

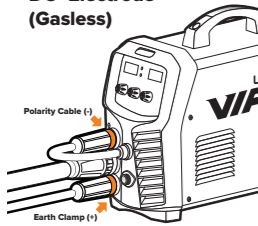
VIPER 185

Welding Setup Guide

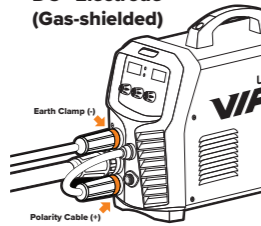


Polarity: MIG

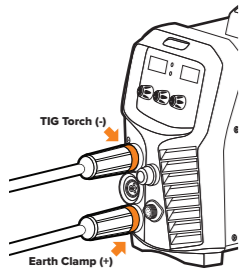
DC- Electrode (Gasless)



DC+ Electrode (Gas-shielded)

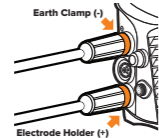


Polarity: TIG

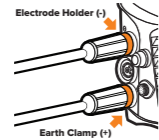


Polarity: Stick

DC+ Electrode



DC- Electrode



Please refer to electrode packaging for correct polarity settings.

MIG Setup Guide

Material Type	Wire Type	Wire Size	Drive Roller	Polarity	Shielding Gas	Gas Flow Rate	Material Thickness	1mm	2mm	3mm	4mm	6mm	8mm
Steel	ER70S-6	0.8mm	V Groove	DCEP+	ArCO ²	8-12L/min	Voltage (V)	15	18	20	21	23	23
							Wire Speed (m/min)	5	7.5	8.5	9	12	13
	ER70S-6	0.9mm	V Groove	DCEP+	ArCO ²	8-12L/min	Voltage (V)	/	18	18.5	19	22	23
							Wire Speed (m/min)	/	6	7	7.5	11	13
Stainless Steel	E71T-11	0.8mm	F Groove (Knurled)	DCEN-	/	/	Voltage (V)	14	17	21	22	23	/
							Wire Speed (m/min)	3.5	5.5	8.5	9	11	/
	E71T-11	0.9mm	F Groove (Knurled)	DCEN-	/	/	Voltage (V)	15	18	19	20	22	23
							Wire Speed (m/min)	4	5	5.5	6	8	9
Aluminium	316LSi	0.8mm	V Groove	DCEP+	ArCO ²	8-12L/min	Voltage (V)	12	13	14.5	16	17	19
							Wire Speed (m/min)	7	8	9	10	11	15
	316LSi	0.9mm	V Groove	DCEP+	ArCO ²	8-12L/min	Voltage (V)	/	13	14.5	16	18	20
							Wire Speed (m/min)	/	7	8	9	10	14
Aluminium	5356	1.0mm	U Groove	DCEP+	Ar	8-12L/min	Voltage (V)	/	11	12	13	17	18
							Wire Speed (m/min)	/	9	10	11	14	16

TIG Setup Guide (Pure Argon Gas / DC- Polarity)

Tungsten Diameter	Filler Rod	Material	1.6mm	3.2mm	4.8mm	6.0mm
1.6mm	1.6mm	Steel	60-90A	80-115A	/	/
		Stainless	40-70A	65-110A	/	/
2.4mm	2.4mm	Steel	/	/	115-165A	/
		Stainless	/	/	100-150A	/
3.2mm	2.4mm	Steel	/	/	/	160-200A
		Stainless	/	/	/	135-180A

Stick Setup Guide

Material Type	Electrode Type	Electrode Thickness	2.5mm	3.2mm	4.0mm
Steel	HYPERARC™ GP 6013	Amperage Range (A)	50-90A	90-130A	110-170A
		Polarity	DCEP+		
Steel	HYPERARC™ 16TC	Amperage Range (A)	50-90A	80-130A	110-180A
		Polarity	DCEP+		
Stainless Steel	HYPERARC™ 316L	Amperage Range (A)	50-90A	70-110A	100-150A
		Polarity	DCEP+		

Drive Rollers

SKU	Description
0.6-0.8V30/22	Drive Roll V Groove 0.6-0.8mm
0.8-1.0V30/22	Drive Roll V Groove 0.8-1.0mm
0.9-1.2V30/22	Drive Roll V Groove 0.9-1.2mm
1.0-1.2V30/22	Drive Roll V Groove 1.0-1.2mm
0.8-0.9F30/22	Drive Roll Knurled 0.8-0.9mm
0.9-1.2F30/22	Drive Roll Knurled 0.9-1.2mm
0.8-1.0U30/22	Drive Roll U Groove 1.0-1.2mm
0.9-1.0U30/22	Drive Roll U Groove 0.9-1.0mm
0.9-1.2U30/22	Drive Roll U Groove 0.9-1.2mm
1.0-1.2U30/22	Drive Roll U Groove 1.0-1.2mm

Please refer to operating manual for more detailed information.

SB15 MIG Torch Spares

SKU	Description	QTY
PCTH15	TIP HOLDER	2
PGNS15	NOZZLE SPRING	2
PCT0008-06	CONTACT TIPS - Steel 0.6mm	10
PCT0008-08	CONTACT TIPS - Steel 0.8mm	10
PCT0008-09	CONTACT TIPS - Steel 0.9mm	10
PCT0008-10	CONTACT TIPS - Steel 1.0mm	10
PCT0008-12	CONTACT TIPS - Steel 1.2mm	10
PCTAL0008-09	CONTACT TIPS - Aluminium 0.9mm	10
PCTAL0008-10	CONTACT TIPS - Aluminium 1.0mm	10
PCTAL0008-12	CONTACT TIPS - Aluminium 1.2mm	10
PGN15CON	GAS NOZZLE - Conical	2
PGN15CYL	GAS NOZZLE - Cylindrical	2
PGN15SPOT	GAS NOZZLE - Spot	2
PGN15TAP	GAS NOZZLE - Tapered	2

Please refer to operating manual for more detailed information.

This setup information is intended to act as a guide only. Individual may vary depending on technique, skill and material. Please refer to the operating manual for further instructions.