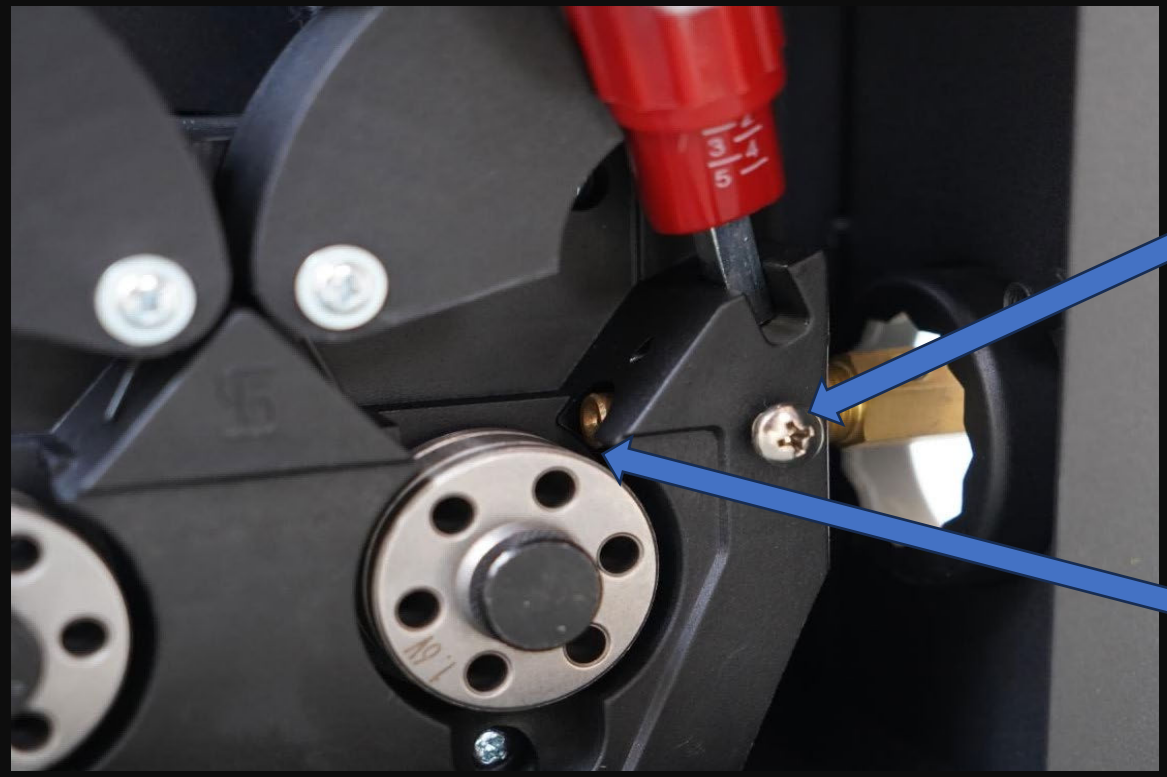
V drive wheels are designed for steel/stainless steel filler metals while the U drive wheels are designed for aluminum.



Wire feeder continued

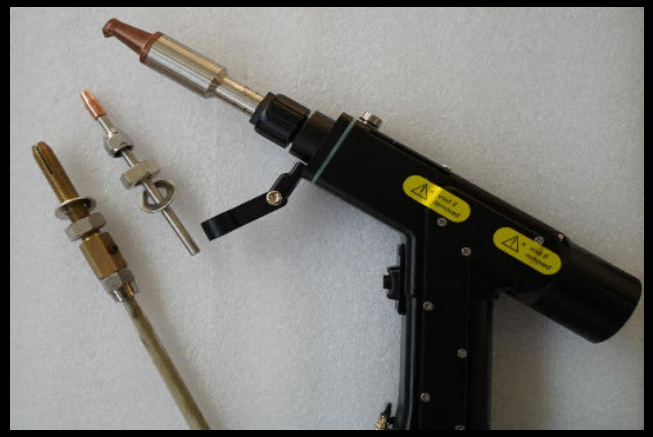
- Pictured is a wire feeder set up for steel. Drive wheel tension is set to 3.
- On the face of the drive wheel is a number indicator for the size of the wire. In this case 1.6 v is showing which means that the v groove on the rollers far side is suitable for 1.6 mm wire

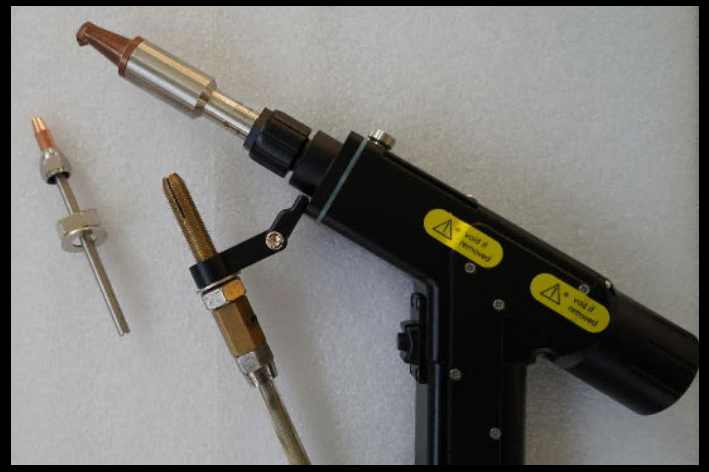
Wire feeder continued

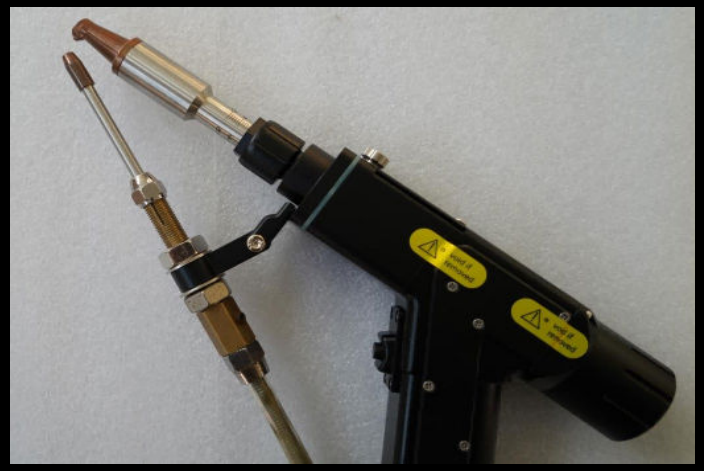


- Connect wire feeder tube to wire feeder with Phillips screw seen here

Make sure there is some space between wire feeder tube end and drive wheel as seen here







Wire feeder tube

- Ensure wire feeding tube is kept as straight as possible, especially when using aluminum.
- Connect wire feeding tube to welding gun.

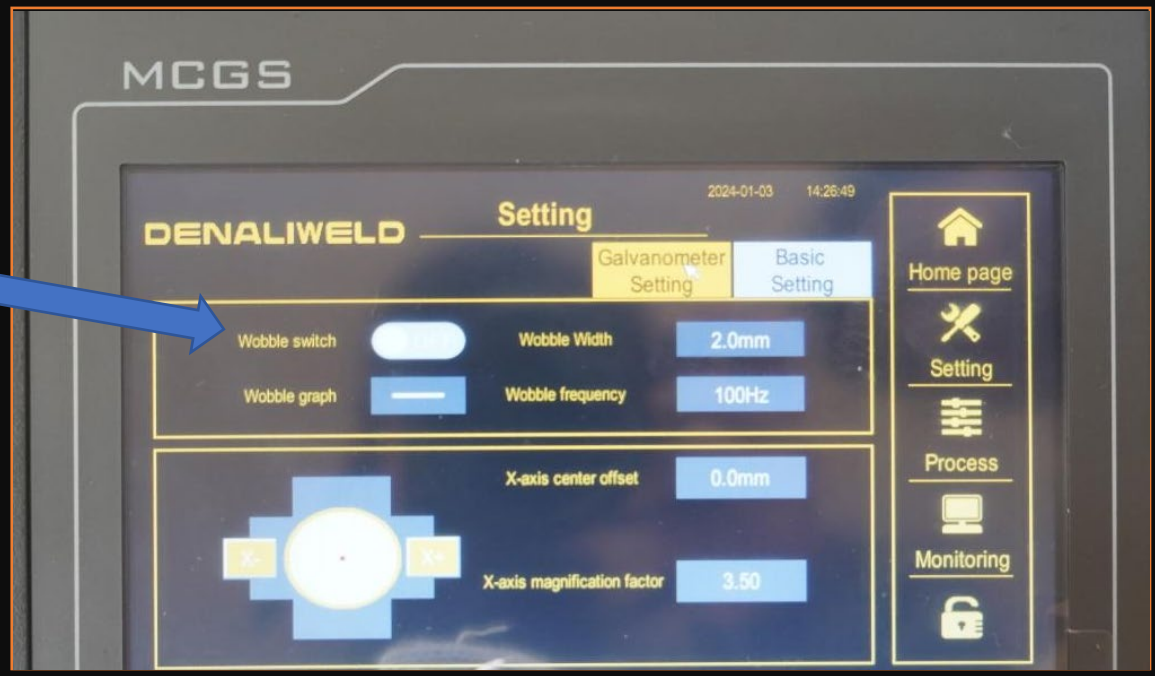
Galvo settings

- When machine is turned on there are still a few steps to take to ensure welding machine performs properly
- Always ensure the red light is centered on your filler metal
- If it is not centered these are the steps to fix it.
- 1st go to settings, then galvo settings

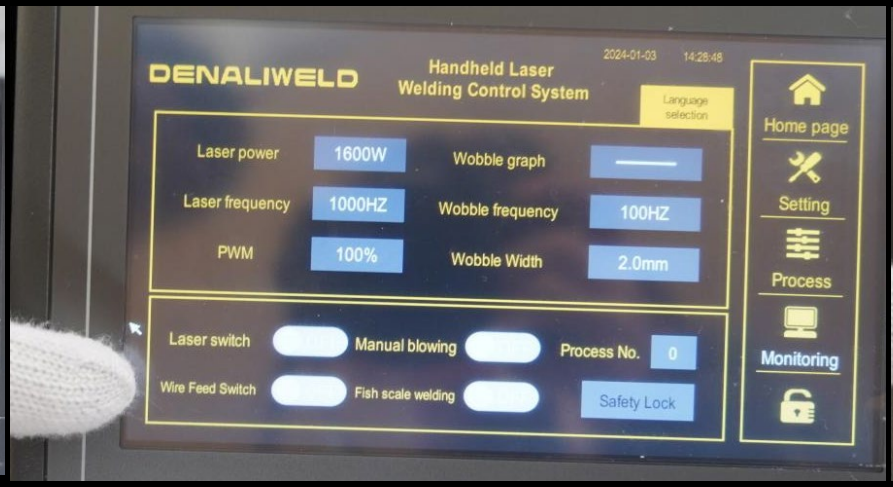
Galvo settings (continued)

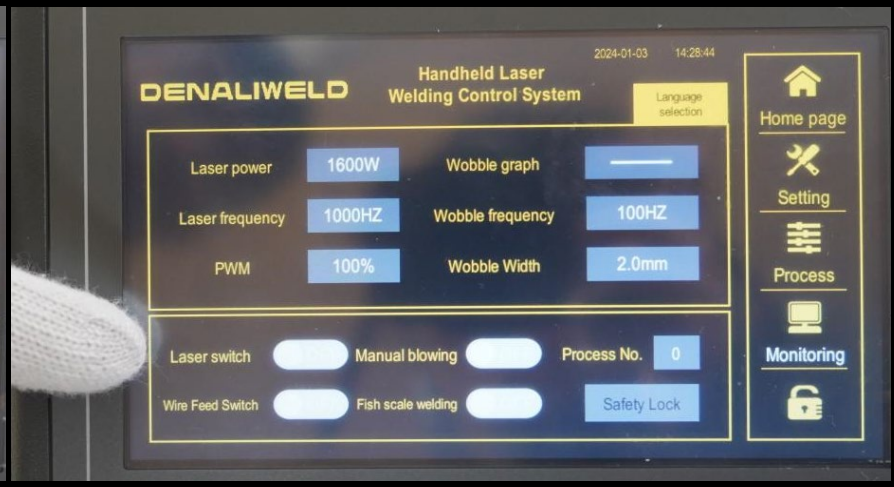
In galvo settings you can adjust the axis of the red light. Adjust them until the red light is visually centered on the filler metal. This should be done any time the machine is turned off or if you are away from the machine for any amount of time including breaks and lunch.

The wobble function is also in this menu to ensure this is done daily. When in this menu turn on the bobble setting.



Gas, wirefeeding, and laser





Toggle gas manual to on position to ensure gas flow. Then turn off (you will audibly hear this)

Toggle wire feeding to on position

Toggle laser to on position